Accelerator Structures
Construction Tolerance Specification

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Brief Summary  Specifies critical construction tolerances related to the location and form of the accelerator structures.

Change History Log

<table>
<thead>
<tr>
<th>Rev Number</th>
<th>Revision Date</th>
<th>Sections Affected</th>
<th>Description of Change</th>
</tr>
</thead>
<tbody>
<tr>
<td>000</td>
<td>8-5-2005</td>
<td>All</td>
<td>Initial Version</td>
</tr>
<tr>
<td>001</td>
<td>3/1/2005</td>
<td>2.1 Specifications</td>
<td>Revise Shotcrete Wall Tolerance</td>
</tr>
</tbody>
</table>
Applicability - This specification is intended to be used as construction tolerances for critical interior surfaces of the accelerator structures to be constructed for LCLS. This specification does not apply to offices, labs, service buildings and other such construction.

1. Background
   1.1 The accelerator structure walls and floor must accurately follow the path of the beamline. The beamline is a precisely determined path along which the high energy electrons travel. Tolerance on the deviation of the structure surfaces from the design is specified to insure proper fit up of, and clearances to, components when installed.

2. Specifications
   2.1 The tolerances are: Finished floor +/- 3/8 inch in 20 feet, walls and roof in shotcrete construction + 1 inch, -3 inches, poured-in-place concrete walls and roof +/- ½ inch

   2.2 The beam centerline is defined in the LCLS coordinates system. For the section of the beam centerline through the UH, BTH, and Beam Dump it is a straight line along the z coordinate with x coordinate -1.25 m, and y coordinate –0.895305 m.
Maximum outward deviation from true position is 3 inch.

Maximum inward deviation from true position is 1 inch.

Actual Tunnel Inside Surface

Ideal Surfaces

Beam centerline

Flatness tolerance on floor
+/- 3/8 inch over any 20ft span