

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	002
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	710008	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	19-OCT-2009, 10:40:27
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	0.00043	0.00000	0.00100	0.00000	0.00043	
DATUM_B		CYL					
	DM	0.37514	0.37500	0.00050	-0.00050	0.00014	
CYL_B		CYL					
	CYLFRM	0.00006	0.00000	0.00050	0.00000	0.00006	
SQR_B		AXI					
	SQRNES	0.00004	0.00000	0.00100	0.00000	0.00004	
FEATURE(1)		CIR					
	DM	0.99734	0.99800	0.00000	-0.00100	-0.00066	
FEATURE(2)		AXI					
	RADRUN	0.00013	0.00000	0.00100	0.00000	0.00013	
FEATURE(3)		PLA					
	Z	0.24170	0.24400	0.00000	-0.00500	-0.00230	
FEATURE(6)		CYL					
	FORM	0.00035					
	DM	0.28105	0.28100	0.00500	-0.00500	0.00005	
	X	-0.00006	0.00000			0.00006	
	Y	0.89996	0.90000			-0.00004	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.00024	0.00000	0.03471	0.00000	0.00024	
FEATURE(7)		CYL					
	FORM	0.00046					
	DM	0.28115	0.28100	0.00500	-0.00500	0.00015	
	X	-0.63637	0.63630			0.00007	
	Y	0.63632	0.63630			0.00002	
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					
	POSMC	0.00020	0.00000	0.03468	0.00000	0.00020	

FEATURE(8)		CYL					
	FORM	0.00032					
	DM	0.28099	0.28100	0.00500	-0.00500	-0.00001	
	X	-0.90001	0.90000			0.00001	
	Y	-0.00010	0.00000			0.00010	

POS_FEATURE(8)		AXI					
	POSITN			0.03000			
	POSMC	0.00031	0.00000	0.03465	0.00000	0.00031	

FEATURE(9)		CYL					
	FORM	0.00044					
	DM	0.28101	0.28100	0.00500	-0.00500	0.00001	
	X	-0.63639	0.63630			0.00009	
	Y	-0.63647	0.63630			0.00017	

POS_FEATURE(9)		AXI					
	POSITN			0.03000			
	POSMC	0.00048	0.00000	0.03459	0.00000	0.00048	

FEATURE(10)		CYL					
	FORM	0.00028					
	DM	0.28096	0.28100	0.00500	-0.00500	-0.00004	
	X	-0.00007	0.00000			0.00007	
	Y	-0.90010	0.90000			0.00010	

POS_FEATURE(10)		AXI					
	POSITN			0.03000			
	POSMC	0.00031	0.00000	0.03467	0.00000	0.00031	

FEATURE(11)		CYL					
	FORM	0.00045					
	DM	0.28110	0.28100	0.00500	-0.00500	0.00010	
	X	0.63637	0.63630			0.00007	
	Y	-0.63645	0.63630			0.00015	

POS_FEATURE(11)		AXI					
	POSITN			0.03000			
	POSMC	0.00041	0.00000	0.03465	0.00000	0.00041	

FEATURE(12)		CYL					
	FORM	0.00032					
	DM	0.28102	0.28100	0.00500	-0.00500	0.00002	
	X	0.89994	0.90000			-0.00006	
	Y	-0.00009	0.00000			0.00009	

POS_FEATURE(12)		AXI					
	POSITN			0.03000			
	POSMC	0.00027	0.00000	0.03469	0.00000	0.00027	

FEATURE(13)		CYL					
	FORM	0.00044					
	DM	0.28115	0.28100	0.00500	-0.00500	0.00015	
	X	0.63642	0.63630			0.00012	
	Y	0.63637	0.63630			0.00007	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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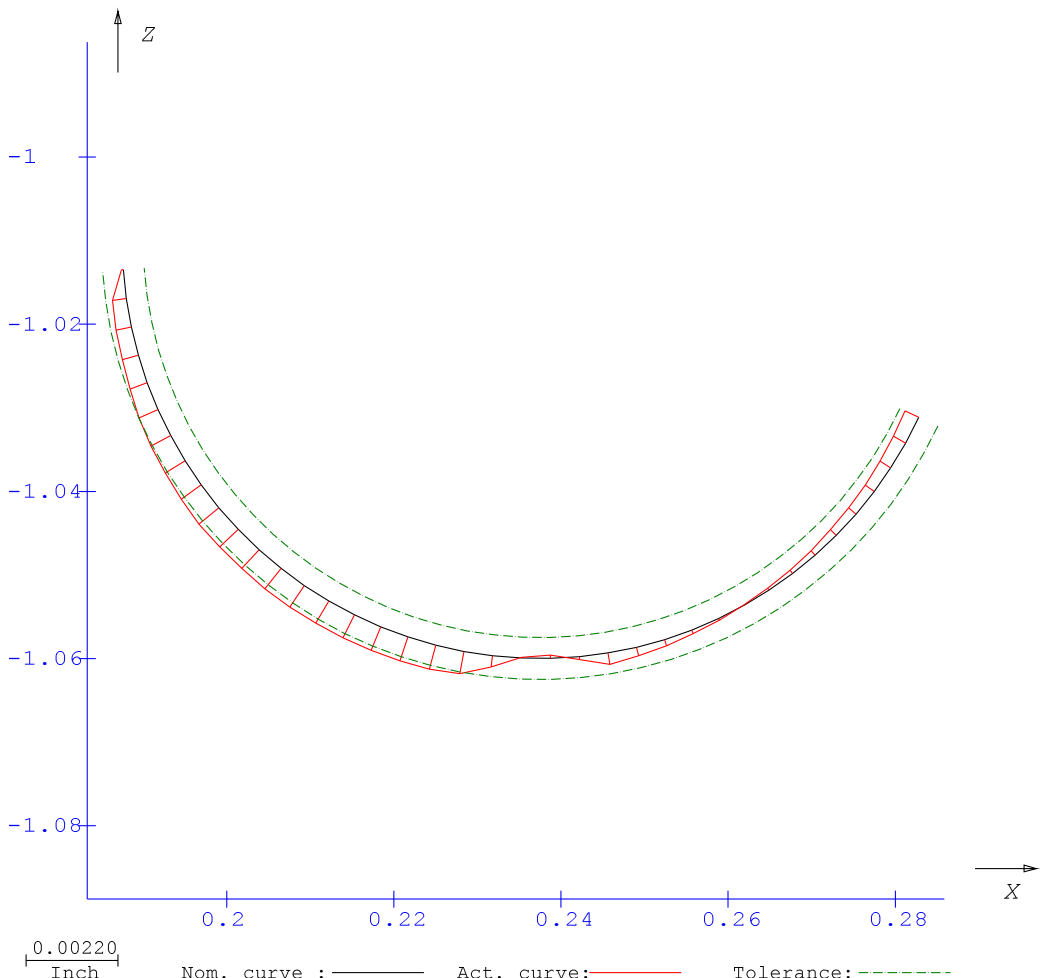
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Text	Eva1.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
POS_FEATURE(13)		AXI					
	POSITN			0.03000			
	POSMC	0.00031	0.00000	0.03471	0.00000	0.00031	
FEATURE(14)		CYL					
	FORM	0.00029					
	DM	3.49990	3.50000	0.00500	-0.00500	-0.00010	
FEATURE(15)		AXI					
	RADRUN	0.00029	0.00000	0.00100	0.00000	0.00029	
FEATURE(4)		AXI					
	DZ	-0.09700	0.09700	0.00500	-0.00500	0.00000	
FEATURE(5)		CIR					
	FORM	0.00012					
	DM	0.87485	0.87500	0.00500	-0.00500	-0.00015	
POS_FEA(5)		POI					
	POSITN	0.00006	0.00000	0.00500	0.00000	0.00006	
FEATURE(16)		CIR					
	FORM	0.00003					
	DM	0.62607	0.62600	0.00500	-0.00500	0.00007	
FEATURE(17)		AXI					
	RADRUN	0.00009	0.00000	0.00100	0.00000	0.00009	
FEATURE(18)		CON					
	FORM	0.00002					
	CONANG_2	15.99455	16.00000			-0.00545	
	X	-0.00004	0.00000			0.00004	
	Y	0.00000	0.00000			0.00000	
FEATURE(19)		POI					
	Z	0.12206	0.12000	0.00500	-0.00500	0.00206	
FEA_20(1)		AXI					
	DY	-0.06089	0.06000	0.01000	-0.01000	0.00089	
POS\$FEA_20(1)		AXI					
	POSITN	0.00095	0.00000	0.01000	0.00000	0.00095	
FEA_20(2)		AXI					
	DX	0.06062	0.06000	0.01000	-0.01000	0.00062	
POS\$FEA_20(2)		AXI					
	POSITN	0.00052	0.00000	0.01000	0.00000	0.00052	
FEA_20(3)		AXI					
	DY	-0.06084	0.06000	0.01000	-0.01000	0.00084	
POS\$FEA_20(3)		AXI					
	POSITN	0.00105	0.00000	0.01000	0.00000	0.00105	
FEA_20(4)		AXI					
	DX	0.06061	0.06000	0.01000	-0.01000	0.00061	
POS\$FEA_20(4)		AXI					
	POSITN	0.00030	0.00000	0.01000	0.00000	0.00030	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEAT_21(1)			AXI				
DZ		0.05940	0.06000	0.00500	-0.00500	-0.00061	
FEAT_21(2)			AXI				
DZ		0.05927	0.06000	0.00500	-0.00500	-0.00073	
FEAT_21(3)			AXI				
DZ		0.05932	0.06000	0.00500	-0.00500	-0.00068	
FEAT_21(4)			AXI				
DZ		0.05934	0.06000	0.00500	-0.00500	-0.00066	
DAT_B_OP			CYL				
DM		0.37514					
FORM		0.00006					
FEATURE(22)			PLA				
FORM		0.00025					
Z		-0.56469					
FEATURE(23)			PLA				
PARALL		0.00029	0.00000	0.00100	0.00000	0.00029	
FEA(24)			PLA				
Z		-1.01040					
FORM		0.00002					
FEATURE(24)			PLA				
PARALL		0.00004	0.00000	0.00100	0.00000	0.00004	
FEATURE(25)			AXI				
DZ		-0.44571	0.44500	0.00100	0.00000	0.00071	
FEATURE(26)			AXI				
Z		-1.01040	1.01000	0.00200	0.00000	0.00040	
FEAT_27(1)			AXI				
DZ		-0.07946	0.08000	0.01000	-0.01000	-0.00054	
FEAT_27(2)			AXI				
DZ		-0.07599	0.08000	0.01000	-0.01000	-0.00401	
FEATURE(28)			CIR				
FORM		0.00016					
DM		2.25040	2.25000	0.01000	-0.01000	0.00040	
FEAT(28)			AXI				
RADRUN		0.00019	0.00000	0.00500	0.00000	0.00019	
FEATURE(30)			CYL				
FORM		0.00005					
DM		0.99725	0.99800	0.00000	-0.01000	-0.00075	
FEATURE(31)			AXI				
RADRUN		0.00008	0.00000	0.00100	0.00000	0.00008	
FEA(36)			CYL				
DM		0.28128	0.28100	0.00500	-0.00500	0.00028	
XY		1.49979	1.50000			-0.00021	
PP_PXPY		-0.46111	0.00000			0.46111	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
FEA(36)		CYL					
DM		0.28129	0.28100	0.00500	-0.00500	0.00029	
XY		1.49978	1.50000			-0.00022	
PP_PXPY		-0.46104	0.00000			0.46104	
FEA(37)		CYL					
DM		0.28126	0.28100	0.00500	-0.00500	0.00026	
XY		1.49998	1.50000			-0.00002	
PP_PXPY		44.54438	45.00000			-0.45562	
FEA(38)		CYL					
DM		0.28117	0.28100	0.00500	-0.00500	0.00017	
XY		1.49980	1.50000			-0.00020	
PP_PXPY		89.55089	90.00000			-0.44911	
FEA(39)		CYL					
DM		0.28128	0.28100	0.00500	-0.00500	0.00028	
XY		1.50002	1.50000			0.00002	
PP_PXPY		134.55366	135.00000			-0.44634	
FEA(40)		CYL					
DM		0.28123	0.28100	0.00500	-0.00500	0.00023	
XY		1.50009	1.50000			0.00009	
PP_PXPY		179.55646	180.00000			-0.44354	
POS_FEATURE(36)		AXI					
POSITN				0.03000			
POSMCC		0.02416	0.00000	0.03512	0.00000	0.02416	
POS_FEATURE(37)		AXI					
POSITN				0.03000			
POSMCC		0.02387	0.00000	0.03494	0.00000	0.02387	
POS_FEATURE(38)		AXI					
POSITN				0.03000			
POSMCC		0.02354	0.00000	0.03505	0.00000	0.02354	
POS_FEATURE(39)		AXI					
POSITN				0.03000			
POSMCC		0.02346	0.00000	0.03508	0.00000	0.02346	
POS_FEATURE(40)		AXI					
POSITN				0.03000			
POSMCC		0.02325	0.00000	0.03514	0.00000	0.02325	
FEATURE(32)		AXI					
RADRUN		0.00014	0.00000	0.00100	0.00000	0.00014	
FEATURE(29)		TOR					
FORM		0.00056					
Cir_RA		0.04971	0.05000	0.00050	-0.00050	-0.00029	
OUT_DM		0.57339	0.57500	0.00100	-0.00100	-0.00161	
INN_DM		0.37454	0.37500			-0.00046	
X		0.00000					
Y		0.00002					
FEA(33)		PLA					
FORM		0.00005					
Z		-1.06010					

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEATURE(34)		AXI					
DZ		0.04970	0.05000	0.00050	-0.00050	-0.00030	
FEATURE(41)		CIR					
FORM		0.00027					
RA		0.01741	0.01600	0.00200	-0.00200	0.00141	
FEA_42(1)		AXI					
Y		-0.21144	0.20000	0.01000	-0.01000	0.01144	0.00144 ◀
FEA_42(2)		AXI					
Y		-0.18857	0.20000	0.01000	-0.01000	-0.01143	-0.00143 ◀
FEATURE(43)		CIR					
RA		0.12752	0.12500	0.00500	-0.00500	0.00252	
FEATURE(44)		CIR					
FORM		0.00012					
RA		1.24973	1.25000	0.01000	-0.01000	-0.00027	
FEATURE(45)		POI					
POSITN		0.00004	0.00000	0.00500	0.00000	0.00004	
FEATURE(46)		CIR					
FORM		0.00020					
RA		1.65015	1.65000	0.01000	-0.01000	0.00015	
FEATURE(47)		POI					
POSITN		0.00025	0.00000	0.00500	0.00000	0.00025	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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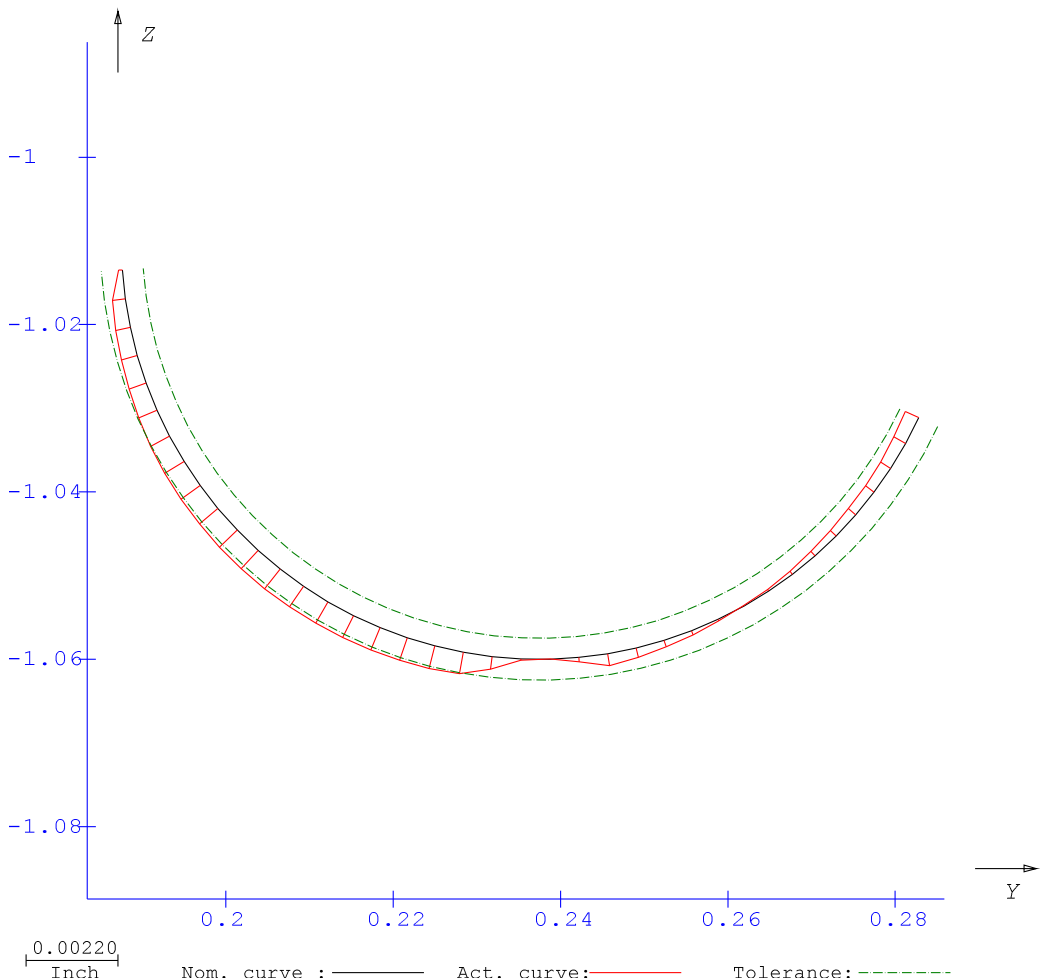
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

	X	Y	Z	Nr.		
Form	0.00099	Min. Deviat.:-0.00062	0.20928	0.00000	-1.05128	26
Lower Toler. :-	0.00050	Max. Deviat.: 0.00036	0.28282	0.00000	-1.03113	1
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 0°				
No. of points:	39					



2D - CONTOUR

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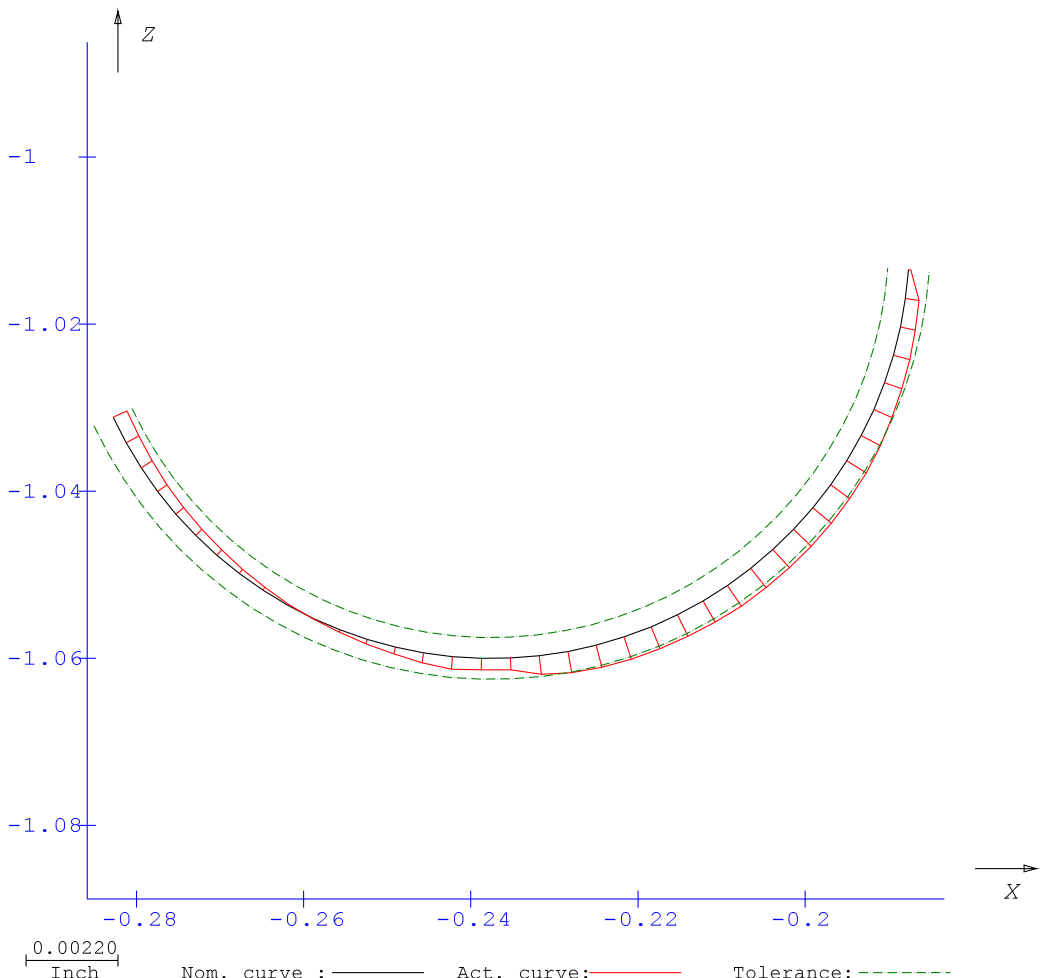
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

	X	Y	Z	Nr.
Form	0.00096	0.00000	-1.03113	1
Lower Toler. :-	-0.00050	0.00000	-1.04922	27
Upper Toler. : 0.00050	Profile of Radius 0.0500			
Error Magnif.:	5	@ 90°		
No. of points:	39			



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 Time:10:40:27



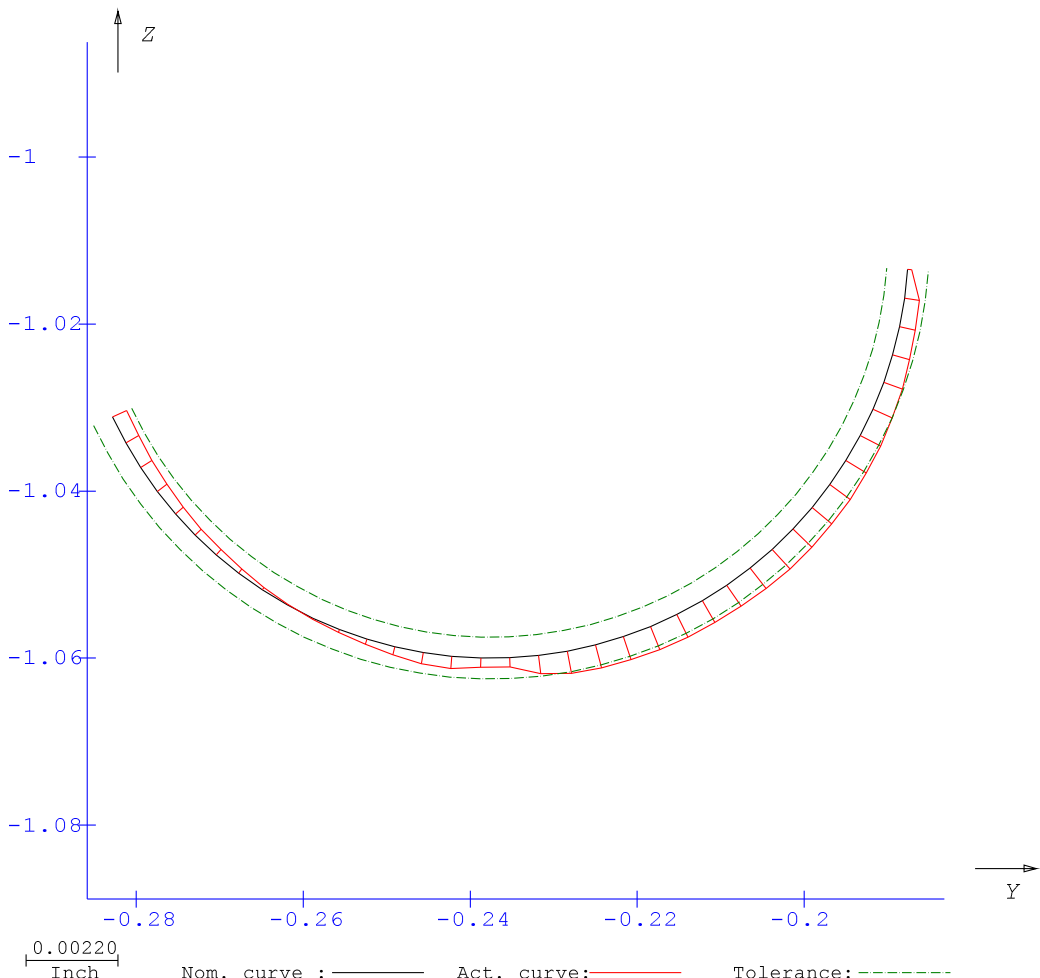
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.	
Form	0.00096	Min. Deviat.:-0.00037	-0.28282	0.00000	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00059	-0.20928	0.00000	-1.05128	26
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 180°				
No. of points:	39					



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Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

	X	Y	Z	Nr.		
Form	0.00101	Min. Deviat.:-0.00037	0.00000	-0.28282	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00064	0.00000	-0.20384	-1.04698	28
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 270°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban
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