

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	001
Remarks		Article Number	
Supplier	KLYSTRON	Delivery Date	
Delivery Note		Delivery Volume	
Lot Number		Lot Size	
Test Schedule		Sample Size	
Production Machine		Production Tool	
Production Date		Production Time	
Order	710074	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	19-OCT-2009, 09:24:54
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9272-B
User Name	kcaban	WKP Name	NO\$NAME

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DATUM_A		PLA					
	FLATNS	0.00063	0.00000	0.00100	0.00000	0.00063	
DATUM_B		CYL					
	DM	0.37519	0.37500	0.00050	-0.00050	0.00019	
CYL_B		CYL					
	CYLFRM	0.00008	0.00000	0.00050	0.00000	0.00008	
SQR_B		AXI					
	SQRNES	0.00003	0.00000	0.00100	0.00000	0.00003	
FEATURE(1)		CIR					
	DM	0.99748	0.99800	0.00000	-0.00100	-0.00052	
FEATURE(2)		AXI					
	RADRUN	0.00029	0.00000	0.00100	0.00000	0.00029	
FEATURE(3)		PLA					
	Z	0.24169	0.24400	0.00000	-0.00500	-0.00231	
FEATURE(6)		CYL					
	FORM	0.00035					
	DM	0.28101	0.28100	0.00500	-0.00500	0.00001	
	X	-0.00545	0.00000			0.00545	
	Y	0.89934	0.90000			-0.00066	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01099	0.00000	0.03466	0.00000	0.01099	
FEATURE(7)		CYL					
	FORM	0.00048					
	DM	0.28111	0.28100	0.00500	-0.00500	0.00011	
	X	-0.64020	0.63630			0.00390	
	Y	0.63200	0.63630			-0.00430	
POS_FEATURE(7)		AXI					
	POSITN			0.03000			

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

POS_FEATURE(7)		AXI					
POSMMC	0.01175	0.00000	0.03463	0.00000	0.01175		

FEATURE(8)		CYL					
FORM	0.00030						
DM	0.28090	0.28100	0.00500	-0.00500	-0.00010		
X	-0.90014	0.90000			0.00014		
Y	-0.00589	0.00000			0.00589		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01188	0.00000	0.03454	0.00000	0.01188		

FEATURE(9)		CYL					
FORM	0.00044						
DM	0.28103	0.28100	0.00500	-0.00500	0.00003		
X	-0.63285	0.63630			-0.00345		
Y	-0.64081	0.63630			0.00451		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01139	0.00000	0.03458	0.00000	0.01139		

FEATURE(10)		CYL					
FORM	0.00028						
DM	0.28093	0.28100	0.00500	-0.00500	-0.00007		
X	0.00496	0.00000			0.00496		
Y	-0.90072	0.90000			0.00072		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.01009	0.00000	0.03464	0.00000	0.01009		

FEATURE(11)		CYL					
FORM	0.00046						
DM	0.28108	0.28100	0.00500	-0.00500	0.00008		
X	0.63990	0.63630			0.00360		
Y	-0.63342	0.63630			-0.00288		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.00930	0.00000	0.03463	0.00000	0.00930		

FEATURE(12)		CYL					
FORM	0.00031						
DM	0.28102	0.28100	0.00500	-0.00500	0.00002		
X	0.89976	0.90000			-0.00024		
Y	0.00448	0.00000			0.00448		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00909	0.00000	0.03470	0.00000	0.00909		

FEATURE(13)		CYL					
FORM	0.00049						
DM	0.28113	0.28100	0.00500	-0.00500	0.00013		
X	0.63257	0.63630			-0.00373		
Y	0.63945	0.63630			0.00315		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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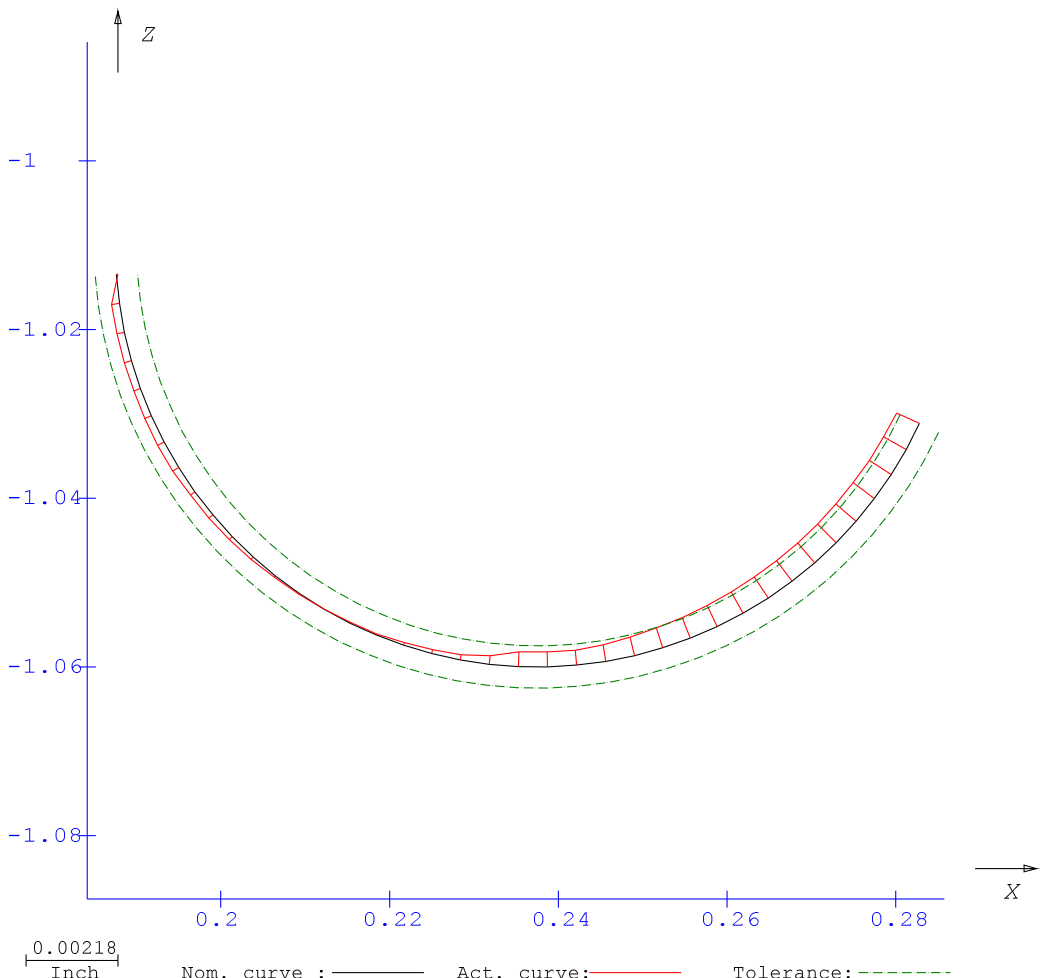
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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
POS_FEATURE(13)		AXI					
	POSITN			0.03000			
	POSMC	0.00985	0.00000	0.03464	0.00000	0.00985	
FEATURE(14)		CYL					
	FORM	0.00026					
	DM	3.50001	3.50000	0.00500	-0.00500	0.00001	
FEATURE(15)		AXI					
	RADRUN	0.00030	0.00000	0.00100	0.00000	0.00030	
FEATURE(4)		AXI					
	DZ	-0.09701	0.09700	0.00500	-0.00500	0.00001	
FEATURE(5)		CIR					
	FORM	0.00002					
	DM	0.87495	0.87500	0.00500	-0.00500	-0.00005	
POS_FEA(5)		POI					
	POSITN	0.00000	0.00000	0.00500	0.00000	0.00000	
FEATURE(16)		CIR					
	FORM	0.00058					
	DM	0.62602	0.62600	0.00500	-0.00500	0.00002	
FEATURE(17)		AXI					
	RADRUN	0.00066	0.00000	0.00100	0.00000	0.00066	
FEATURE(18)		CON					
	FORM	0.00001					
	CONANG_2	15.99184	16.00000			-0.00816	
	X	-0.00001	0.00000			0.00001	
	Y	-0.00006	0.00000			0.00006	
FEATURE(19)		POI					
	Z	0.12149	0.12000	0.00500	-0.00500	0.00149	
FEA_20(1)		AXI					
	DY	-0.06093	0.06000	0.01000	-0.01000	0.00093	
POS\$FEA_20(1)		AXI					
	POSITN	0.00170	0.00000	0.01000	0.00000	0.00170	
FEA_20(2)		AXI					
	DX	0.06058	0.06000	0.01000	-0.01000	0.00058	
POS\$FEA_20(2)		AXI					
	POSITN	0.00017	0.00000	0.01000	0.00000	0.00017	
FEA_20(3)		AXI					
	DY	-0.06086	0.06000	0.01000	-0.01000	0.00086	
POS\$FEA_20(3)		AXI					
	POSITN	0.00159	0.00000	0.01000	0.00000	0.00159	
FEA_20(4)		AXI					
	DX	0.06062	0.06000	0.01000	-0.01000	0.00062	
POS\$FEA_20(4)		AXI					
	POSITN	0.00027	0.00000	0.01000	0.00000	0.00027	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEAT_21(1)			AXI				
DZ		0.05899	0.06000	0.00500	-0.00500	-0.00101	
FEAT_21(2)			AXI				
DZ		0.05895	0.06000	0.00500	-0.00500	-0.00105	
FEAT_21(3)			AXI				
DZ		0.05890	0.06000	0.00500	-0.00500	-0.00110	
FEAT_21(4)			AXI				
DZ		0.05881	0.06000	0.00500	-0.00500	-0.00119	
DAT_B_OP			CYL				
DM		0.37520					
FORM		0.00018					
FEATURE(22)			PLA				
FORM		0.00028					
Z		-0.56399					
FEATURE(23)			PLA				
PARALL		0.00036	0.00000	0.00100	0.00000	0.00036	
FEA(24)			PLA				
Z		-1.00974					
FORM		0.00004					
FEATURE(24)			PLA				
PARALL		0.00006	0.00000	0.00100	0.00000	0.00006	
FEATURE(25)			AXI				
DZ		-0.44575	0.44500	0.00100	0.00000	0.00075	
FEATURE(26)			AXI				
Z		-1.00974	1.01000	0.00200	0.00000	-0.00026	-0.00026
FEAT_27(1)			AXI				
DZ		-0.07939	0.08000	0.01000	-0.01000	-0.00061	
FEAT_27(2)			AXI				
DZ		-0.07563	0.08000	0.01000	-0.01000	-0.00437	
FEATURE(28)			CIR				
FORM		0.00019					
DM		2.25043	2.25000	0.01000	-0.01000	0.00043	
FEAT(28)			AXI				
RADRUN		0.00032	0.00000	0.00500	0.00000	0.00032	
FEATURE(30)			CYL				
FORM		0.00006					
DM		0.99727	0.99800	0.00000	-0.01000	-0.00073	
FEATURE(31)			AXI				
RADRUN		0.00013	0.00000	0.00100	0.00000	0.00013	
FEA(36)			CYL				
DM		0.28121	0.28100	0.00500	-0.00500	0.00021	
XY		1.49982	1.50000			-0.00018	
PP_PXPY		-0.20633	0.00000			0.20633	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEA(36)		CYL					
DM		0.28122	0.28100	0.00500	-0.00500	0.00022	
XY		1.49982	1.50000			-0.00018	
PP_PXPY		-0.20633	0.00000			0.20633	
FEA(37)		CYL					
DM		0.28124	0.28100	0.00500	-0.00500	0.00024	
XY		1.49979	1.50000			-0.00021	
PP_PXPY		44.80141	45.00000			-0.19859	
FEA(38)		CYL					
DM		0.28111	0.28100	0.00500	-0.00500	0.00011	
XY		1.49954	1.50000			-0.00046	
PP_PXPY		89.81367	90.00000			-0.18633	
FEA(39)		CYL					
DM		0.28122	0.28100	0.00500	-0.00500	0.00022	
XY		1.49981	1.50000			-0.00019	
PP_PXPY		134.82286	135.00000			-0.17714	
FEA(40)		CYL					
DM		0.28120	0.28100	0.00500	-0.00500	0.00020	
XY		1.50012	1.50000			0.00012	
PP_PXPY		179.82858	180.00000			-0.17142	
POS_FEATURE(36)		AXI					
POSITN				0.03000			
POSMC		0.01082	0.00000	0.03511	0.00000	0.01082	
POS_FEATURE(37)		AXI					
POSITN				0.03000			
POSMC		0.01046	0.00000	0.03494	0.00000	0.01046	
POS_FEATURE(38)		AXI					
POSITN				0.03000			
POSMC		0.00983	0.00000	0.03500	0.00000	0.00983	
POS_FEATURE(39)		AXI					
POSITN				0.03000			
POSMC		0.00936	0.00000	0.03498	0.00000	0.00936	
POS_FEATURE(40)		AXI					
POSITN				0.03000			
POSMC		0.00901	0.00000	0.03512	0.00000	0.00901	
FEATURE(32)		AXI					
RADRUN		0.00033	0.00000	0.00100	0.00000	0.00033	
FEATURE(29)		TOR					
FORM		0.00059					
Cir_RA		0.04972	0.05000	0.00050	-0.00050	-0.00029	
OUT_DM		0.57341	0.57500	0.00100	-0.00100	-0.00159	
INN_DM		0.37455	0.37500			-0.00045	
X		0.00005					
Y		-0.00005					
FEA(33)		PLA					
FORM		0.00009					
Z		-1.05943					

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEATURE(34)			AXI				
DZ		0.04969	0.05000	0.00050	-0.00050	-0.00031	
FEATURE(41)			CIR				
FORM		0.00027					
RA		0.01728	0.01600	0.00200	-0.00200	0.00128	
FEA_42(1)			AXI				
Y		-0.20500	0.20000	0.01000	-0.01000	0.00500	
FEA_42(2)			AXI				
Y		-0.19544	0.20000	0.01000	-0.01000	-0.00456	
FEATURE(43)			CIR				
RA		0.12733	0.12500	0.00500	-0.00500	0.00233	
FEATURE(44)			CIR				
FORM		0.00009					
RA		1.24981	1.25000	0.01000	-0.01000	-0.00019	
FEATURE(45)			POI				
POSITN		0.00061	0.00000	0.00500	0.00000	0.00061	
FEATURE(46)			CIR				
FORM		0.00018					
RA		1.65015	1.65000	0.01000	-0.01000	0.00015	
FEATURE(47)			POI				
POSITN		0.00068	0.00000	0.00500	0.00000	0.00068	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

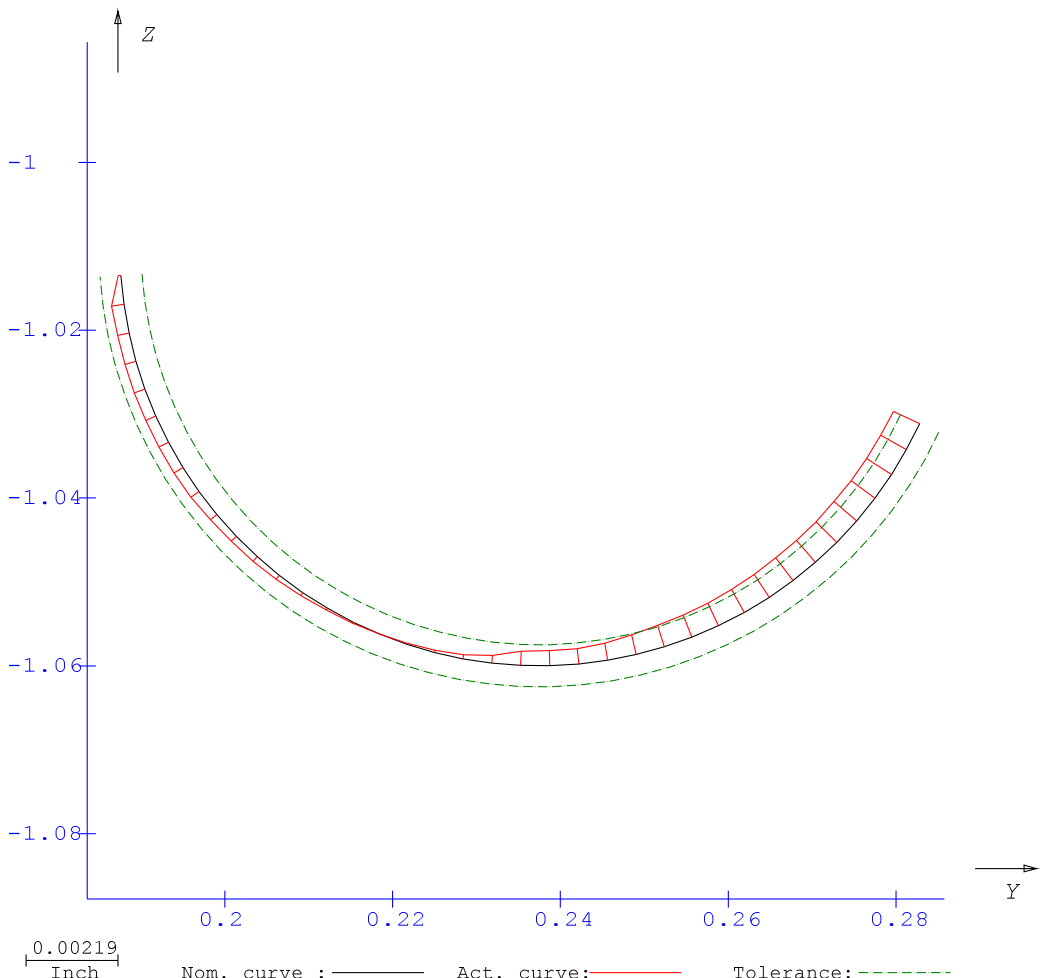
		X	Y	Z	Nr.
Form	0.00082	0.18798	0.00000	-1.01691	38
Lower Toler. :	-0.00050	0.27747	0.00000	-1.04004	4
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00019 Profile of Radius 0.0500
 Max. Deviat.: 0.00063 @ 0°



2D - CONTOUR

Inspector.:kcaban
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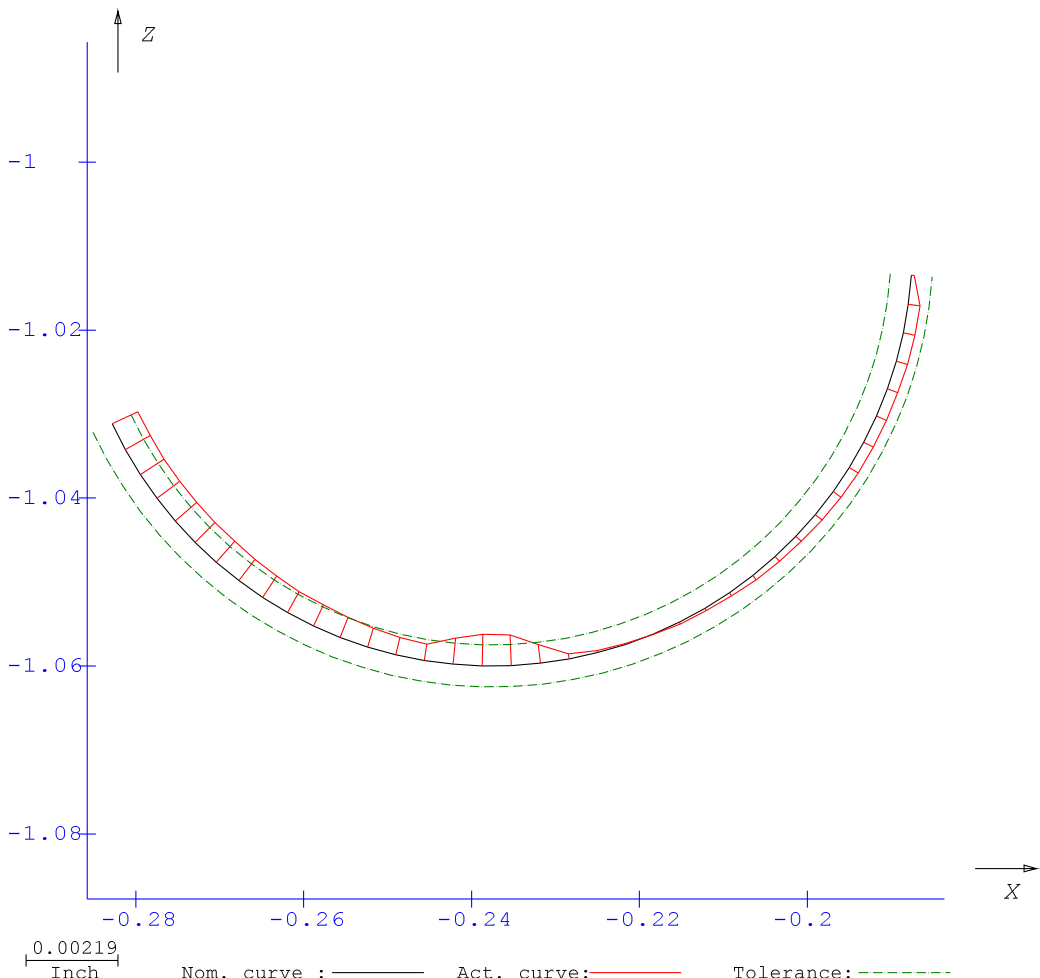
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

		X	Y	Z	Nr.	
Form	0.00101	Min. Deviat.:-0.00071	0.00000	0.27529	-1.04274	5
Lower Toler. :	-0.00050	Max. Deviat.: 0.00030	0.00000	0.18798	-1.01691	38
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 90°				
No. of points:	39					



2D - CONTOUR

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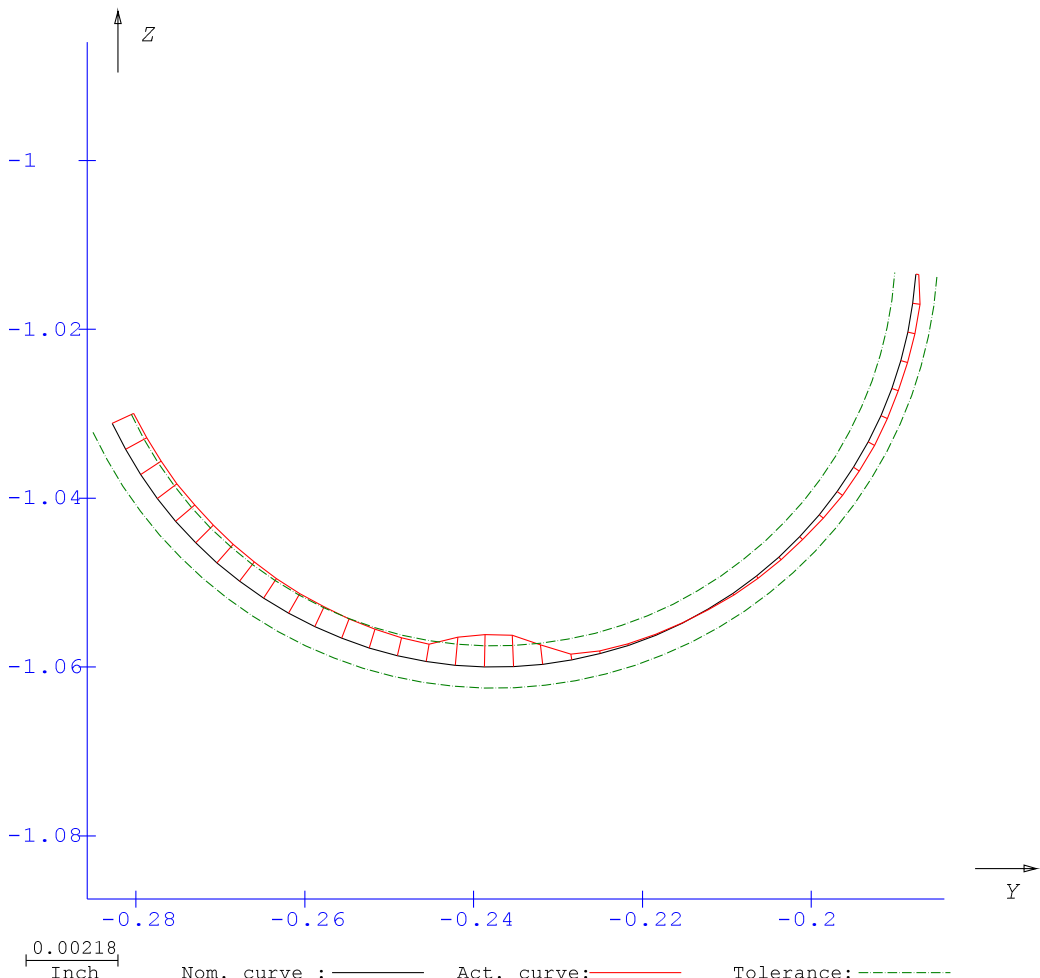
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.	
Form	0.00104	Min. Deviat.:-0.00075	-0.23873	0.00000	-1.05998	17
Lower Toler. :	-0.00050	Max. Deviat.: 0.00028	-0.18798	0.00000	-1.01691	38
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 180°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban
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 Time:09:24:54



Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.
Form	0.00094	0.00000	-0.23873	-1.05998	17
Lower Toler. :	-0.00050	0.00000	-0.18798	-1.01691	38
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00076 Profile of Radius 0.0500
 Max. Deviat.: 0.00018 @ 270°



2D - CONTOUR

Inspector.:kcaban
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