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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **00001**

P.O.#: **5A-05150** DATE: **12/30/05 8:18 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **00002**

P.O.#: **5A-05150** DATE: **12/30/05 10:36 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.937	**Rejected**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.045	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.009	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.005	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **00003**

P.O.#: **5A-05150** DATE: **12/30/05 9:17 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.020	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **00004**

P.O.#: **5A-05150** DATE: **12/30/05 9:40 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

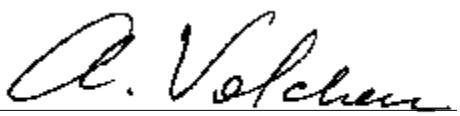
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.156	**Rejected**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **00005**

P.O.#: **5A-05150** DATE: **12/30/05 10:09 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

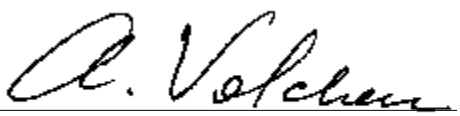
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.980	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **00450**

P.O.#: **5A-05150** DATE: **12/30/05 10:16 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01002**

P.O.#: **5A-05150** DATE: **12/30/05 9:33 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01003**

P.O.#: **5A-05150** DATE: **12/30/05 8:16 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

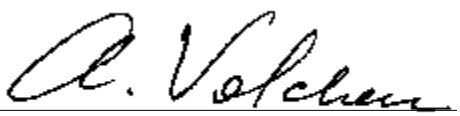
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.000	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01004**

P.O.#: **5A-05150** DATE: **12/30/05 7:48 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

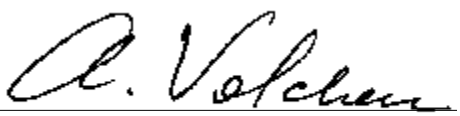
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01005**

P.O.#: **5A-05150** DATE: **12/30/05 10:05 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.998	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.002	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01007**

P.O.#: **5A-05150** DATE: **12/30/05 10:08 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01008**

P.O.#: **5A-05150** DATE: **11/10/05 8:50 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.989	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01011**

P.O.#: **5A-05150** DATE: **01/14/06 7:13 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

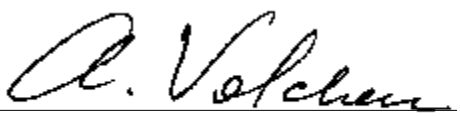
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01015**

P.O.#: **5A-05150** DATE: **12/30/05 9:21 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

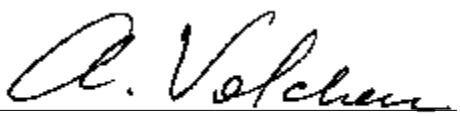
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.020	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01016**

P.O.#: **5A-05150** DATE: **12/30/05 9:58 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

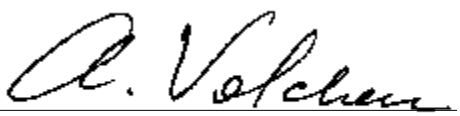
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01025**

P.O.#: **5A-05150** DATE: **12/30/05 10:50 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.937	**Rejected**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.036	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.009	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.049	**Rejected**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01026**

P.O.#: **5A-05150** DATE: **01/14/06 7:29 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

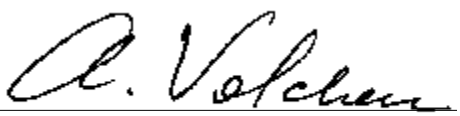
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.979	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.008	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.010	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01027**

P.O.#: **5A-05150** DATE: **12/30/05 8:07 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

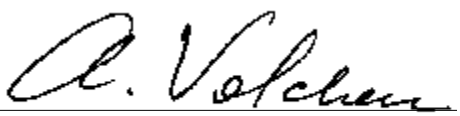
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01030**

P.O.#: **5A-05150** DATE: **12/30/05 8:50 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.998	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.002	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01032**

P.O.#: **5A-05150** DATE: **01/14/06 6:53 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

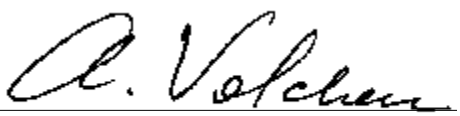
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.995	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.010	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.002	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01033**

P.O.#: **5A-05150** DATE: **12/30/05 9:22 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

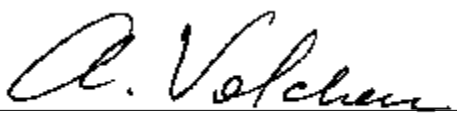
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01034**

P.O.#: **5A-05150** DATE: **11/10/05 8:26 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.016	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01037**

P.O.#: **5A-05150** DATE: **12/30/05 8:17 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

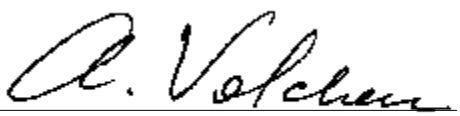
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.997	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.002	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.001	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01038**

P.O.#: **5A-05150** DATE: **01/03/06 9:34 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

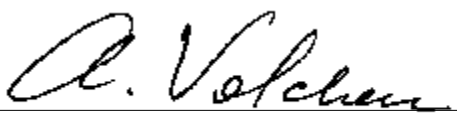
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.900	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01047**

P.O.#: **5A-05150** DATE: **11/10/05 11:13 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.031	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.990	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.008	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.800	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01170**

P.O.#: **5A-05150** DATE: **12/30/05 8:09 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.006	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01491**

P.O.#: **5A-05150** DATE: **11/10/05 11:07 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.037	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.990	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.016	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.007	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.800	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01513**

P.O.#: **5A-05150** DATE: **12/30/05 7:16 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

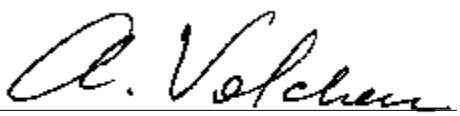
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.019	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.010	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.200	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01515**

P.O.#: **5A-05150** DATE: **12/30/05 10:40 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.024	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.939	**Rejected**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.030	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.011	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01519**

P.O.#: **5A-05150** DATE: **12/30/05 8:38 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

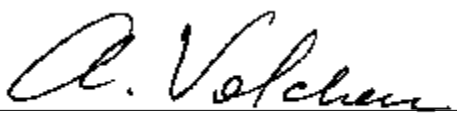
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01522**

P.O.#: **5A-05150** DATE: **12/30/05 10:13 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01527**

P.O.#: **5A-05150** DATE: **12/30/05 10:01 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

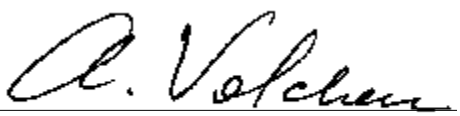
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01528**

P.O.#: **5A-05150** DATE: **01/03/06 9:33 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.990	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.900	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01533**

P.O.#: **5A-05150** DATE: **01/03/06 9:51 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

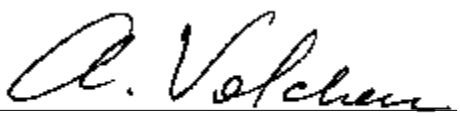
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.010	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.900	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01538**

P.O.#: **5A-05150** DATE: **12/30/05 8:41 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

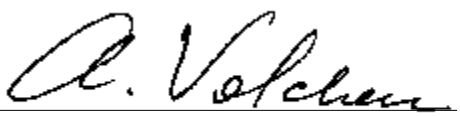
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.997	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.021	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.002	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01543**

P.O.#: **5A-05150** DATE: **01/14/06 6:46 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01544**

P.O.#: **5A-05150** DATE: **12/30/05 8:53 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

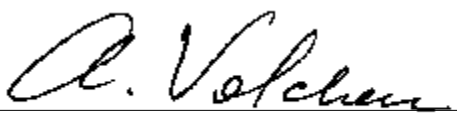
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01546**

P.O.#: **5A-05150** DATE: **11/10/05 9:34 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

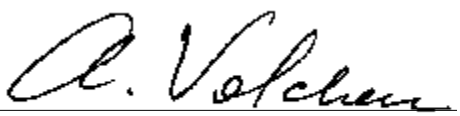
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.997	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.014	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01549**

P.O.#: **5A-05150** DATE: **10/13/06 9:49 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.990	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.006	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.000	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01550**

P.O.#: **5A-05150** DATE: **01/14/06 6:50 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01557**

P.O.#: **5A-05150** DATE: **12/30/05 8:54 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01558**

P.O.#: **5A-05150** DATE: **01/14/06 7:11 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

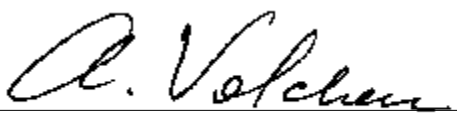
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01559**

P.O.#: **5A-05150** DATE: **12/30/05 7:11 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.000	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.200	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01572**

P.O.#: **5A-05150** DATE: **12/30/05 10:11 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

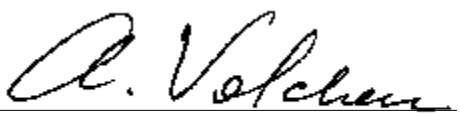
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01573**

P.O.#: **5A-05150** DATE: **11/10/05 8:43 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.990	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01580**

P.O.#: **5A-05150** DATE: **01/14/06 7:02 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

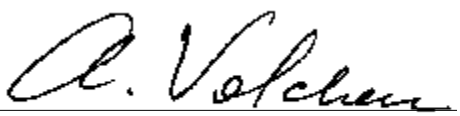
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01590**

P.O.#: **5A-05150** DATE: **11/10/05 9:47 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

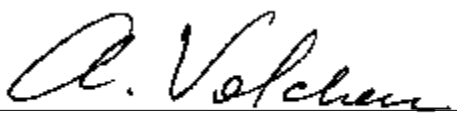
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.993	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01591**

P.O.#: **5A-05150** DATE: **12/30/05 8:35 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

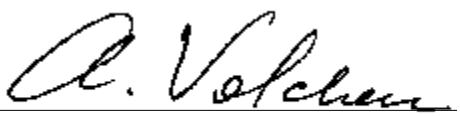
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.003	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01592**

P.O.#: **5A-05150** DATE: **12/30/05 8:15 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

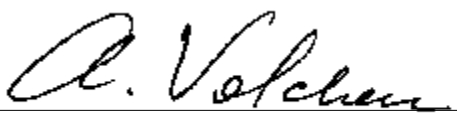
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.007	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01595**

P.O.#: **5A-05150** DATE: **12/30/05 9:48 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

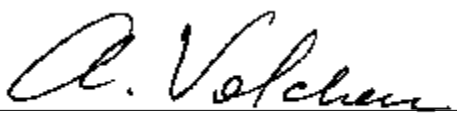
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01596**

P.O.#: **5A-05150** DATE: **11/10/05 9:37 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.991	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01597**

P.O.#: **5A-05150** DATE: **11/10/05 9:40 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

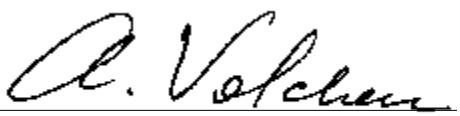
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.020	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.011	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01599**

P.O.#: **5A-05150** DATE: **12/30/05 9:51 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

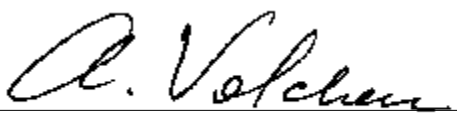
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01600**

P.O.#: **5A-05150** DATE: **11/10/05 8:51 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.992	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01604**

P.O.#: **5A-05150** DATE: **01/14/06 7:05 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

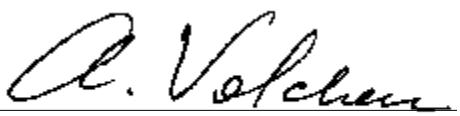
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01606**

P.O.#: **5A-05150** DATE: **01/14/06 6:48 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

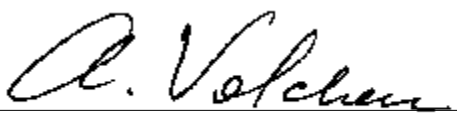
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01610**

P.O.#: **5A-05150** DATE: **01/14/06 7:06 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

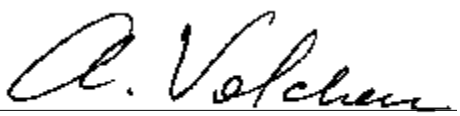
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01615**

P.O.#: **5A-05150** DATE: **11/10/05 8:46 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

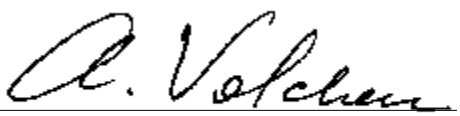
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.992	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.011	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01616**

P.O.#: **5A-05150** DATE: **12/30/05 9:57 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.995	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.016	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.003	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01620**

P.O.#: **5A-05150** DATE: **11/10/05 9:23 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.998	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.993	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.013	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01623**

P.O.#: **5A-05150** DATE: **12/30/05 9:50 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.998	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.002	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01624**

P.O.#: **5A-05150** DATE: **12/30/05 7:56 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

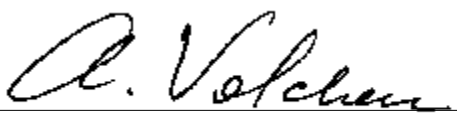
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.007	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01625**

P.O.#: **5A-05150** DATE: **01/03/06 9:42 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

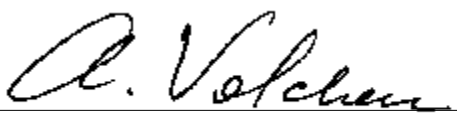
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.991	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.980	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.016	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.009	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.005	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.900	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01640**

P.O.#: **5A-05150** DATE: **12/30/05 8:14 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

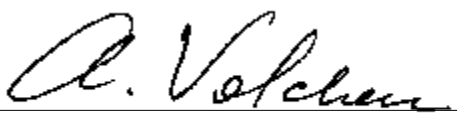
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.980	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01835**

P.O.#: **5A-05150** DATE: **01/14/06 6:49 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

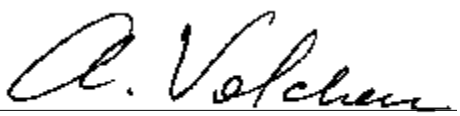
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.000	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.010	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01845**

P.O.#: **5A-05150** DATE: **12/30/05 10:56 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.963	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.007	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01978**

P.O.#: **5A-05150** DATE: **12/30/05 7:55 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

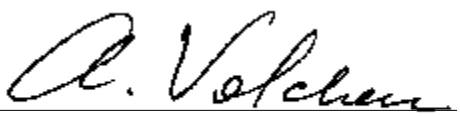
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.000	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01986**

P.O.#: **5A-05150** DATE: **12/30/05 10:44 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

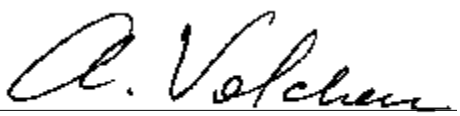
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.964	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.020	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.006	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.009	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01989**

P.O.#: **5A-05150** DATE: **12/30/05 8:30 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

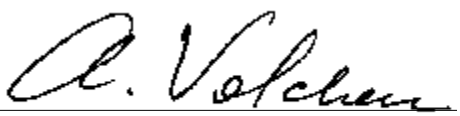
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.009	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **01996**

P.O.#: **5A-05150** DATE: **12/30/05 9:15 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.003	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02000**

P.O.#: **5A-05150** DATE: **01/14/06 6:52 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

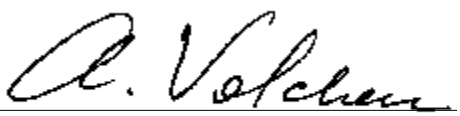
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.996	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.022	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.010	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.009	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02004**

P.O.#: **5A-05150** DATE: **11/10/05 9:28 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.999	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.002	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.014	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02041**

P.O.#: **5A-05150** DATE: **11/10/05 8:45 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

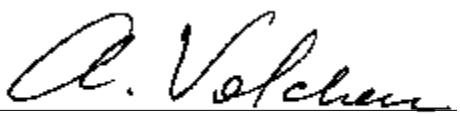
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.015	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02042**

P.O.#: **5A-05150** DATE: **12/30/05 8:31 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.998	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.001	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02043**

P.O.#: **5A-05150** DATE: **01/14/06 7:03 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

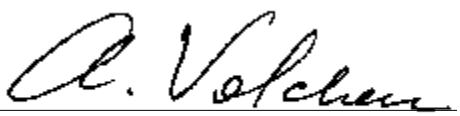
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.993	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02048**

P.O.#: **5A-05150** DATE: **11/10/05 9:20 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.988	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.003	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.012	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02054**

P.O.#: **5A-05150** DATE: **11/10/05 9:39 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.991	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02057**

P.O.#: **5A-05150** DATE: **12/30/05 10:29 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.964	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.036	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02063**

P.O.#: **5A-05150** DATE: **11/10/05 8:17 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.021	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.016	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02068**

P.O.#: **5A-05150** DATE: **12/30/05 8:13 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02072**

P.O.#: **5A-05150** DATE: **12/30/05 9:41 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

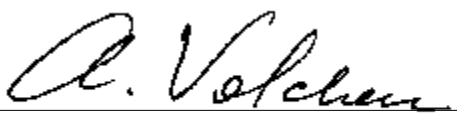
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.000	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02081**

P.O.#: **5A-05150** DATE: **12/30/05 8:32 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.999	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.001	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02082**

P.O.#: **5A-05150** DATE: **12/30/05 10:30 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.935	**Rejected**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02083**

P.O.#: **5A-05150** DATE: **12/30/05 7:49 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.007	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02095**

P.O.#: **5A-05150** DATE: **01/14/06 7:00 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

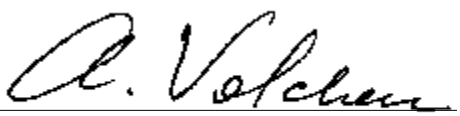
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.980	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02117**

P.O.#: **5A-05150** DATE: **12/30/05 10:02 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

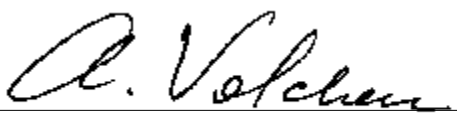
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02118**

P.O.#: **5A-05150** DATE: **01/14/06 6:38 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

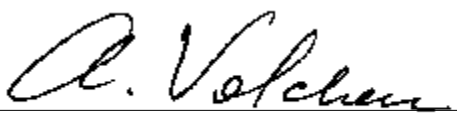
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02126**

P.O.#: **5A-05150** DATE: **11/10/05 8:13 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02134**

P.O.#: **5A-05150** DATE: **12/30/05 7:57 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

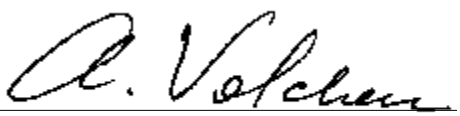
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02135**

P.O.#: **5A-05150** DATE: **12/30/05 10:37 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.964	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.031	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02145**

P.O.#: **5A-05150** DATE: **12/30/05 9:46 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02146**

P.O.#: **5A-05150** DATE: **11/10/05 8:35 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.995	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.987	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.019	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.015	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02147**

P.O.#: **5A-05150** DATE: **11/10/05 8:44 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.988	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.019	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.015	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02148**

P.O.#: **5A-05150** DATE: **11/10/05 9:45 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.994	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.996	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.022	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.014	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02149**

P.O.#: **5A-05150** DATE: **01/27/06 6:38 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.994	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.009	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.005	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	19.700	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02152**

P.O.#: **5A-05150** DATE: **12/30/05 7:08 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

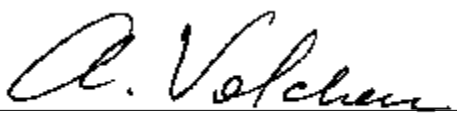
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.021	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.003	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.200	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02153**

P.O.#: **5A-05150** DATE: **12/30/05 9:30 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.992	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.022	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.001	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02154**

P.O.#: **5A-05150** DATE: **12/30/05 10:04 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02160**

P.O.#: **5A-05150** DATE: **01/14/06 7:04 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

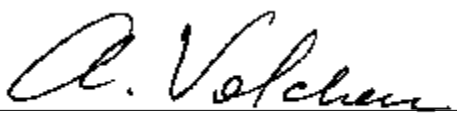
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02164**

P.O.#: **5A-05150** DATE: **01/14/06 6:47 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

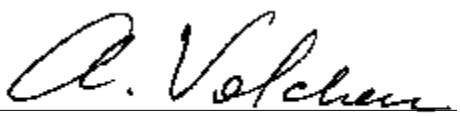
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02168**

P.O.#: **5A-05150** DATE: **12/30/05 10:49 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

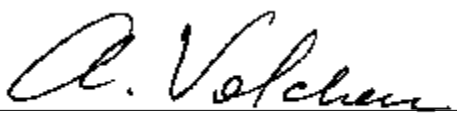
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.028	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.963	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.006	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02172**

P.O.#: **5A-05150** DATE: **11/10/05 9:26 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.015	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02173**

P.O.#: **5A-05150** DATE: **11/10/05 9:22 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.020	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02174**

P.O.#: **5A-05150** DATE: **12/30/05 8:46 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02177**

P.O.#: **5A-05150** DATE: **11/10/05 9:00 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.991	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.002	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02178**

P.O.#: **5A-05150** DATE: **12/30/05 7:14 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

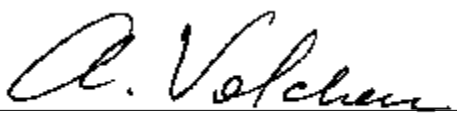
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.200	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02180**

P.O.#: **5A-05150** DATE: **12/30/05 7:42 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.200	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02181**

P.O.#: **5A-05150** DATE: **12/30/05 10:52 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.937	**Rejected**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02183**

P.O.#: **5A-05150** DATE: **12/30/05 7:50 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

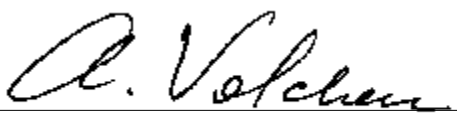
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02188**

P.O.#: **5A-05150** DATE: **01/03/06 9:23 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

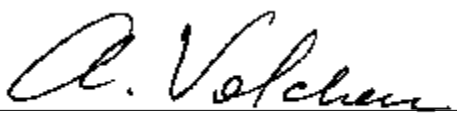
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.020	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.008	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.003	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.900	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02189**

P.O.#: **5A-05150** DATE: **01/14/06 7:12 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

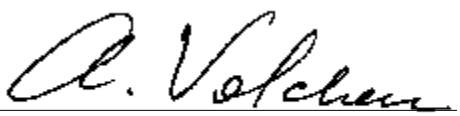
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.993	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02190**

P.O.#: **5A-05150** DATE: **12/30/05 9:47 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.006	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02191**

P.O.#: **5A-05150** DATE: **11/10/05 9:19 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.021	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.012	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02196**

P.O.#: **5A-05150** DATE: **12/30/05 7:51 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

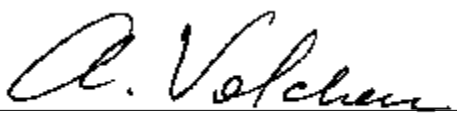
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02197**

P.O.#: **5A-05150** DATE: **11/10/05 9:32 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

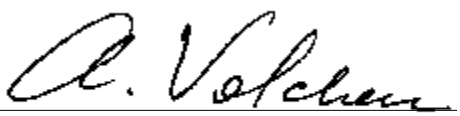
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.996	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02203**

P.O.#: **5A-05150** DATE: **12/30/05 10:15 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

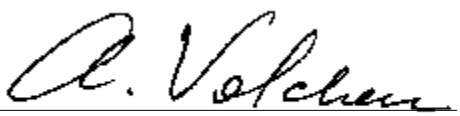
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02210**

P.O.#: **5A-05150** DATE: **01/14/06 7:13 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02211**

P.O.#: **5A-05150** DATE: **11/10/05 11:00 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

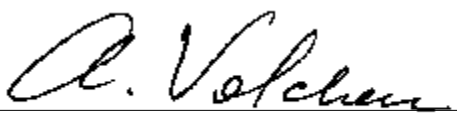
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.032	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.989	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.008	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.700	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02212**

P.O.#: **5A-05150** DATE: **01/03/06 9:46 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.900	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02221**

P.O.#: **5A-05150** DATE: **11/10/05 8:41 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

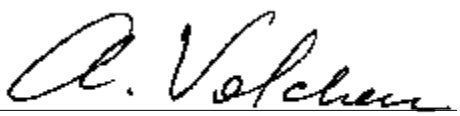
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.993	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.994	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.010	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02223**

P.O.#: **5A-05150** DATE: **11/10/05 8:52 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.993	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.015	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02225**

P.O.#: **5A-05150** DATE: **11/10/05 9:44 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

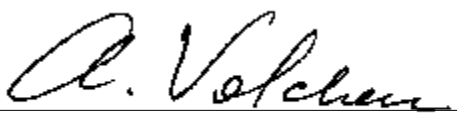
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.993	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.022	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02231**

P.O.#: **5A-05150** DATE: **12/30/05 8:02 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

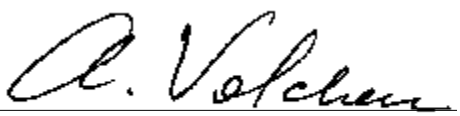
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.025	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02234**

P.O.#: **5A-05150** DATE: **01/14/06 7:09 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

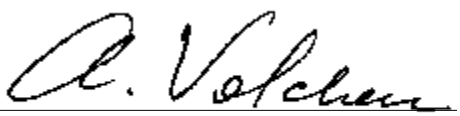
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.990	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02236**

P.O.#: **5A-05150** DATE: **01/14/06 7:08 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

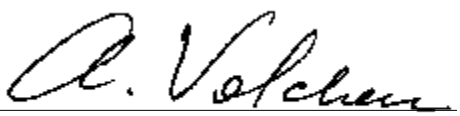
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.993	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02244**

P.O.#: **5A-05150** DATE: **11/10/05 8:58 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.993	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.989	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.012	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02245**

P.O.#: **5A-05150** DATE: **11/10/05 8:31 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

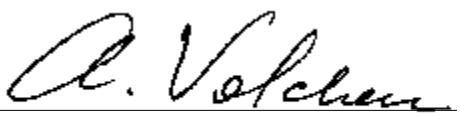
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.995	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.990	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.014	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02247**

P.O.#: **5A-05150** DATE: **11/10/05 9:25 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

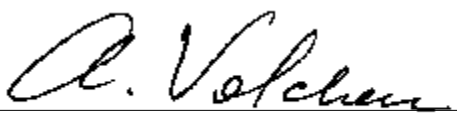
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.014	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02252**

P.O.#: **5A-05150** DATE: **12/30/05 9:27 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.016	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02256**

P.O.#: **5A-05150** DATE: **12/30/05 10:33 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.938	**Rejected**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.003	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.003	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02264**

P.O.#: **5A-05150** DATE: **12/30/05 9:14 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

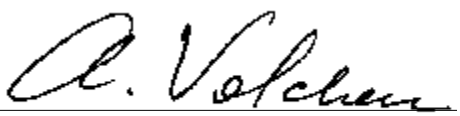
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02267**

P.O.#: **5A-05150** DATE: **12/30/05 7:23 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

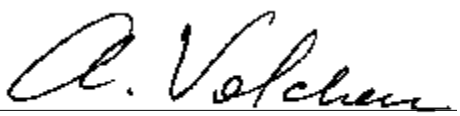
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.022	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.200	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02297**

P.O.#: **5A-05150** DATE: **12/30/05 9:16 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

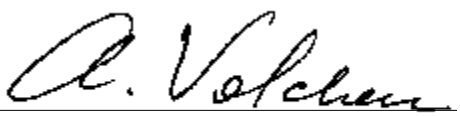
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02300**

P.O.#: **5A-05150** DATE: **11/12/05 11:48 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.995	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.987	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.013	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.200	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02301**

P.O.#: **5A-05150** DATE: **12/30/05 9:52 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

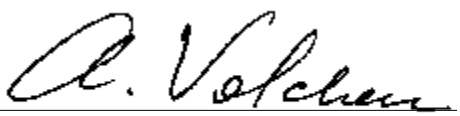
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.008	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02313**

P.O.#: **5A-05150** DATE: **12/30/05 8:29 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

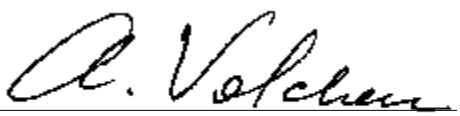
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	48.000	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.008	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.004	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02318**

P.O.#: **5A-05150** DATE: **12/30/05 10:10 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02323**

P.O.#: **5A-05150** DATE: **10/13/06 9:25 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

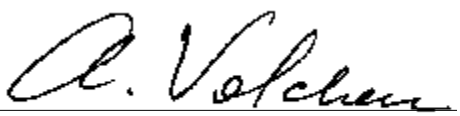
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.000	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.800	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02331**

P.O.#: **5A-05150** DATE: **12/30/05 9:56 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.007	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02343**

P.O.#: **5A-05150** DATE: **12/30/05 8:53 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

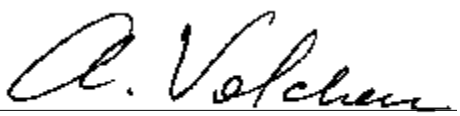
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.003	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.003	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02363**

P.O.#: **5A-05150** DATE: **01/14/06 6:54 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

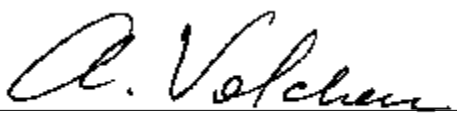
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02364**

P.O.#: **5A-05150** DATE: **11/10/05 8:59 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.021	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02418**

P.O.#: **5A-05150** DATE: **01/14/06 7:07 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

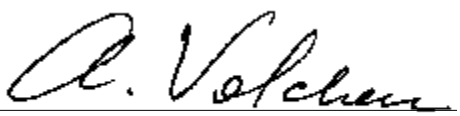
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02434**

P.O.#: **5A-05150** DATE: **12/30/05 9:43 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

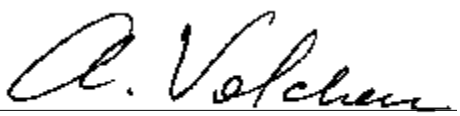
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02439**

P.O.#: **5A-05150** DATE: **12/30/05 10:00 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.010	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02493**

P.O.#: **5A-05150** DATE: **12/30/05 9:20 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

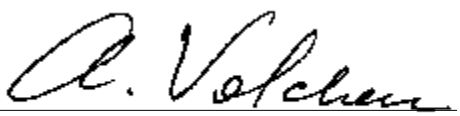
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.000	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02527**

P.O.#: **5A-05150** DATE: **12/30/05 10:35 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.939	**Rejected**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.036	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.035	**Rejected**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.006	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02531**

P.O.#: **5A-05150** DATE: **12/30/05 10:43 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

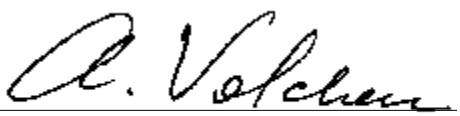
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.034	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.963	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.006	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02536**

P.O.#: **5A-05150** DATE: **01/14/06 7:01 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

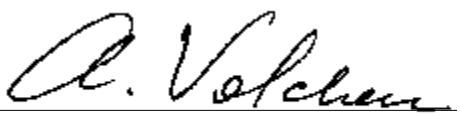
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.003	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02562**

P.O.#: **5A-05150** DATE: **11/10/05 9:24 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.999	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.988	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.011	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02601**

P.O.#: **5A-05150** DATE: **11/10/05 8:29 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

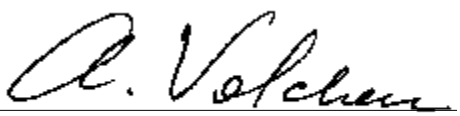
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.984	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.015	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02604**

P.O.#: **5A-05150** DATE: **12/30/05 8:08 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

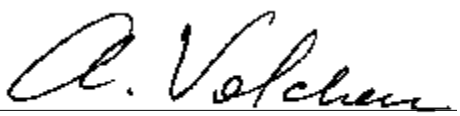
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02615**

P.O.#: **5A-05150** DATE: **01/14/06 6:51 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

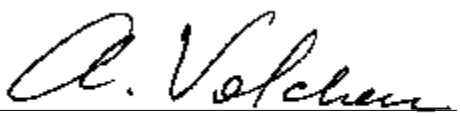
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.018	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.010	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	21.000	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02632**

P.O.#: **5A-05150** DATE: **12/30/05 7:38 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

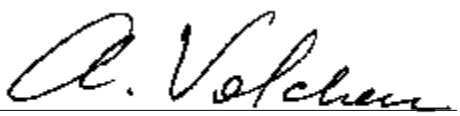
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.025	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.200	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02639**

P.O.#: **5A-05150** DATE: **11/10/05 9:38 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

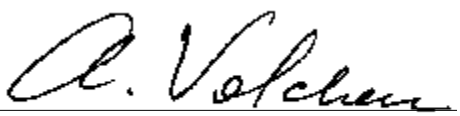
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.010	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02650**

P.O.#: **5A-05150** DATE: **12/30/05 10:14 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

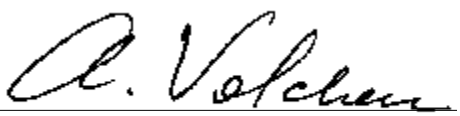
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.010	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02661**

P.O.#: **5A-05150** DATE: **11/10/05 9:43 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.019	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.013	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02674**

P.O.#: **5A-05150** DATE: **11/10/05 8:28 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.986	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.015	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02684**

P.O.#: **5A-05150** DATE: **11/10/05 8:33 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.994	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.990	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.021	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.013	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02685**

P.O.#: **5A-05150** DATE: **12/30/05 9:59 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

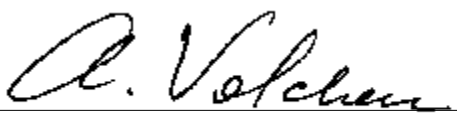
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **02698**

P.O.#: **5A-05150** DATE: **11/10/05 8:30 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

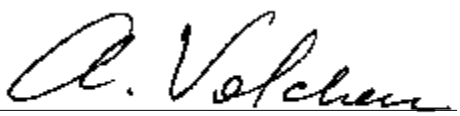
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.997	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.985	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.023	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.014	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03044**

P.O.#: **5A-05150** DATE: **12/30/05 10:53 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

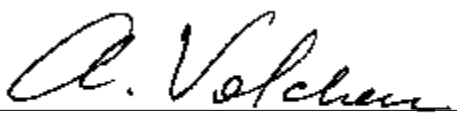
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.032	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.963	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.016	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.007	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.003	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03048**

P.O.#: **5A-05150** DATE: **12/30/05 9:31 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03153**

P.O.#: **5A-05150** DATE: **11/10/05 8:19 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.992	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.011	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03163**

P.O.#: **5A-05150** DATE: **12/30/05 9:55 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.003	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03165**

P.O.#: **5A-05150** DATE: **12/30/05 8:49 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.025	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03166**

P.O.#: **5A-05150** DATE: **12/30/05 9:37 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

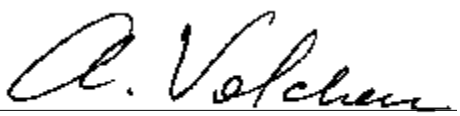
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.992	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.983	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.008	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03174**

P.O.#: **5A-05150** DATE: **12/30/05 9:49 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.982	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.007	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.001	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03189**

P.O.#: **5A-05150** DATE: **11/10/05 9:46 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

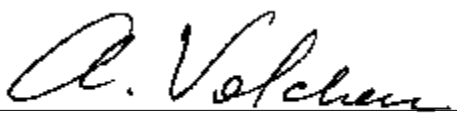
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.992	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.011	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.500	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03379**

P.O.#: **5A-05150** DATE: **11/10/05 11:29 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

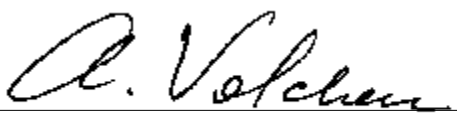
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.040	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.996	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.031	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.009	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.800	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **03759**

P.O.#: **5A-05150** DATE: **11/10/05 11:34 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	48.038	**Rejected**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.996	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.002	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.015	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.007	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	20.800	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **04356**

P.O.#: **5A-05150** DATE: **11/10/05 11:40 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

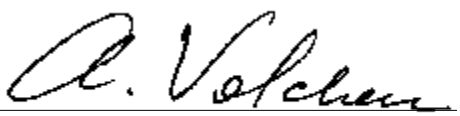
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.027	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.995	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.019	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.000	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.009	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.900	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **05097**

P.O.#: **5A-05150** DATE: **12/30/05 10:55 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	48.036	**Rejected**
2	Pole Thickness	6.000 -.000 -.050	5.954	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.053	**Rejected**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.018	**Rejected**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.017	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	20.600	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **REJECTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **08038**

P.O.#: **5A-05150** DATE: **10/13/06 10:15 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.997	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.960	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.005	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.005	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **08141**

P.O.#: **5A-05150** DATE: **10/13/06 9:33 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

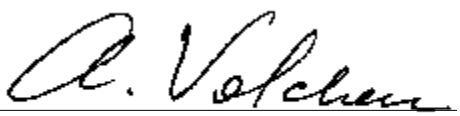
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.964	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.013	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.009	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.400	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **10913**

P.O.#: **5A-05150** DATE: **10/13/06 9:38 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.972	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.006	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **11758**

P.O.#: **5A-05150** DATE: **10/13/06 9:51 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

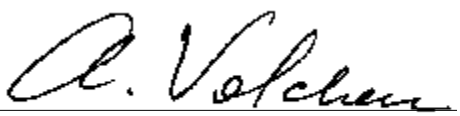
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.979	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.002	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.008	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **12599**

P.O.#: **5A-05150** DATE: **10/13/06 10:03 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.967	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.009	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.007	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.003	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **12622**

P.O.#: **5A-05150** DATE: **10/13/06 9:35 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

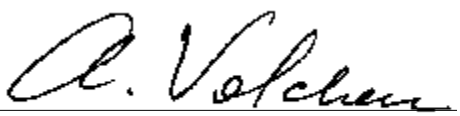
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.996	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.967	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.006	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.006	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **13030**

P.O.#: **5A-05150** DATE: **10/13/06 9:29 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.972	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.400	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **13751**

P.O.#: **5A-05150** DATE: **10/13/06 10:10 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.962	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.008	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.006	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **13776**

P.O.#: **5A-05150** DATE: **10/13/06 10:16 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 $^{-.000}_{-.010}$	47.999	**Accepted**
2	Pole Thickness	6.000 $^{-.000}_{-.050}$	5.963	**Accepted**
3	Plane A (Base) Flatness	0.000 $^{+.010}_{-.000}$	0.000	**Accepted**
4	Back-to-Base Perpendicularity	0.000 $^{+.025}_{-.000}$	0.019	**Accepted**
5	Plane B (Back) Flatness	0.000 $^{+.010}_{-.000}$	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 $^{+.025}_{-.000}$	0.004	**Accepted**
7	Threaded Holes Location	3.000 $^{+.050}_{-.050}$	Checked	**Accepted**
8	Temperature	20.000 $^{+2.000}_{-2.000}$	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **15965**

P.O.#: **5A-05150** DATE: **10/13/06 10:06 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.999	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.976	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.007	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.005	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **16095**

P.O.#: **5A-05150** DATE: **10/13/06 9:55 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

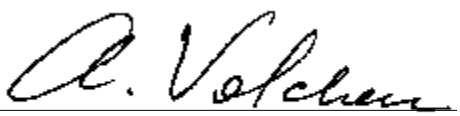
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.979	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.012	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.007	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **16394**

P.O.#: **5A-05150** DATE: **10/13/06 9:44 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

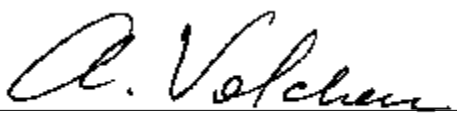
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.980	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.001	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.006	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **16559**

P.O.#: **5A-05150** DATE: **10/13/06 10:09 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.973	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.007	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **16748**

P.O.#: **5A-05150** DATE: **10/13/06 9:45 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.978	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.017	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.006	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.009	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **17143**

P.O.#: **5A-05150** DATE: **10/13/06 10:02 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.995	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.975	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.000	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.004	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **17283**

P.O.#: **5A-05150** DATE: **10/13/06 9:53 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

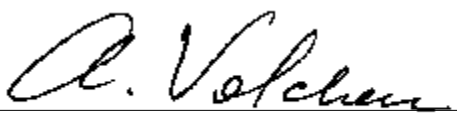
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.998	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.966	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.007	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **17395**

P.O.#: **5A-05150** DATE: **10/13/06 9:37 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

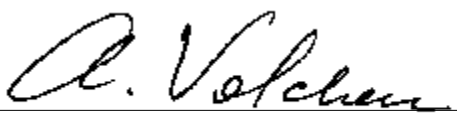
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.979	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.022	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.006	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **18052**

P.O.#: **5A-05150** DATE: **10/13/06 9:54 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

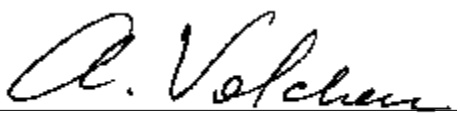
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.994	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.977	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.000	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.011	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.003	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.007	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **18666**

P.O.#: **5A-05150** DATE: **10/13/06 9:57 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.961	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.003	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **18850**

P.O.#: **5A-05150** DATE: **10/13/06 9:48 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.966	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.019	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.005	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.007	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **19463**

P.O.#: **5A-05150** DATE: **10/13/06 10:19 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

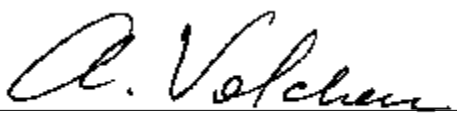
CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.996	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.967	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.024	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.004	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.002	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: 

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: 

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

INSPECTION/ACCEPTANCE REPORT OF COMPONENTS FOR AS-BUILT DRAWINGS

VENDOR: **Hi-Tech Manufacturing, Inc.** PART NAME: **LCLS Magnet Structure Last Pole**

DRAWING #: **L143-110107** SERIAL #: **20058**

P.O.#: **5A-05150** DATE: **10/13/06 10:12 am**

ACCEPTANCE CRITERIA

1	Visual inspection for shipping damage	**Accepted**

CRITICAL DIMENSIONS (mm)

#	Feature	Target & Tolerance	Measured Value	Result
1	Pole Height	48.000 -.000 -.010	47.997	**Accepted**
2	Pole Thickness	6.000 -.000 -.050	5.981	**Accepted**
3	Plane A (Base) Flatness	0.000 +.010 -.000	0.001	**Accepted**
4	Back-to-Base Perpendicularity	0.000 +.025 -.000	0.014	**Accepted**
5	Plane B (Back) Flatness	0.000 +.010 -.000	0.002	**Accepted**
6	Front-to-Back Parallelism	0.000 +.025 -.000	0.004	**Accepted**
7	Threaded Holes Location	3.000 +.050 -.050	Checked	**Accepted**
8	Temperature	20.000 +2.000 -2.000	18.300	**Accepted**

INSPECTOR: _____

FINAL CONCLUSION: **ACCEPTED**

TEST EQUIPMENT USED: **Mitutoyo CRT-AC544**

QA SUPERVISOR: _____