Argonne National Lab
Strongback -L143-110700
Inspection and Test Results

Serial Number	#	23	Inspector	Floyd
Date		12/18/06		

CMM Critical Feature Results	*Req*	*Tolr*	*Actual*	
flatness - plane -A-		.050	.031	
side opposite -A- flatness		.050	.025	
surface finish -A-	1.6		1.0	
surface finish side opposite -A-	1.6		1.0	
-B- surface flatness		.050	.018	
-B- surface perp to -A-		.100	.016	
Pads				
RH Mounting Pad parallel to -A-		.050	.021	
LH Mounting Pad parallel to -A-		.050	.027	
Overall Length	3400.00	+.000/-.200	-.195	
LH end to 1700mm holes right	1700.00	+.000/-.100	-.100	
LH end to 1700mm holes left	1700.00	+.000/-.100	-.095	
side opposite -A- 167.00 dim	167.00	+.050/-.000	167.004	plane to plane
Individual Gaps	167.00		167.002/167.020	direct gaps
side -A- to Centerline 83.5	83.50	+/- .080	83.502	

Other Dimensions		*Date*	*Reviewer*	
		12/18	skl	SDR 23-12-18

Material and Certifications		*Date*	*Reviewer*	
Material Certs		12/18	skl	
Heat Treat Certs		12/18	skl	
Visual inspection of Material		12/18	skl	SDR 23-12-18

Approvals	
.	
.	

Temps	
20.8	Start
21.2	Finish

SUPPLIER DISPOSITION REQUEST (SDR)

(Form ANL-311 includes instructions and continuation sheet.)

Page ___ of ___

(CHECK ONE)

☑ 1A. **Deviation Request**

☐ 1B. **Nonconformance Action Request**

2. SDR No. 23-12-18

3. SDR Date 12/18/2006

4. Supplier Name, Address, Telephone, Fax

Dial Machine, Inc
2902 Eastrock Dr.
Rockford, IL 61125

5. Purchase Order No. 51-0488

6. Related Documents

6.1 _____ Date _____

7. Qty.	8. Describe Nonconforming Condition	9. Identify Requirement	10. Cause & Corrective Action
	M6 Tap holes in ends out of position. True Position tolerance .100mm (7) holes out of location. Worst T.P. is .234mm.		Consider using as is. Worst out of location is .117mm. Standard bolt clearance in a mating part would be .600mm dia. or .300mm per side. This deviation is less than half of the standard bolt clearance.
	Lateral mark in OD.		Affects aesthetics only. Evaluate on site.

SUPPLIER'S COMMENTS (IF YES, EXPLAIN):

11. Affects Form, Fit or Function
☐ Yes ☐ No

12. Affects Price
☐ Yes ☑ No

12/18/06

15. SUPPLIER REPRESENTATIVE – TITLE – DATE

13. Affects Delivery
☐ Yes ☑ No

14. Recommended Disposition and Comments:

Accept deviation this unit only.

16. ANL REPRESENTATIVE – DATE

17. ANL Disposition and Remarks: Accept deviation for this unit only.

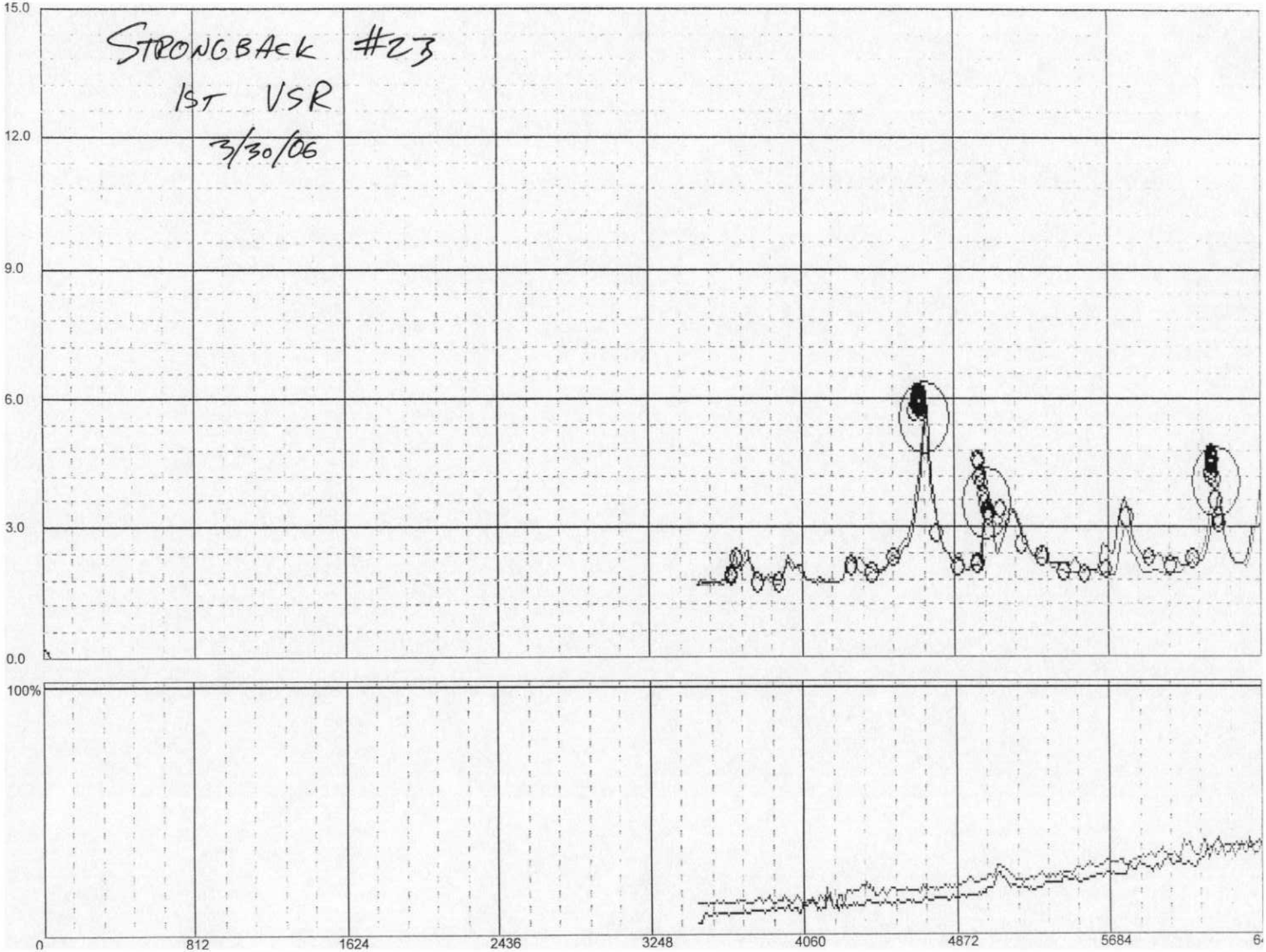
18. Approved

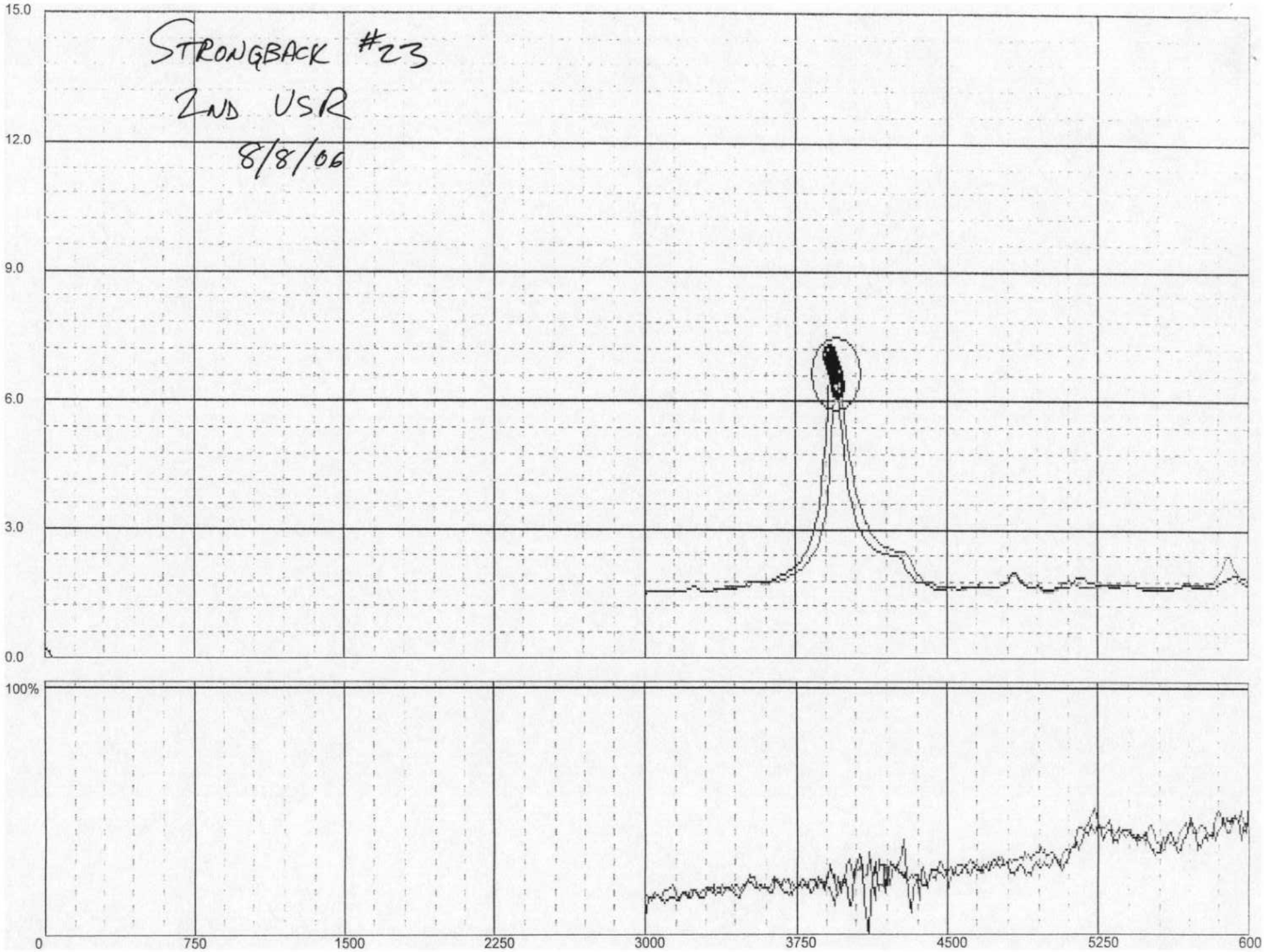
Emil Trauchtenberg 12/19/06 — TECHNICAL REPRESENTATIVE – DATE

12/19/06 — QUALITY ASSURANCE REPRESENTATIVE – DATE

12/19/06 — PROCUREMENT REPRESENTATIVE – DATE

ANL-311 (4-94)


STRONGBACK #23
1ST VSR
3/30/06
15.0
12.0
9.0
6.0
3.0
0.0
100%
0
812
1624
2436
3248
4060
4872
5684


STRONGBACK #23
2ND USR
8/8/06
15.0
12.0
9.0
6.0
3.0
0.0
100%
0
750
1500
2250
3000
3750
4500
5250
600

21,23,25,27,29,31

CORROSION MATERIALS
TEST REPORT

2262 Groom Rd
Baker, LA 70714
(225) 775 - 3675 (Main Office)
(225) 778 - 6436 (Quality Control)
(225) 778 - 6489 (Fax)

Date: 3/9/2006

Customer: Dial Machine

PO No: 102437 & 102669

C89385
CMI No: C83758

Alloy: TI GR2 Heat No: 089-1 Quantity: 6 PCS

Item Description: 12" DIA RND BAR X 137"

Specifications DIN 50049 3.1B ASTM B348, ASME SB348
EN 10204 3.1B

Chemical Components

C	CO	CR	CU	FE	MN	MO	NI	P	S
0.02	—	—	—	0.05	—	—	—	—	—
SI	TI	V	W	CB+TA	SN	AL	ZN	PB	N
—	—	—	—	—	—	—	—	—	0.010

Mechanical Properties

Tensile Strength: Elongation in 2":

Yield Strength: Reduction in Area:

Hardness:

Remarks: O=0.10, H=0.002, TI=BAL
CHEMISTRY ONLY
MATERIAL HAS BEEN ANNEALED PER AMS-H-81200 AND WAS ANNEALLED AT 1200 DEG FOR 4 HOURS.

The information stated in this document is true and accurate based upon information acquired by and maintained on file at Corrosion Materials.

Certified by: Tom Holstein

Title: Quality Control Coordinator

According to records provided by mill sources, all material has been manufactured free from mercury.
Corrosion Materials is an ISO 9001-2000 certified company, registered with RWTUV USA.

International Company «ANTARES»

CERTIFICATE OF QUALITY № 285

Kind of product: titanium cast cylindrical billet | TuU 27.4-20056770-001-2003

Customer: "Rovena" / "M-Solutions LLC" | CONTRACT № 26/05-05 dated 26.05.2005

Material: Grade 2 | ASTM B 348-00 | Date of issue: 14.07.2005

Size, mm Diam x length	Weight kg	№ of melting	Place of test	Chemical specification, %								Ultrasonic test	Condition of surface
				Ti	Fe	O	N	H	C	Residuals (each) max	Residuals (total) max		
807 X 2437	7906	089-1	Top	Base	0.06	0.07	0.010	0.002	0.02	≤ 0,1	≤ 0,4	acceptable	machined
			Bottom		0.05	0.10	0.010	0.002	0.02	≤ 0,1	≤ 0,4		

Chief of technological department — Derecha A.Y.

Chief of quality control department — Krivoshlykov U.M.

71,25,25,27,29,31

Mag LOT 27

Date 1/12/07 Device# 23 Start Time 11:10. Start Temperature 23.7 °C.

Slot	Value	Slot	Value	Slot	Value	Slot	Value	Slot	Value
1	-	51	-1.27	101	-1.26	151	-1.27	201	-1.26
2	0.733	52	1.26	102	1.25	152	1.27	202	1.26
3	1.21	53	-1.27	103	-1.26	153	-1.27	203	-1.27
4	1.29	54	1.27	104	1.27	154	1.26	204	1.26
5	-1.26	55	-1.26	105	-1.26	155	-1.27	205	-1.26
6	1.27	56	1.26	106	1.26	156	1.26	206	1.26
7	-1.26	57	-1.27	107	-1.26	157	-1.26	207	-1.26
8	1.26	58	1.27	108	1.26	158	1.26	208	1.25
9	-1.26	59	-1.27	109	-1.27	159	-1.26	209	-1.26
10	1.26	60	1.26	110	1.26	160	1.26	210	1.26
11	-1.26	61	-1.26	111	-1.26	161	-1.27	211	-1.26
12	1.25	62	1.26	112	1.26	162	1.26	212	1.26
13	-1.26	63	-1.26	113	-1.26	163	-1.26	213	-1.25
14	1.26	64	1.26	114	1.26	164	1.27	214	1.26
15	-1.27	65	-1.27	115	-1.26	165	-1.26	215	-1.26
16	1.26	66	1.26	116	1.26	166	1.26	216	1.26
17	-1.27	67	-1.27	117	-1.27	167	-1.26	217	-1.26
18	1.27	68	1.27	118	1.26	168	1.26	218	1.27
19	-1.27	69	-1.26	119	-1.26	169	-1.27	219	-1.26
20	1.27	70	1.26	120	1.26	170	1.25	220	1.26
21	-1.27	71	-1.26	121	-1.26	171	-1.26	221	-1.27
22	1.27	72	1.26	122	1.26	172	1.27	222	1.25
23	-1.27	73	-1.27	123	-1.25	173	-1.25	223	-1.28
24	1.27	74	1.26	124	1.26	174	1.25	224	1.21
25	-1.26	75	-1.26	125	-1.27	175	-1.26	225	-0.743
26	1.27	76	1.26	126	1.26	176	1.26		
27	-1.27	77	-1.26	127	-1.26	177	-1.26		
28	+1.27	78	1.27	128	1.26	178	1.26		
29	-1.26	79	-1.26	129	-1.26	179	-1.26		
30	1.26	80	1.26	130	1.26	180	1.26		
31	-1.27	81	-1.25	131	-1.26	181	-1.26		
32	1.27	82	1.26	132	1.27	182	1.26		
33	-1.27	83	-1.26	133	-1.27	183	-1.26		
34	1.26	84	1.26	134	1.26	184	1.27		
35	-1.26	85	-1.27	135	-1.27	185	-1.26		
36	1.27	86	1.26	136	1.26	186	1.26		
37	-1.27	87	-1.26	137	-1.26	187	-1.26		
38	1.27	88	1.26	138	1.26	188	1.26		
39	-1.27	89	-1.26	139	-1.27	189	-1.26		
40	1.26	90	1.27	140	1.26	190	1.26		
41	-1.27	91	-1.26	141	-1.27	191	-1.26		
42	1.27	92	1.26	142	1.27	192	1.26		
43	-1.27	93	-1.27	143	-1.26	193	-1.27		
44	1.27	94	1.26	144	1.27	194	1.26		
45	-1.27	95	-1.26	145	-1.26	195	-1.26		
46	+1.26	96	1.26	146	1.25	196	1.25		
47	-1.27	97	-1.26	147	-1.26	197	-1.26		
48	1.26	98	1.26	148	1.26	198	1.26		
49	-1.27	99	-1.26	149	-1.27	199	-1.26		
50	1.27	100	1.26	150	1.26	200	1.26		

End Temperature 24.1 C

End Time 11:32

Hall Probe S/N device: 01340076

Probe: 01230153

Signatures:

LOT27 magnets Serial # 12481-12960

Bottom Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	12674	Upstream	Right
2	12655	Downstream	Right
3	12686	Upstream	Left
4	12790	Downstream	Left
5	12769	Upstream	Left
6	12693	Downstream	Right
7	12763	Upstream	Right
8	12880	Downstream	Right
9	12778	Upstream	Right
10	12871	Downstream	Left
11	12841	Upstream	Right
12	12939	Downstream	Right
13	12809	Upstream	Right
14	12516	Downstream	Left
15	12943	Upstream	Right
16	12776	Downstream	Left
17	12884	Upstream	Left
18	12660	Downstream	Right
19	12896	Upstream	Left
20	12913	Downstream	Right
21	12835	Upstream	Left
22	12666	Downstream	Right
23	12805	Upstream	Left
24	12910	Downstream	Right
25	12725	Upstream	Right
26	12545	Downstream	Left
27	12710	Upstream	Left
28	12566	Downstream	Left
29	12895	Upstream	Right
30	12514	Downstream	Right
31	12774	Upstream	Left
32	12573	Downstream	Left
33	12792	Upstream	Right
34	12729	Downstream	Right
35	12820	Upstream	Left
36	12498	Downstream	Left
37	12766	Upstream	Right
38	12527	Downstream	Right
39	12698	Upstream	Left
40	12665	Downstream	Left
41	12955	Upstream	Left
42	12560	Downstream	Left
43	12814	Upstream	Left
44	12551	Downstream	Right
45	12807	Upstream	Left
46	12562	Downstream	Left
47	12737	Upstream	Right

Top Jaw

Slot Number	Serial No.	Main filed Orientation	x-axis orientation
1	12775	Downstream	Right
2	12670	Upstream	Right
3	12727	Downstream	Left
4	12754	Upstream	Right
5	12722	Downstream	Right
6	12733	Upstream	Left
7	12957	Downstream	Right
8	12800	Upstream	Right
9	12770	Downstream	Right
10	12653	Upstream	Left
11	12657	Downstream	Left
12	12829	Upstream	Left
13	12575	Downstream	Left
14	12793	Upstream	Left
15	12859	Downstream	Left
16	12758	Upstream	Left
17	12507	Downstream	Right
18	12940	Upstream	Left
19	12561	Downstream	Right
20	12771	Upstream	Right
21	12696	Downstream	Right
22	12937	Upstream	Left
23	12530	Downstream	Left
24	12799	Upstream	Left
25	12689	Downstream	Left
26	12942	Upstream	Left
27	12579	Downstream	Left
28	12839	Upstream	Right
29	12626	Downstream	Left
30	12893	Upstream	Right
31	12719	Downstream	Right
32	12865	Upstream	Left
33	12483	Downstream	Left
34	12691	Upstream	Left
35	12497	Downstream	Right
36	12850	Upstream	Left
37	12623	Downstream	Right
38	12902	Upstream	Left
39	12614	Downstream	Right
40	12925	Upstream	Left
41	12518	Downstream	Right
42	12756	Upstream	Right
43	12642	Downstream	Right
44	12882	Upstream	Right
45	12555	Downstream	Right
46	12791	Upstream	Right
47	12598	Downstream	Left

48	12580	Downstream	Left
49	12786	Upstream	Left
50	12522	Downstream	Left
51	12713	Upstream	Left
52	12512	Downstream	Right
53	12901	Upstream	Right
54	12652	Downstream	Right
55	12894	Upstream	Right
56	12605	Downstream	Left
57	12732	Upstream	Right
58	12492	Downstream	Left
59	12760	Upstream	Right
60	12590	Downstream	Right
61	12881	Upstream	Right
62	12581	Downstream	Left
63	12787	Upstream	Left
64	12651	Downstream	Right
65	12848	Upstream	Right
66	12572	Downstream	Right
67	12808	Upstream	Right
68	12537	Downstream	Right
69	12851	Upstream	Right
70	12641	Downstream	Right
71	12582	Upstream	Right
72	12496	Downstream	Left
73	12755	Upstream	Right
74	12591	Downstream	Left
75	12908	Upstream	Left
76	12508	Downstream	Right
77	12935	Upstream	Right
78	12571	Downstream	Left
79	12844	Upstream	Right
80	12542	Downstream	Left
81	12858	Upstream	Right
82	12773	Downstream	Right
83	12643	Upstream	Right
84	12782	Downstream	Right
85	12887	Upstream	Right
86	12938	Downstream	Left
87	12836	Upstream	Right
88	12740	Downstream	Left
89	12900	Upstream	Left
90	12515	Downstream	Right
91	12741	Upstream	Right
92	12920	Downstream	Right
93	12915	Upstream	Left
94	12501	Downstream	Left
95	12822	Upstream	Right
96	12659	Downstream	Left
97	12950	Upstream	Left
98	12620	Downstream	Right
99	12779	Upstream	Right

48	12849	Upstream	Right
49	12521	Downstream	Right
50	12704	Upstream	Left
51	12635	Downstream	Left
52	12877	Upstream	Left
53	12528	Downstream	Left
54	12926	Upstream	Left
55	12650	Downstream	Left
56	12823	Upstream	Left
57	12811	Downstream	Right
58	12735	Upstream	Left
59	12552	Downstream	Left
60	12954	Upstream	Left
61	12576	Downstream	Left
62	12874	Upstream	Left
63	12616	Downstream	Left
64	12789	Upstream	Left
65	12526	Downstream	Right
66	12831	Upstream	Right
67	12533	Downstream	Right
68	12768	Upstream	Left
69	12644	Downstream	Left
70	12834	Upstream	Left
71	12553	Downstream	Right
72	12947	Upstream	Left
73	12548	Downstream	Right
74	12739	Upstream	Right
75	12499	Downstream	Right
76	12547	Upstream	Left
77	12520	Downstream	Left
78	12936	Upstream	Right
79	12543	Downstream	Right
80	12857	Upstream	Left
81	12663	Downstream	Left
82	12711	Upstream	Left
83	12730	Downstream	Right
84	12746	Upstream	Left
85	12604	Downstream	Right
86	12784	Upstream	Left
87	12914	Downstream	Left
88	12615	Upstream	Left
89	12898	Downstream	Left
90	12960	Upstream	Right
91	12558	Downstream	Right
92	12772	Upstream	Left
93	12678	Downstream	Right
94	12625	Upstream	Left
95	12610	Downstream	Left
96	12930	Upstream	Right
97	12563	Downstream	Right
98	12683	Upstream	Left
99	12669	Downstream	Left

100	12600	Downstream	Left
101	12856	Upstream	Right
102	12718	Downstream	Left
103	12588	Upstream	Right
104	12832	Downstream	Left
105	12493	Upstream	Left
106	12673	Downstream	Left
107	12892	Upstream	Right
108	12608	Downstream	Right
109	12690	Upstream	Right
110	12917	Downstream	Right
111	12878	Upstream	Right
112	12788	Downstream	Right
113	12932	Upstream	Right
114	12861	Downstream	Right
115	12491	Upstream	Right
116	12795	Downstream	Right
117	12911	Upstream	Right
118	12609	Downstream	Right
119	12899	Upstream	Right
120	12785	Downstream	Right
121	12837	Upstream	Right
122	12636	Downstream	Right
123	12923	Upstream	Right
124	12510	Downstream	Left
125	12601	Upstream	Left
126	12599	Downstream	Right
127	12888	Upstream	Right
128	12667	Downstream	Left
129	12505	Upstream	Right
130	12934	Downstream	Left
131	12951	Upstream	Right
132	12517	Downstream	Right
133	12762	Upstream	Right
134	12585	Downstream	Left
135	12744	Upstream	Right
136	12618	Downstream	Right
137	12824	Upstream	Right
138	12826	Downstream	Right
139	12487	Upstream	Right
140	12629	Downstream	Left
141	12885	Upstream	Right
142	12529	Downstream	Right
143	12797	Upstream	Left
144	12918	Downstream	Left
145	12798	Upstream	Left
146	12647	Downstream	Right
147	12864	Upstream	Left
148	12634	Downstream	Left
149	12879	Upstream	Right
150	12540	Downstream	Right
151	12804	Upstream	Left

100	12612	Upstream	Left
101	12538	Downstream	Left
102	12654	Upstream	Left
103	12903	Downstream	Left
104	12699	Upstream	Right
105	12633	Downstream	Left
106	12846	Upstream	Right
107	12525	Downstream	Left
108	12959	Upstream	Right
109	12941	Downstream	Left
110	12912	Upstream	Right
111	12645	Downstream	Right
112	12875	Upstream	Left
113	12506	Downstream	Right
114	12952	Upstream	Right
115	12638	Downstream	Right
116	12909	Upstream	Left
117	12749	Downstream	Left
118	12890	Upstream	Left
119	12523	Downstream	Left
120	12574	Upstream	Left
121	12767	Downstream	Right
122	12904	Upstream	Left
123	12631	Downstream	Left
124	12708	Upstream	Left
125	12617	Downstream	Left
126	12853	Upstream	Left
127	12577	Downstream	Left
128	12679	Upstream	Left
129	12559	Downstream	Left
130	12953	Upstream	Right
131	12639	Downstream	Right
132	12876	Upstream	Left
133	12481	Downstream	Left
134	12752	Upstream	Left
135	12556	Downstream	Right
136	12956	Upstream	Left
137	12500	Downstream	Left
138	12595	Upstream	Left
139	12685	Downstream	Right
140	12607	Upstream	Left
141	12606	Downstream	Right
142	12748	Upstream	Left
143	12593	Downstream	Left
144	12794	Upstream	Left
145	12646	Downstream	Right
146	12855	Upstream	Right
147	12664	Downstream	Right
148	12813	Upstream	Right
149	12488	Downstream	Left
150	12868	Upstream	Left
151	12489	Downstream	Right

152	12603	Downstream	Left
153	12743	Upstream	Right
154	12539	Downstream	Left
155	12891	Upstream	Right
156	12594	Downstream	Right
157	12919	Upstream	Left
158	12524	Downstream	Right
159	12602	Upstream	Left
160	12541	Downstream	Left
161	12830	Upstream	Right
162	12717	Downstream	Right
163	12854	Upstream	Left
164	12495	Downstream	Left
165	12867	Upstream	Right
166	12568	Downstream	Left
167	12759	Upstream	Right
168	12624	Downstream	Left
169	12753	Upstream	Left
170	12534	Downstream	Left
171	12825	Upstream	Left
172	12640	Downstream	Right
173	12872	Upstream	Right
174	12513	Downstream	Left
175	12897	Upstream	Left
176	12816	Downstream	Right
177	12810	Upstream	Right
178	12578	Downstream	Right
179	12680	Upstream	Left
180	12671	Downstream	Right
181	12781	Upstream	Right
182	12630	Downstream	Right
183	12818	Upstream	Right
184	12721	Downstream	Left
185	12907	Upstream	Right
186	12677	Downstream	Right
187	12716	Upstream	Right
188	12485	Downstream	Right
189	12922	Upstream	Right
190	12949	Downstream	Right
191	12862	Upstream	Right
192	12592	Downstream	Right
193	12736	Upstream	Right
194	12482	Downstream	Right
195	12803	Upstream	Left
196	12701	Downstream	Left
197	12958	Upstream	Right
198	12531	Downstream	Left
199	12720	Upstream	Right
200	12668	Downstream	Right
201	12745	Upstream	Left
202	12802	Downstream	Right
203	12847	Upstream	Right

152	12697	Upstream	Left
153	12570	Downstream	Left
154	12747	Upstream	Right
155	12503	Downstream	Left
156	12833	Upstream	Right
157	12649	Downstream	Right
158	12661	Upstream	Right
159	12611	Downstream	Left
160	12714	Upstream	Left
161	12596	Downstream	Right
162	12728	Upstream	Right
163	12557	Downstream	Left
164	12842	Upstream	Right
165	12569	Downstream	Left
166	12928	Upstream	Right
167	12544	Downstream	Right
168	12761	Upstream	Right
169	12550	Downstream	Right
170	12687	Upstream	Right
171	12565	Downstream	Left
172	12707	Upstream	Right
173	12628	Downstream	Left
174	12905	Upstream	Left
175	12632	Downstream	Right
176	12765	Upstream	Left
177	12484	Downstream	Right
178	12511	Upstream	Left
179	12597	Downstream	Left
180	12726	Upstream	Left
181	12622	Downstream	Left
182	12870	Upstream	Right
183	12532	Downstream	Left
184	12738	Upstream	Right
185	12519	Downstream	Right
186	12946	Upstream	Right
187	12675	Downstream	Left
188	12906	Upstream	Left
189	12554	Downstream	Left
190	12706	Upstream	Right
191	12494	Downstream	Right
192	12684	Upstream	Right
193	12682	Downstream	Right
194	12933	Upstream	Right
195	12587	Downstream	Right
196	12700	Upstream	Left
197	12504	Downstream	Right
198	12613	Upstream	Left
199	12567	Downstream	Right
200	12817	Upstream	Right
201	12751	Downstream	Right
202	12724	Upstream	Right
203	12564	Downstream	Left

204	12658	Downstream	Left
205	12757	Upstream	Right
206	12873	Downstream	Right
207	12702	Upstream	Right
208	12838	Downstream	Left
209	12931	Upstream	Right
210	12860	Downstream	Left
211	12681	Upstream	Right
212	12672	Downstream	Left
213	12709	Upstream	Left
214	12742	Downstream	Right
215	12694	Upstream	Right
216	12783	Downstream	Right
217	12883	Upstream	Right
218	12723	Downstream	Left
219	12827	Upstream	Left
220	12828	Downstream	Right
221	12621	Upstream	Right
222	12852	Downstream	Left
223	12695	Upstream	Left
224	12921	Downstream	Left
225	12486	Upstream	Left

204	12866	Upstream	Left
205	12536	Downstream	Right
206	12715	Upstream	Right
207	12549	Downstream	Right
208	12703	Upstream	Right
209	12656	Downstream	Right
210	12619	Upstream	Right
211	12692	Downstream	Right
212	12924	Upstream	Left
213	12509	Downstream	Right
214	12780	Upstream	Left
215	12869	Downstream	Right
216	12819	Upstream	Left
217	12840	Downstream	Right
218	12796	Upstream	Right
219	12845	Downstream	Left
220	12676	Upstream	Right
221	12734	Downstream	Left
222	12731	Upstream	Left
223	12777	Downstream	Right
224	12815	Upstream	Left
225	12535	Downstream	Left

For "X-Axis Orientation" column
"Right" stands for right-numbered surface should face to the undulator axis.
"Left" stands for left-numbered surface should face to the undulator axis.
This "Right", "Left" procedure applies for both Top and Bottom Jaw

For "Main-Field Orientation" column **(see Assembly Procedure Document)**
"Downstream" side corresponts to the direction of lower-numbered slot.
Arrow should point toward the lower numbered slots.
"Upstream" side corresponds to the direction of higher-numbered slot.
Arrow should point toward the higher numbered slots.

Spare magnets

serial No.	Reduced Magnetization
12927	33%
12764	80%
12801	
12889	
12696	
12812	
12583	
12688	
12662	
12948	
12627	
12712	

Sample magnets

serial No.
12546
12637
12750
12806
12916

12596

12929

12651

12705

12586

12821

12773

12944

12490

12945

12863

12589

12843

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Dial Machine, Inc.**

PART NAME: **LCLS Strongback**

DRAWING #: **L143-110700**

SERIAL #: 23

P.O.#: **5A-13624**

DATE: 12-21-06

#	Inspection/Test Requirement	Inspection Test Location	Accepted by or Nonconformance Report No.	Date
1	Visual inspection of part for shipping damage. A) Were critical surfaces protected per SOW L143-00030 Section 4.1.4? B) Is there any visible damage?	H.T.	OK.	12/21/06
2	Check Strongback is marked with serial number & part no.'s (ANL & SLAC) per SOW Section 4.1.3?	H.T.	OK	12/21/06
3	Check all accompanying Certifications have correct part serial number	H.T.	OK	12/21/06
4	Check Material Certification for compliance with ASTM B381-03 or ASTM B348, Grade F2	H.T.	OK	12/21/06
5	Check Forging Annealing Certification for annealing conformance to AMS-H-81200A, Table V, commercial Pure, Bars & Forgings, including Note 8	H.T.	OK	12/21/06
6	Check Rough Machining Anneal Certification for annealing conformance to AMS-2801B section 3.2.9	H.T.	OK	12/21/06
7	Check the Strongback contractor's reported dimensional measurements against the part drawing	H.T.	OK	12/21/06
8	Verify the Strongback critical dimensions as listed in the SOW section 4.5.2 are in compliance with the print	H.T.	OK	12/21/06

INSPECTOR: SIMON

QA Supervisor: Muelaze

TEST EQUIPMENT USED: VISUAL.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR:

PART NAME: LCLS Strongback

DRAWING #: L143-110700

SERIAL #: 23

P.O. #: 5A-13624

DATE: 12-21-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Overall length	3400.00	+0 / -.04	3399.85	Accept/Reject
Gap height	167.00	+0.05 / -.0	167.02	Accept/Reject
Gap flatness (top and bottom)	<= .05	N/A	<= .03	Accept/Reject
Gap depth	130.00	+/- .08	130.01	Accept/Reject
Flatness of front face	<= .05	N/A	<= .03	Accept/Reject
Perpendicularity of front face to A	<= .1	N/A	<= .03	Accept/Reject
End face perpendicularity to A and B	<= .05	N/A	<= .03	Accept/Reject
Mounting Pads Area	60.00	+0.1/-.0	60.03	Accept/Reject
Holes Location	2 x 30.00	+0.1/-0.1	30.01	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muller

TEST EQUIPMENT USED: SQUAR PRECISION
DROP INDICATOR
ADJUSTEBLE PARALELS
DIAL CALIPER
MICROMETER

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: Dial Machine, Inc.

PART NAME: LCLS Strongback

DRAWING #: L143-110700

SERIAL #: 23

P.O.#: 5A-13624

DATE: 12-21-06

FEATURE: Gap Flatness

#	Distance (mm)	Measured A	Measured B	Comments
1	50	.0002	.0000	OK
2	350	.0008	.0000	OK
3	650	.0009	.0000	OK
4	950	.0008	.0004	OK
5	1250	.0007	.0002	OK
6	1550	.0006	-.0001	OK
7	1850	.0004	-.0001	OK
8	2150	.0000	-.0002	OK
9	2450	-.0001	-.0008	OK
10	2750	-.0007	-.0009	OK
11	3050	-.0007	-.0008	OK
12	3350	.0000	-.0002	OK

INSPECTOR: Simon

QA Supervisor: Mullage

TEST EQUIPMENT USED: Jig TRANSIT MODEL: 711010 S/N: 231067

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Upper Right Magnet Structure Base

DRAWING #: L143-111201 SERIAL #: Ll43-111200-23

P.O. #: 5A13624 DATE: 10-13-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.980/29.971	Accept/Reject
Bottom surface flatness	<= .04	N/A	0.02	Accept/Reject
Overall length	189	+0 / -.1	188.975	Accept/Reject
Overall width	128	+0 / -.1	127.975	Accept/Reject

INSPECTOR: Mulaze QA Supervisor: Mulaze

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory
Stanford Linear Accelerator Center

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Lower Right Magnet Structure Base

DRAWING #: L143-111301 SERIAL #: L143-111300-23

P.O. #: 5A13624 DATE: 10-13-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.997/29.997	Accept/Reject
Bottom surface flatness	<= .04	N/A	0.015	Accept/Reject
Overall length	189	+0 / -.1	188.975	Accept/Reject
Overall width	128	+0 / -.1	127.98	Accept/Reject

INSPECTOR: Mulaza QA Supervisor: Mulaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Upper Left Magnet Structure Base

DRAWING #: L143-110801 SERIAL #: L143-110800-23

P.O. #: 5A13624 DATE: 10-13-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.985/29.975	Accept/Reject
Bottom surface flatness	<= .04	N/A	0.012	Accept/Reject
Overall length	195	+0 / -.1	194.97	Accept/Reject
Overall width	128	+0 / -.1	127.967	Accept/Reject

INSPECTOR: Mulaze QA Supervisor: Mulaze

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Lower Left Magnet Structure Base

DRAWING #: L143-110901 SERIAL #: L143-110900-23

P.O. #: 5A13624 DATE: 10-13-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.990/29.978	Accept/Reject
Bottom surface flatness	<= .04	N/A	.012	Accept/Reject
Overall length	195	+0 / -.1	194.975	Accept/Reject
Overall width	128	+0 / -.1	127.97	Accept/Reject

INSPECTOR: Mustaza QA Supervisor: Mustaza

TEST EQUIPMENT USED: CMM & Micrometer .

COMMENTS: .

LCLS Linac Coherent Light Source

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Lower Middle Magnet Structure Base

DRAWING #: L143-111101-01 SERIAL #: L143-111100-1-23

P.O. #:5A13624 DATE: 10-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.980/29.970	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005	+0 / -.1	1004.97	Accept/Reject
Overall width	128	+0 / -.1	127.93	Accept/Reject

INSPECTOR: Muñoz QA Supervisor: Muñoz

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Lower Middle Magnet Structure Base

DRAWING #: L143-111101-01 SERIAL #: L143-111100-2-23

P.O. #:5A13624 DATE: 10-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.984/29.975	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005	+0 / -.1	1004.97	Accept/Reject
Overall width	128	+0 / -.1	127.932	Accept/Reject

INSPECTOR: Muelaza QA Supervisor: Muelaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01 SERIAL #: L143-111000-2-23

P.O. #: 5A13624 DATE: 10-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.995/29.975	Accept/Reject
Bottom surface flatness	</= .04	N/A	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.92	Accept/Reject
Overall width	128	+0 / -.1	127.93	Accept/Reject

INSPECTOR: Muelaza QA Supervisor: Muelaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01 SERIAL #: L143-111000-3-23

P.O. #: 5A13624 DATE: 10-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.995/29.970	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.91	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Muelaza QA Supervisor: Muelaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Lower Middle Magnet Structure Base

DRAWING #: L143-111101-01 SERIAL #: L143-111100-3-23

P.O. #:5A13624 DATE: 10-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.994/29.975	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005	+0 / -.1	1004.92	Accept/Reject
Overall width	128	+0 / -.1	127.935	Accept/Reject

INSPECTOR: Muelaza QA Supervisor: Muelaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: Hi-Tech Manufacturing, Inc. PART NAME: Upper Middle Magnet Structure Base

DRAWING #: L143-111001-01 SERIAL #: L143-111000-1-23

P.O. #: 5A13624 DATE: 10-16-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE(S)	
Bottom surface to pole base surface (all surfaces)	30	+0 / -.03	Max / Min 29.985/29.975	Accept/Reject
Bottom surface flatness	<= .04	N/A	.04	Accept/Reject
Overall length	1005.0	+0 / -.1	1004.91	Accept/Reject
Overall width	128	+0 / -.1	127.95	Accept/Reject

INSPECTOR: Mulaza QA Supervisor: Mulaza

TEST EQUIPMENT USED: CMM & Micrometer.

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12775

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Smoa

QA Supervisor: Muelaz

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12657

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mualaze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12696

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12719

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12518

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Smod

QA Supervisor: Muelatz

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12635

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simod

QA Supervisor: Murlage

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12576

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murtaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12553

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulaze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12663

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	(Accept)/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	(Accept)/Reject
Magnet Width	66.00	+/- .25	66.02	(Accept)/Reject
Magnet thickness	9.00	+0 / -.10	8.96	(Accept)/Reject

INSPECTOR: Simon

QA Supervisor: Mulaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12558

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12538

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory
Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12645

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muliaz

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12767

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simodl

QA Supervisor: Mulla

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12639

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory
Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12606

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.95	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulaze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12489

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12596

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	56.99	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muraza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12565

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12622

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muula

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12494

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	56.99	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12751

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: [illegible]

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12692

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12734

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12674

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelage

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12841

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Muelaz

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12835

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaga

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12774

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelsze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12955

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12713

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlate

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12881

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muntz

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12582

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: SIMON

QA Supervisor: Mullaz

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory
Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12858

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12741

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mulaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12856

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.97	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muller

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12878

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: [illegible]

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory
Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12837

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Hurlez

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12951

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.03	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Marla

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12885

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaze

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12804

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Murlaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12830

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mustaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12825

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	(Accept) Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	(Accept) Reject
Magnet Width	66.00	+/- .25	66.03	(Accept) Reject
Magnet thickness	9.00	+0 / -.10	8.95	(Accept) Reject

INSPECTOR: Simon

QA Supervisor: Muelaz

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12781

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.00	Accept/Reject
Magnet Width	66.00	+/- .25	66.02	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Samoa

QA Supervisor: Mullato

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source Stanford Synchrotron Radiation Laboratory Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12862

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.02	Accept Reject
Magnet Width	66.00	+/- .25	66.02	Accept Reject
Magnet thickness	9.00	+0 / -.10	8.67	Accept Reject

INSPECTOR: Simon

QA Supervisor: Muller

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12745

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.03	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Mustaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12681

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.01	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muller

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

LCLS
Linac Coherent Light Source · Stanford Synchrotron Radiation Laboratory · Stanford Linear Accelerator Center

Procedure Number: L143-00076
Revision: 0
Issue Date: April 14, 2005

INSPECTION / ACCEPTANCE REPORT OF COMPONENTS FOR LCLS MAGNET ASSEMBLIES

VENDOR: **Shin-Etsu**

PART NAME: **LCLS Magnet**

DRAWING #: **L143-110106-04**

SERIAL #: 12624

P.O. #: **5A13624**

DATE: 11-15-06

ACCEPTANCE CRITERIA

1. Visually inspect for shipping damage.	Accept/Reject

CRITICAL DIMENSIONS (mm)

FEATURE	TARGET	TOLERANCE	MEASURED VALUE	
Magnet height	57.00	+/- .05	57.01	Accept/Reject
Magnet Width	66.00	+/- .25	66.00	Accept/Reject
Magnet thickness	9.00	+0 / -.10	8.96	Accept/Reject

INSPECTOR: Simon

QA Supervisor: Muelaza

TEST EQUIPMENT USED: **Drop Indicators**

COMMENTS:

800-521-9520
jlindustrial.com
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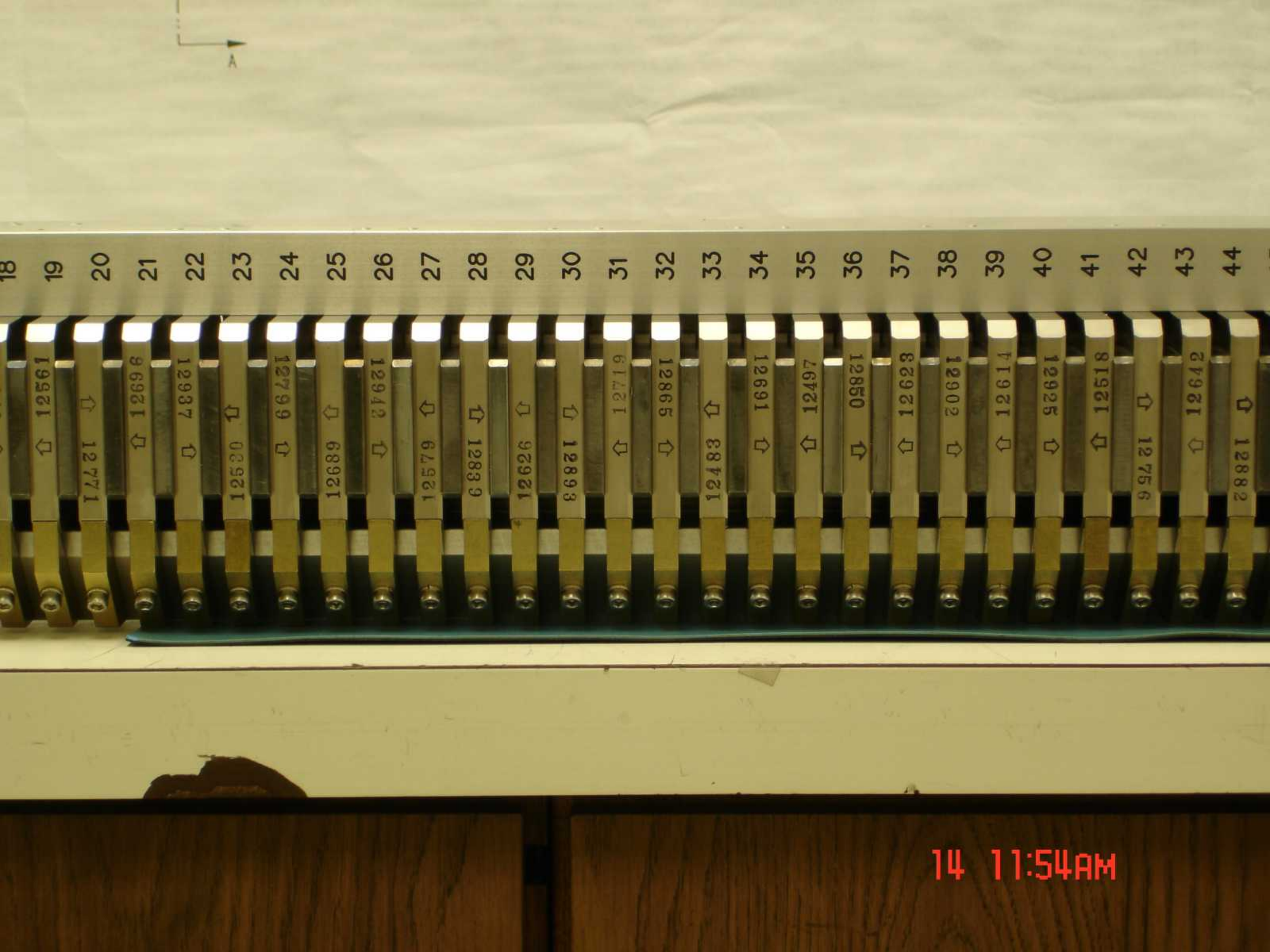
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NOTE 3	7	92196A187	[illegible]	STN. STL	67
NOTE 7	6	97185A151	[illegible]	316 SST	134
	5	92148A545	WASHER LOCK [illegible]	18-8 SST	67
	4	L143-110106	MAGNET	MAGNET TYPE MATERIAL (SEE NOTE 7)	67
	3	L143-110105	POLE	VACOFLUX 50	67
	2	L143-110104	MAGNET CLAMP	5/16" HAPCO 2 ALUMINUM BRONZE PLATE	67
	1	L143-111101	BASE	AL CAST 356 & 316 PLATE 2.5"PLATE	1
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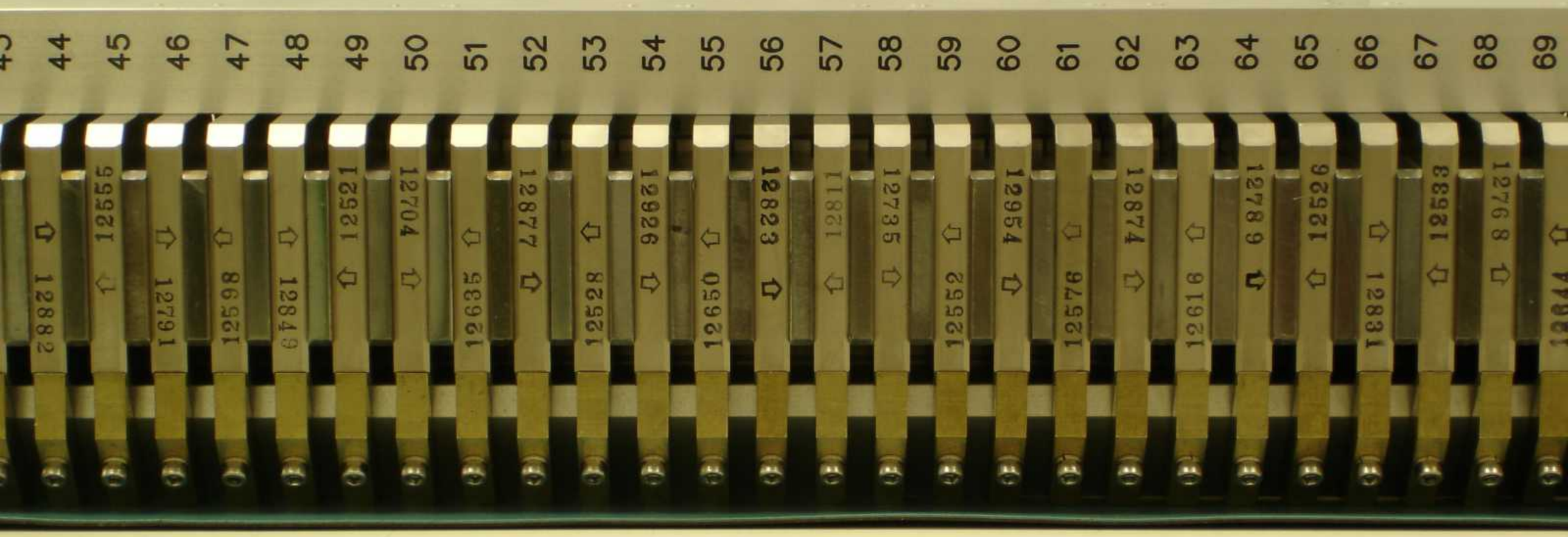

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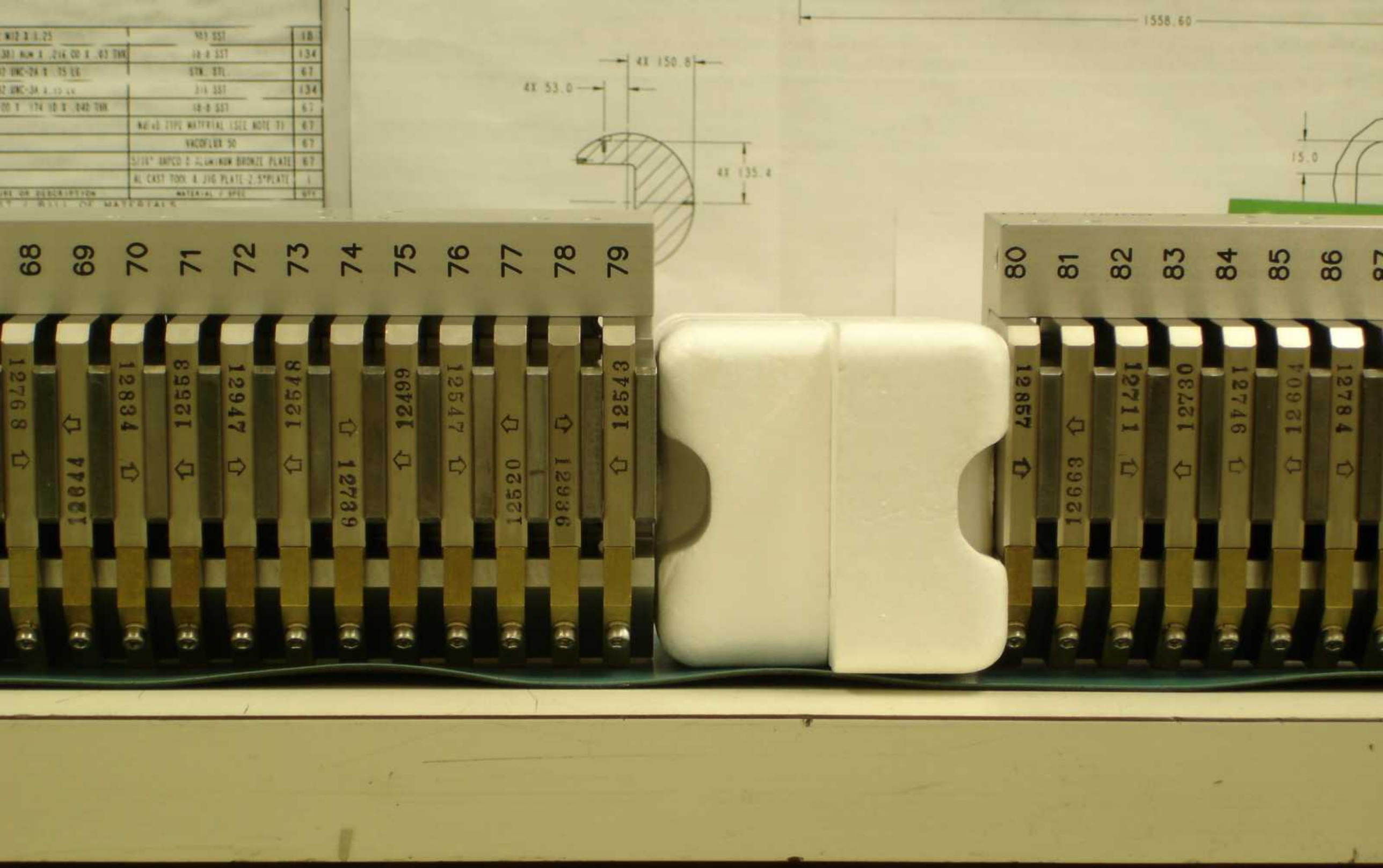
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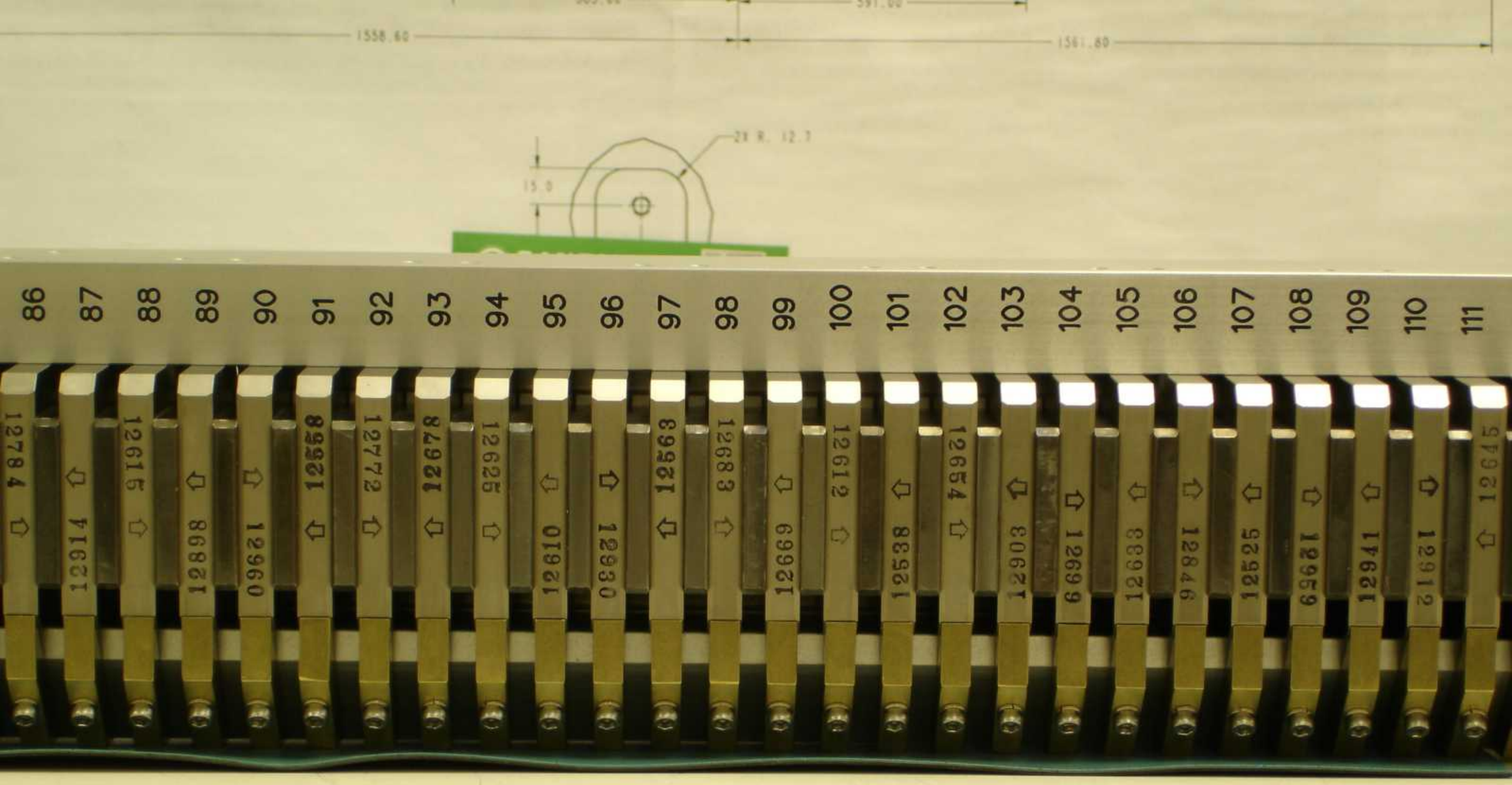
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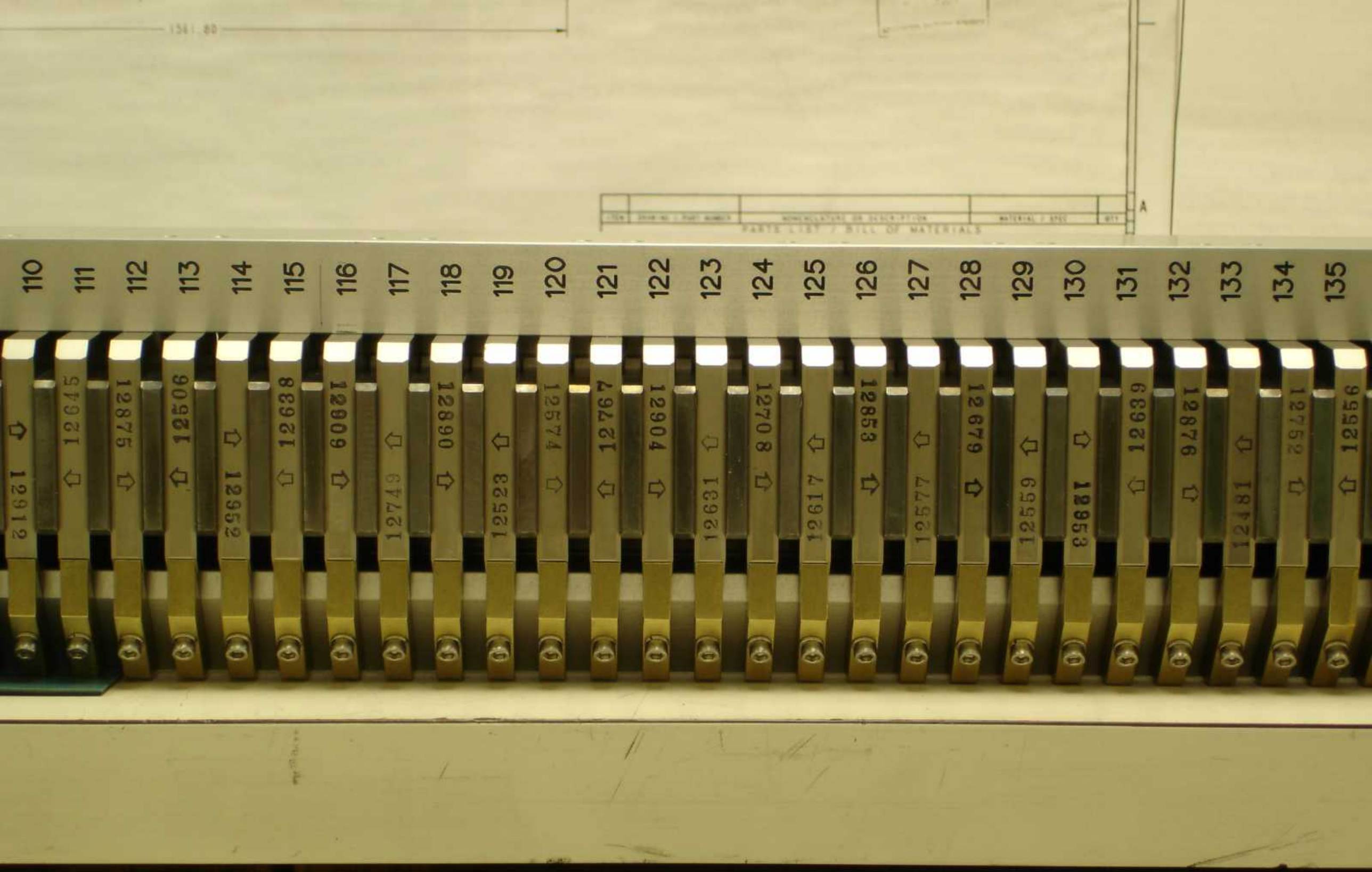
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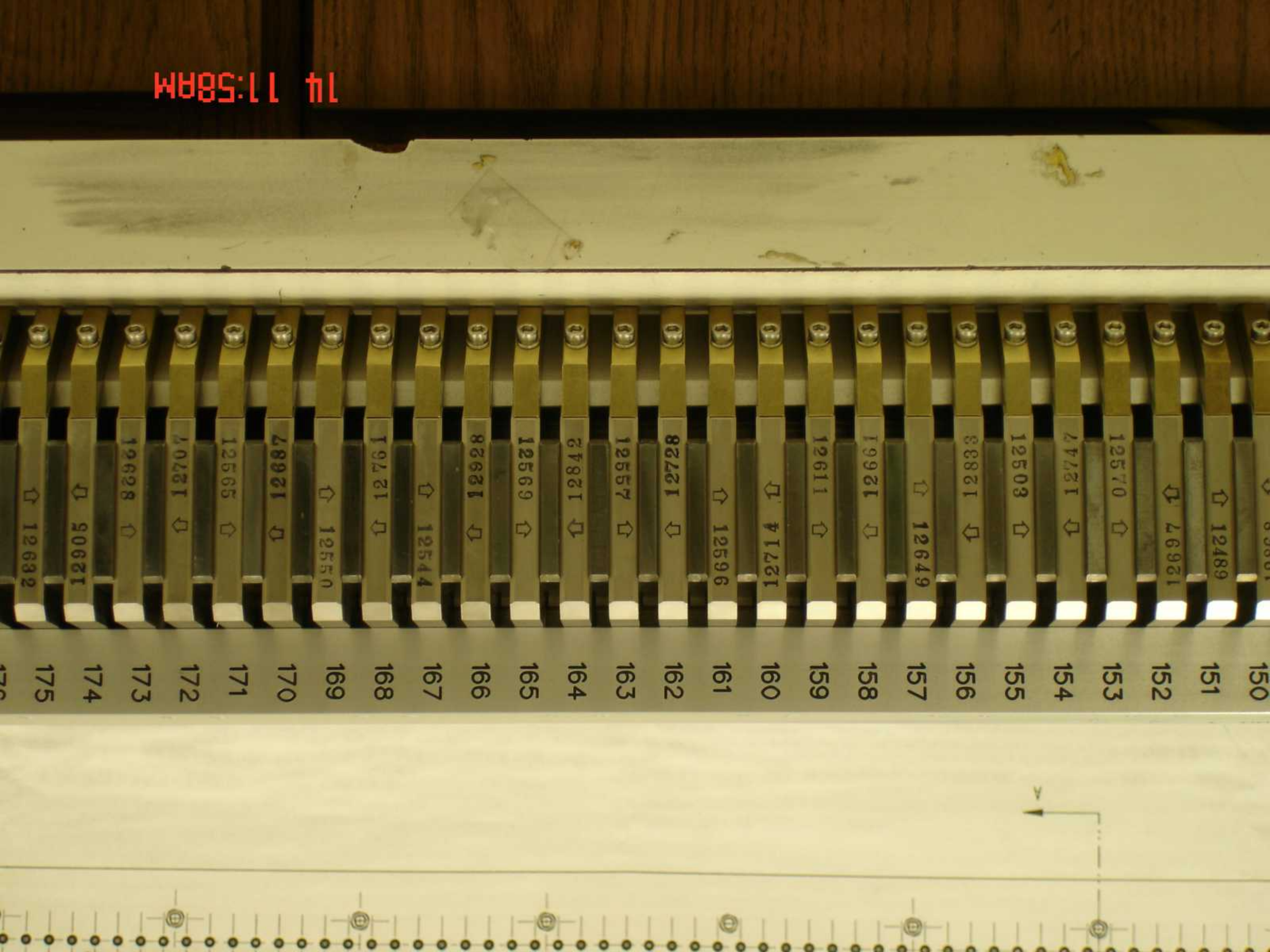
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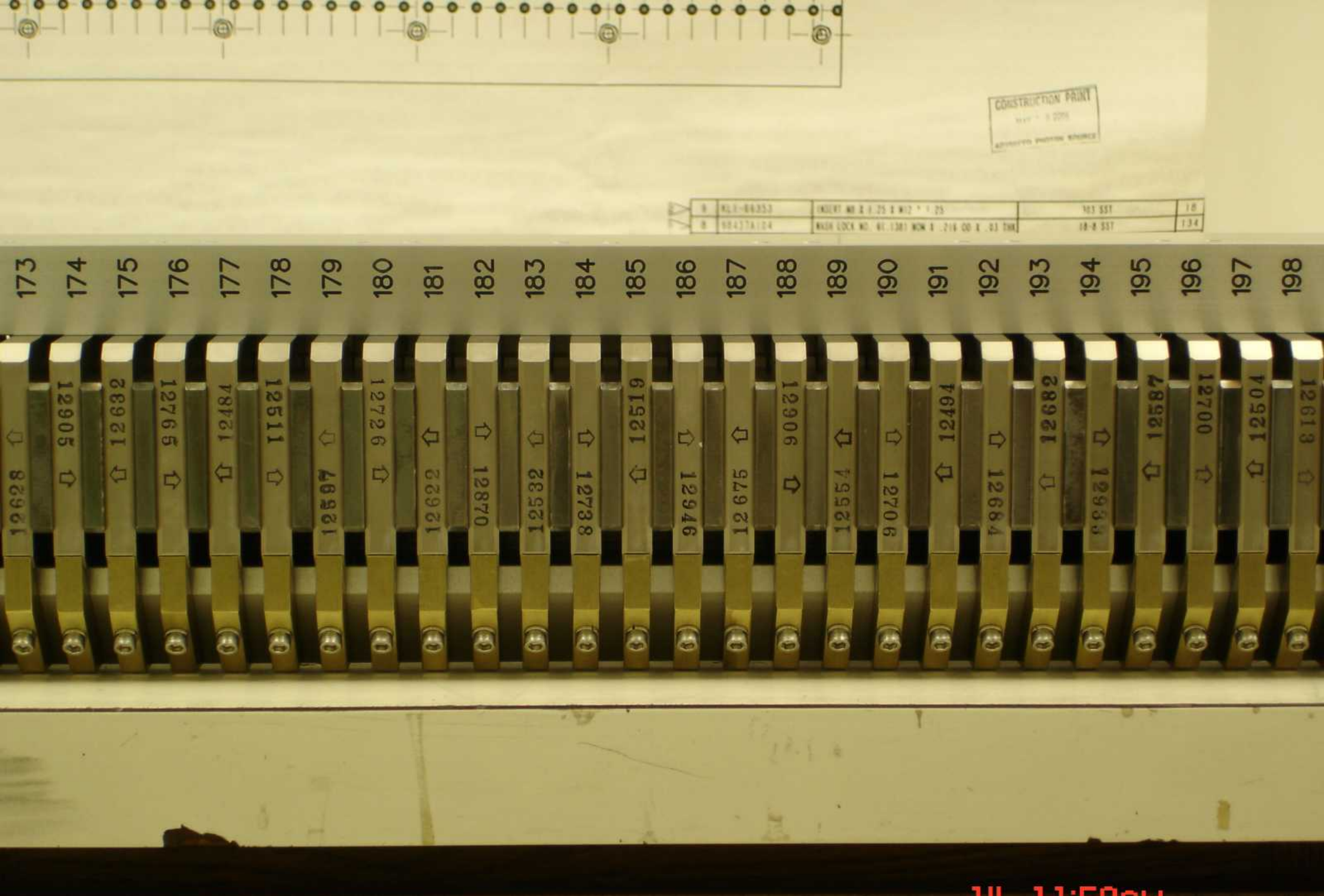
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NOTE 3	7	92196A197	SHCS M5
NOTE 2	6	92185A151	SHCS NO. 8
	5	92146A545	WASHER LOCK
	4	L143-110106	MAGNET
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	ITEM	DRAWING / PART NUMBER	NOMENCLA

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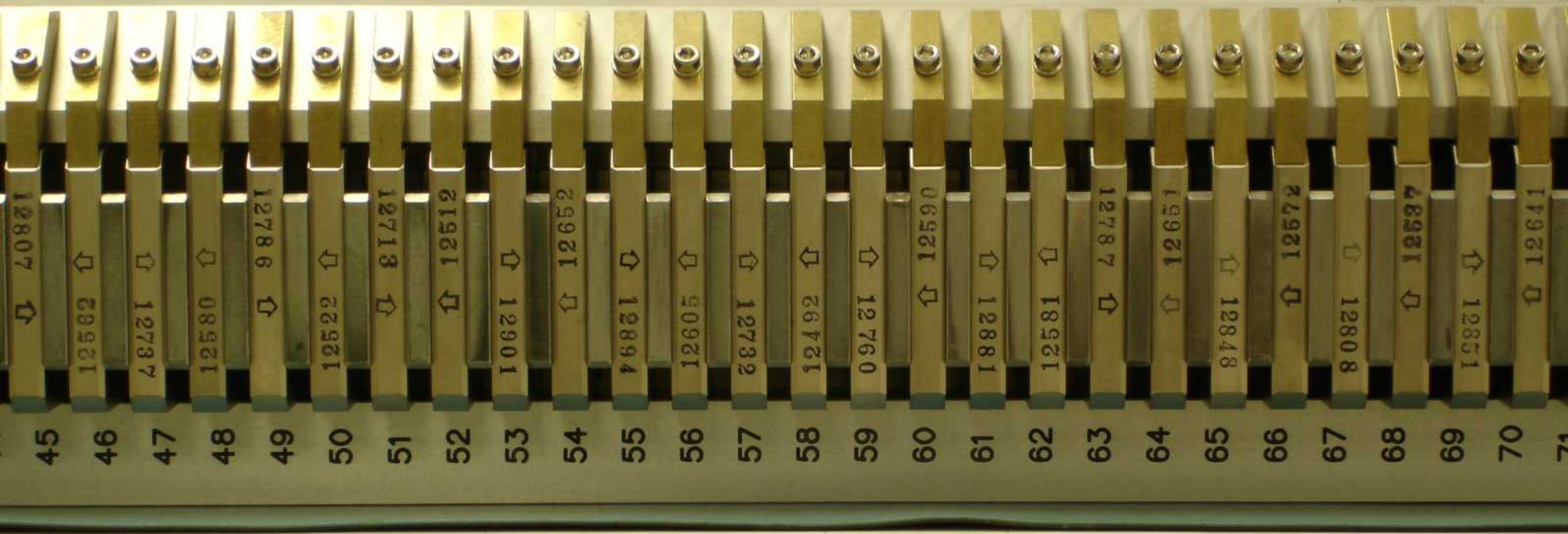

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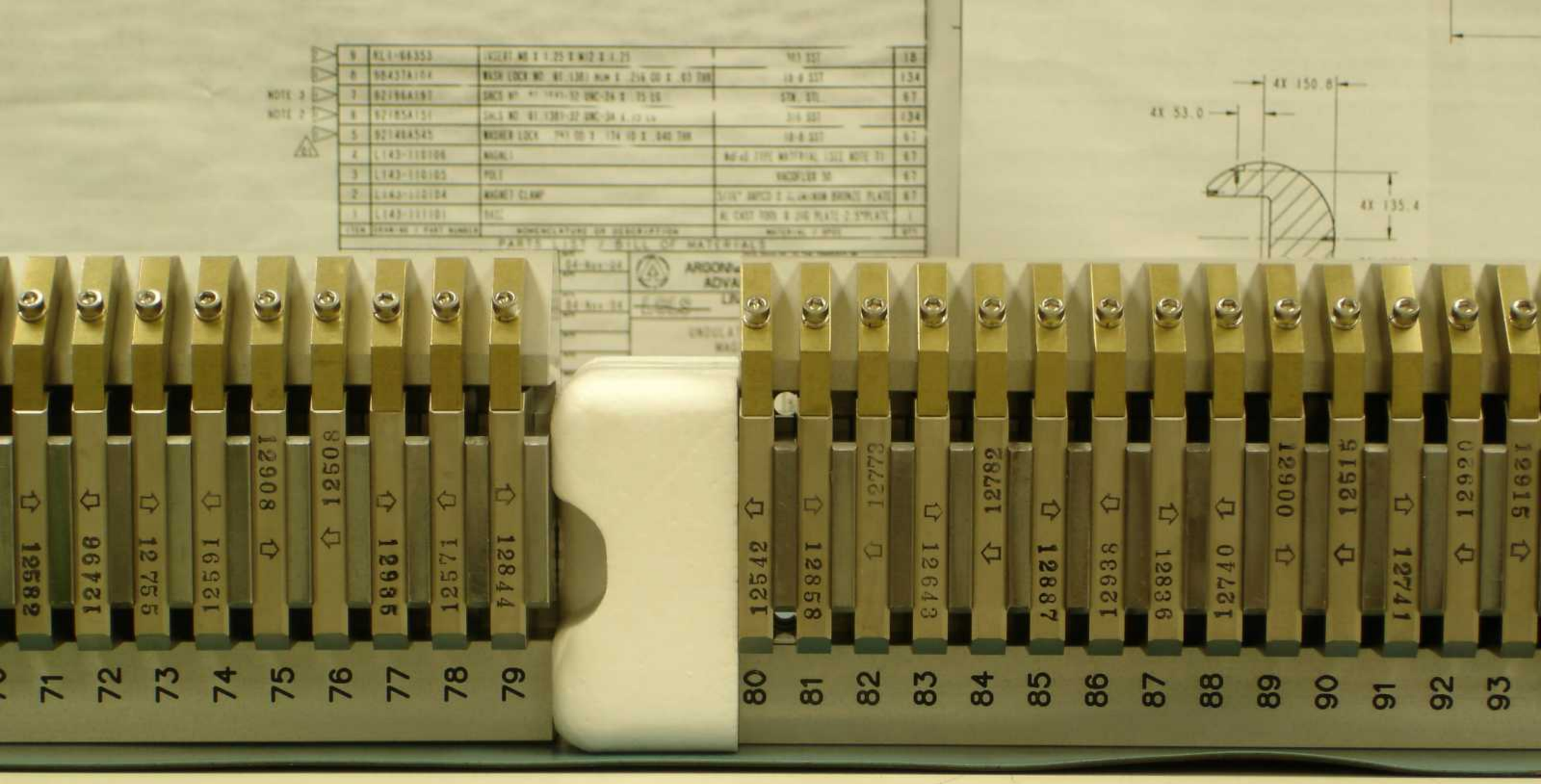
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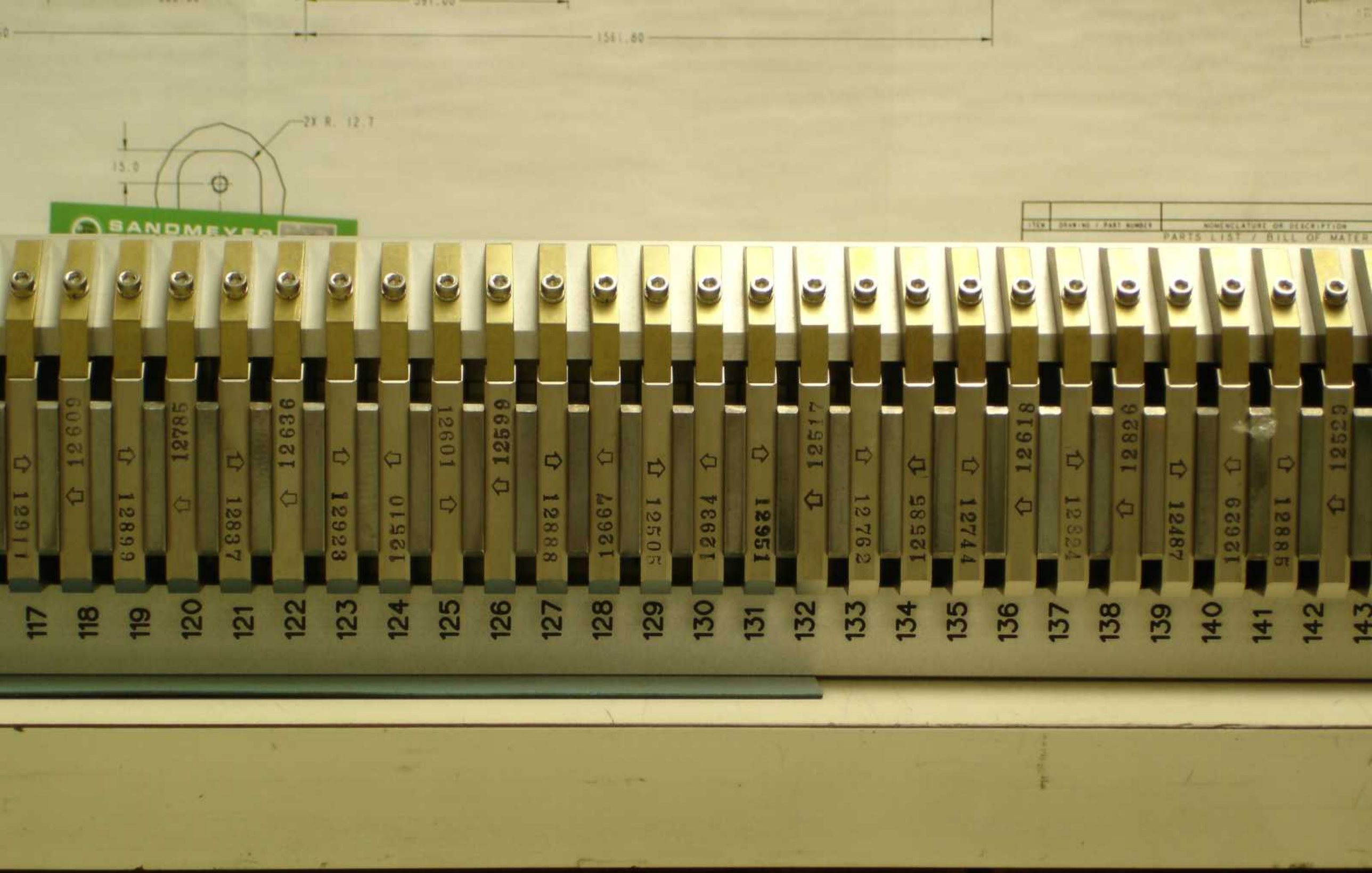
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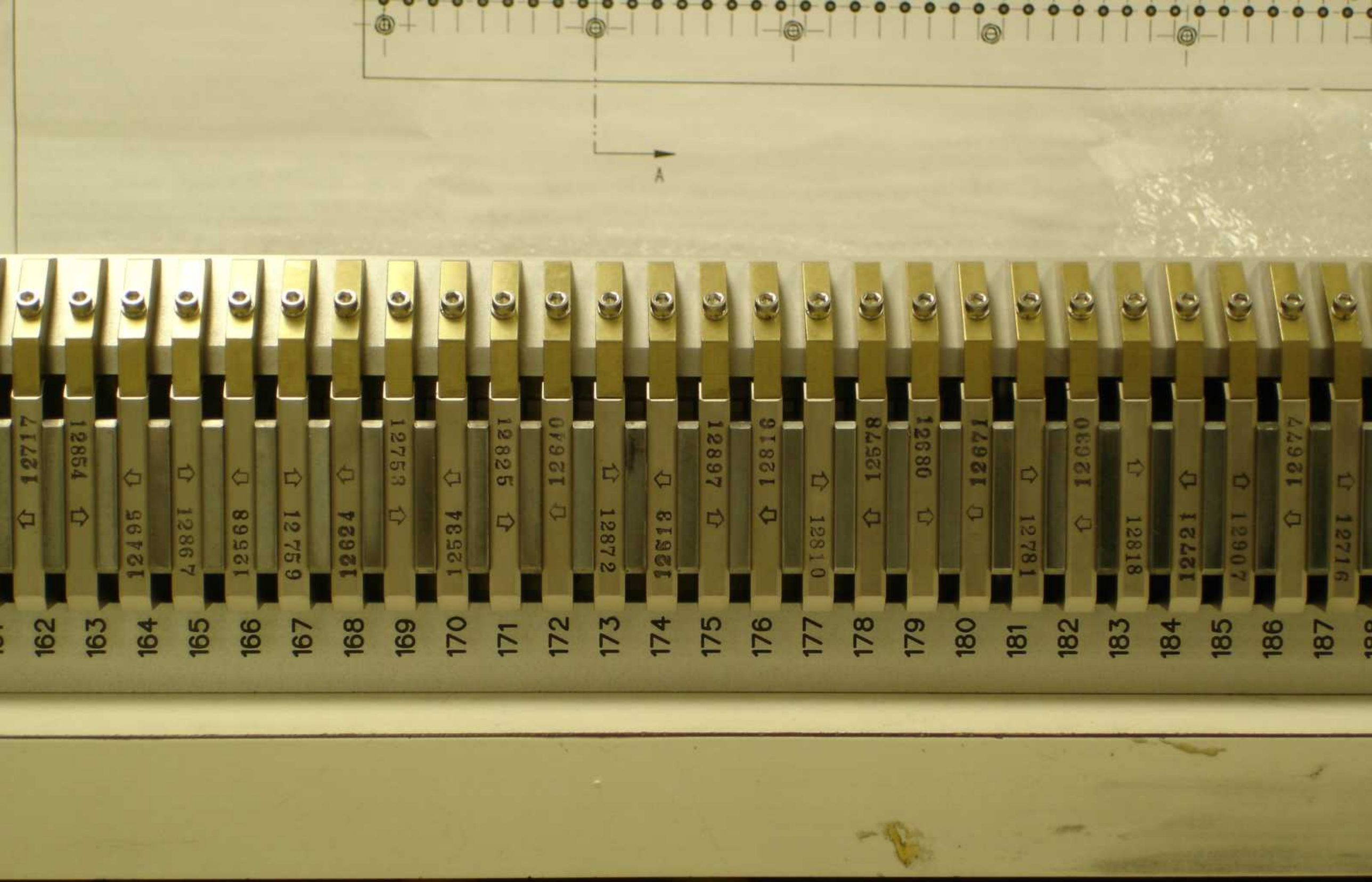
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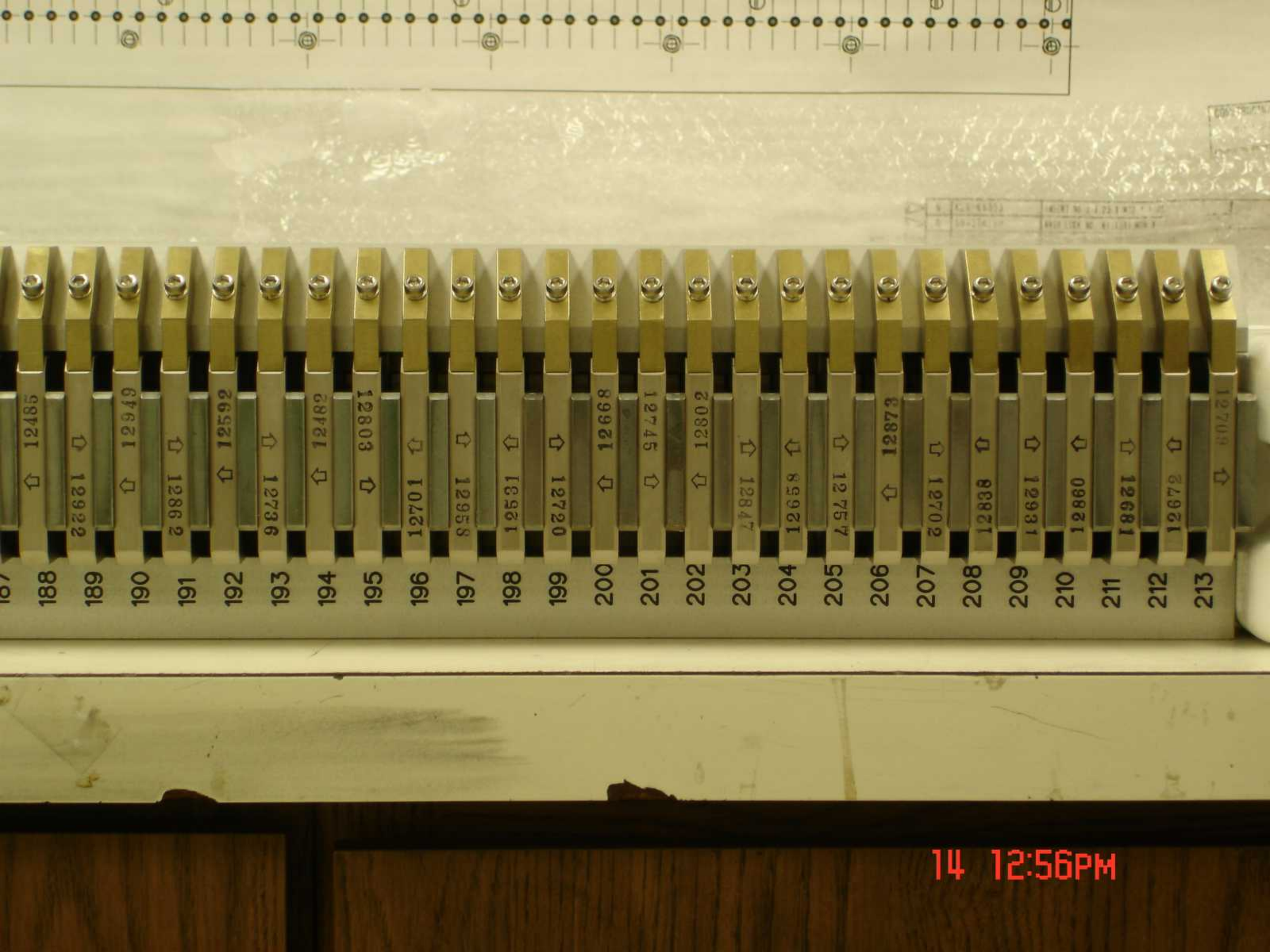
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