

# Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	003
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, 11:50:12
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
<b>DATUM_A</b>		<b>PLA</b>					
	FLATNS	0.00038	0.00000	0.00100	0.00000	0.00038	
<b>DATUM_B</b>		<b>CYL</b>					
	DM	0.37524	0.37500	0.00050	-0.00050	0.00024	
<b>CYL_B</b>		<b>CYL</b>					
	CYLFRM	0.00005	0.00000	0.00050	0.00000	0.00005	
<b>SQR_B</b>		<b>AXI</b>					
	SQRNES	0.00002	0.00000	0.00100	0.00000	0.00002	
<b>FEATURE(1)</b>		<b>CIR</b>					
	DM	0.99736	0.99800	0.00000	-0.00100	-0.00064	
<b>FEATURE(2)</b>		<b>AXI</b>					
	RADRUN	0.00010	0.00000	0.00100	0.00000	0.00010	
<b>FEATURE(3)</b>		<b>PLA</b>					
	Z	0.24171	0.24400	0.00000	-0.00500	-0.00229	
<b>FEATURE(6)</b>		<b>CYL</b>					
	FORM	0.00023					
	DM	0.28111	0.28100	0.00500	-0.00500	0.00011	
	X	-0.00534	0.00000			0.00534	
	Y	0.89894	0.90000			-0.00106	
<b>POS_FEATURE(6)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01093	0.00000	0.03486	0.00000	0.01093	
<b>FEATURE(7)</b>		<b>CYL</b>					
	FORM	0.00040					
	DM	0.28128	0.28100	0.00500	-0.00500	0.00028	
	X	-0.64013	0.63630			0.00383	
	Y	0.63171	0.63630			-0.00459	
<b>POS_FEATURE(7)</b>		<b>AXI</b>					
	POSITN			0.03000			

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 19-Oct-09, 11:50:12		NO\$NAME				Page 1 of 10	

Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 2 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

<b>POS_FEATURE(7)</b>		<b>AXI</b>					
POSMMC	0.01209	0.00000	0.03487	0.00000	0.01209		

<b>FEATURE(8)</b>		<b>CYL</b>					
FORM	0.00026						
DM	0.28107	0.28100	0.00500	-0.00500	0.00007		
X	-0.90017	0.90000			0.00017		
Y	-0.00623	0.00000			0.00623		

<b>POS_FEATURE(8)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01256	0.00000	0.03478	0.00000	0.01256		

<b>FEATURE(9)</b>		<b>CYL</b>					
FORM	0.00035						
DM	0.28115	0.28100	0.00500	-0.00500	0.00015		
X	-0.63288	0.63630			-0.00342		
Y	-0.64110	0.63630			0.00480		

<b>POS_FEATURE(9)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01184	0.00000	0.03478	0.00000	0.01184		

<b>FEATURE(10)</b>		<b>CYL</b>					
FORM	0.00025						
DM	0.28109	0.28100	0.00500	-0.00500	0.00009		
X	0.00489	0.00000			0.00489		
Y	-0.90111	0.90000			0.00111		

<b>POS_FEATURE(10)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01005	0.00000	0.03483	0.00000	0.01005		

<b>FEATURE(11)</b>		<b>CYL</b>					
FORM	0.00038						
DM	0.28122	0.28100	0.00500	-0.00500	0.00022		
X	0.63983	0.63630			0.00353		
Y	-0.63384	0.63630			-0.00246		

<b>POS_FEATURE(11)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00866	0.00000	0.03483	0.00000	0.00866		

<b>FEATURE(12)</b>		<b>CYL</b>					
FORM	0.00026						
DM	0.28108	0.28100	0.00500	-0.00500	0.00008		
X	0.89980	0.90000			-0.00020		
Y	0.00405	0.00000			0.00405		

<b>POS_FEATURE(12)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00823	0.00000	0.03483	0.00000	0.00823		

<b>FEATURE(13)</b>		<b>CYL</b>					
FORM	0.00041						
DM	0.28122	0.28100	0.00500	-0.00500	0.00022		
X	0.63260	0.63630			-0.00370		
Y	0.63898	0.63630			0.00268		

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 2 of 10	

Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 3 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

<b>POS_FEATURE(13)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMC	0.00923	0.00000	0.03481	0.00000	0.00923	
<b>FEATURE(14)</b>		<b>CYL</b>					
	FORM	0.00026					
	DM	3.49993	3.50000	0.00500	-0.00500	-0.00007	
<b>FEATURE(15)</b>		<b>AXI</b>					
	RADRUN	0.00033	0.00000	0.00100	0.00000	0.00033	
<b>FEATURE(4)</b>		<b>AXI</b>					
	DZ	-0.09702	0.09700	0.00500	-0.00500	0.00002	
<b>FEATURE(5)</b>		<b>CIR</b>					
	FORM	0.00003					
	DM	0.87487	0.87500	0.00500	-0.00500	-0.00013	
<b>POS_FEA(5)</b>		<b>POI</b>					
	POSITN	0.00003	0.00000	0.00500	0.00000	0.00003	
<b>FEATURE(16)</b>		<b>CIR</b>					
	FORM	0.00002					
	DM	0.62619	0.62600	0.00500	-0.00500	0.00019	
<b>FEATURE(17)</b>		<b>AXI</b>					
	RADRUN	0.00012	0.00000	0.00100	0.00000	0.00012	
<b>FEATURE(18)</b>		<b>CON</b>					
	FORM	0.00003					
	CONANG_2	15.99713	16.00000			-0.00287	
	X	0.00000	0.00000			0.00000	
	Y	-0.00002	0.00000			0.00002	
<b>FEATURE(19)</b>		<b>POI</b>					
	Z	0.12142	0.12000	0.00500	-0.00500	0.00142	
<b>FEA_20(1)</b>		<b>AXI</b>					
	DY	-0.06087	0.06000	0.01000	-0.01000	0.00087	
<b>POS\$FEA_20(1)</b>		<b>AXI</b>					
	POSITN	0.00217	0.00000	0.01000	0.00000	0.00217	
<b>FEA_20(2)</b>		<b>AXI</b>					
	DX	0.06068	0.06000	0.01000	-0.01000	0.00068	
<b>POS\$FEA_20(2)</b>		<b>AXI</b>					
	POSITN	0.00067	0.00000	0.01000	0.00000	0.00067	
<b>FEA_20(3)</b>		<b>AXI</b>					
	DY	-0.06086	0.06000	0.01000	-0.01000	0.00086	
<b>POS\$FEA_20(3)</b>		<b>AXI</b>					
	POSITN	0.00198	0.00000	0.01000	0.00000	0.00198	
<b>FEA_20(4)</b>		<b>AXI</b>					
	DX	0.06063	0.06000	0.01000	-0.01000	0.00063	
<b>POS\$FEA_20(4)</b>		<b>AXI</b>					
	POSITN	0.00003	0.00000	0.01000	0.00000	0.00003	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 3 of 10	

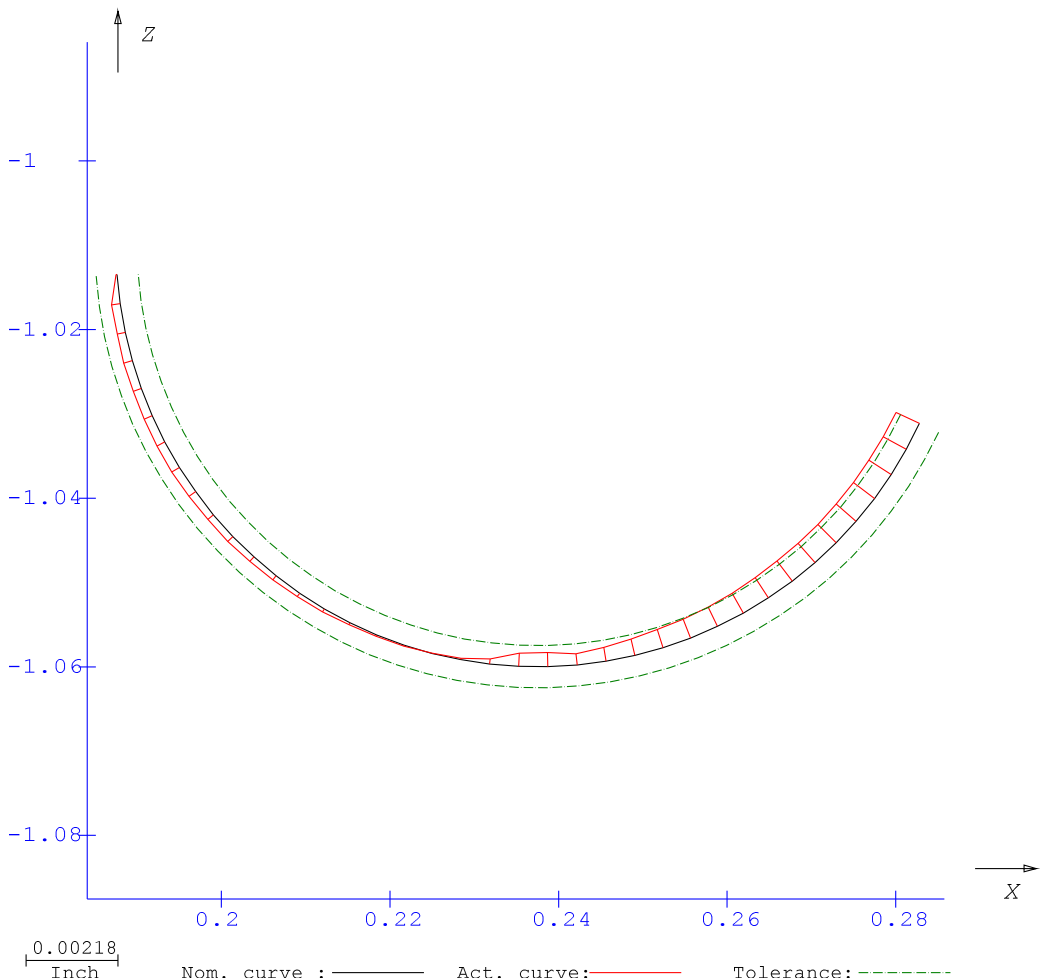
Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 4 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEAT_21(1)</b>			<b>AXI</b>				
DZ		0.05917	0.06000	0.00500	-0.00500	-0.00083	
<b>FEAT_21(2)</b>			<b>AXI</b>				
DZ		0.05899	0.06000	0.00500	-0.00500	-0.00101	
<b>FEAT_21(3)</b>			<b>AXI</b>				
DZ		0.05908	0.06000	0.00500	-0.00500	-0.00092	
<b>FEAT_21(4)</b>			<b>AXI</b>				
DZ		0.05909	0.06000	0.00500	-0.00500	-0.00091	
<b>DAT_B_OP</b>			<b>CYL</b>				
DM		0.37523					
FORM		0.00004					
<b>FEATURE(22)</b>			<b>PLA</b>				
FORM		0.00031					
Z		-0.56408					
<b>FEATURE(23)</b>			<b>PLA</b>				
PARALL		0.00043	0.00000	0.00100	0.00000	0.00043	
<b>FEA(24)</b>			<b>PLA</b>				
Z		-1.00982					
FORM		0.00003					
<b>FEATURE(24)</b>			<b>PLA</b>				
PARALL		0.00006	0.00000	0.00100	0.00000	0.00006	
<b>FEATURE(25)</b>			<b>AXI</b>				
DZ		-0.44574	0.44500	0.00100	0.00000	0.00074	
<b>FEATURE(26)</b>			<b>AXI</b>				
Z		-1.00982	1.01000	0.00200	0.00000	-0.00018	-0.00018
<b>FEAT_27(1)</b>			<b>AXI</b>				
DZ		-0.07938	0.08000	0.01000	-0.01000	-0.00062	
<b>FEAT_27(2)</b>			<b>AXI</b>				
DZ		-0.07746	0.08000	0.01000	-0.01000	-0.00254	
<b>FEATURE(28)</b>			<b>CIR</b>				
FORM		0.00027					
DM		2.25042	2.25000	0.01000	-0.01000	0.00042	
<b>FEAT(28)</b>			<b>AXI</b>				
RADRUN		0.00029	0.00000	0.00500	0.00000	0.00029	
<b>FEATURE(30)</b>			<b>CYL</b>				
FORM		0.00005					
DM		0.99733	0.99800	0.00000	-0.01000	-0.00067	
<b>FEATURE(31)</b>			<b>AXI</b>				
RADRUN		0.00011	0.00000	0.00100	0.00000	0.00011	
<b>FEA(36)</b>			<b>CYL</b>				
DM		0.28131	0.28100	0.00500	-0.00500	0.00031	
XY		1.49988	1.50000			-0.00012	
PP_PXPY		-0.19369	0.00000			0.19369	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 4 of 10	

Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 5 of 10	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>FEA(36)</b>		<b>CYL</b>					
DM		0.28131	0.28100	0.00500	-0.00500	0.00031	
XY		1.49988	1.50000			-0.00012	
PP_PXPY		-0.19366	0.00000			0.19366	
<b>FEA(37)</b>		<b>CYL</b>					
DM		0.28131	0.28100	0.00500	-0.00500	0.00031	
XY		1.49959	1.50000			-0.00041	
PP_PXPY		44.81827	45.00000			-0.18173	
<b>FEA(38)</b>		<b>CYL</b>					
DM		0.28121	0.28100	0.00500	-0.00500	0.00021	
XY		1.49918	1.50000			-0.00082	
PP_PXPY		89.83675	90.00000			-0.16325	
<b>FEA(39)</b>		<b>CYL</b>					
DM		0.28143	0.28100	0.00500	-0.00500	0.00043	
XY		1.49956	1.50000			-0.00044	
PP_PXPY		134.85770	135.00000			-0.14230	
<b>FEA(40)</b>		<b>CYL</b>					
DM		0.28128	0.28100	0.00500	-0.00500	0.00028	
XY		1.50004	1.50000			0.00004	
PP_PXPY		179.86866	180.00000			-0.13134	
<b>POS_FEATURE(36)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.01017	0.00000	0.03517	0.00000	0.01017	
<b>POS_FEATURE(37)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00970	0.00000	0.03499	0.00000	0.00970	
<b>POS_FEATURE(38)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00872	0.00000	0.03510	0.00000	0.00872	
<b>POS_FEATURE(39)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00757	0.00000	0.03523	0.00000	0.00757	
<b>POS_FEATURE(40)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00692	0.00000	0.03512	0.00000	0.00692	
<b>FEATURE(32)</b>		<b>AXI</b>					
RADRUN		0.00055	0.00000	0.00100	0.00000	0.00055	
<b>FEATURE(29)</b>		<b>TOR</b>					
FORM		0.00070					
Cir_RA		0.04973	0.05000	0.00050	-0.00050	-0.00027	
OUT_DM		0.57352	0.57500	0.00100	-0.00100	-0.00148	
INN_DM		0.37461	0.37500			-0.00039	
X		-0.00002					
Y		0.00001					
<b>FEA(33)</b>		<b>PLA</b>					
FORM		0.00014					
Z		-1.05943					

Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 6 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEATURE(34)</b>			<b>AXI</b>				
DZ		0.04961	0.05000	0.00050	-0.00050	-0.00039	
<b>FEATURE(41)</b>			<b>CIR</b>				
FORM		0.00006					
RA		0.01676	0.01600	0.00200	-0.00200	0.00076	
<b>FEA_42(1)</b>			<b>AXI</b>				
Y		-0.20479	0.20000	0.01000	-0.01000	0.00479	
<b>FEA_42(2)</b>			<b>AXI</b>				
Y		-0.19658	0.20000	0.01000	-0.01000	-0.00343	
<b>FEATURE(43)</b>			<b>CIR</b>				
RA		0.12792	0.12500	0.00500	-0.00500	0.00292	
<b>FEATURE(44)</b>			<b>CIR</b>				
FORM		0.00016					
RA		1.24970	1.25000	0.01000	-0.01000	-0.00030	
<b>FEATURE(45)</b>			<b>POI</b>				
POSITN		0.00123	0.00000	0.00500	0.00000	0.00123	
<b>FEATURE(46)</b>			<b>CIR</b>				
FORM		0.00019					
RA		1.65023	1.65000	0.01000	-0.01000	0.00023	
<b>FEATURE(47)</b>			<b>POI</b>				
POSITN		0.00147	0.00000	0.00500	0.00000	0.00147	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 19-Oct-09, 11:50:12			NO\$NAME			Page 6 of 10	



Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 003                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(1)

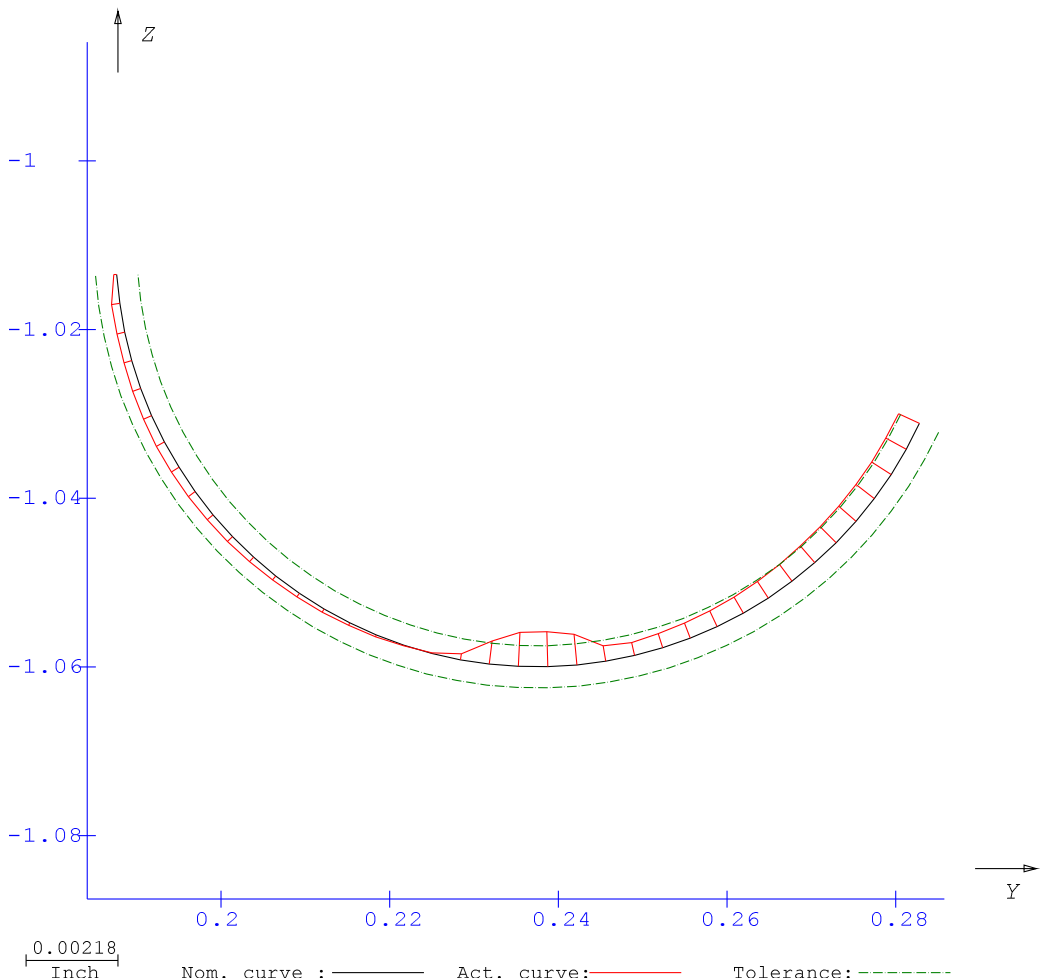
		X	Y	Z	Nr.
Form .....	0.00085	0.19500	0.00000	-1.03634	32
Lower Toler. :-	-0.00050	0.27946	0.00000	-1.03719	3
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00021      Profile of Radius 0.0500  
 Max. Deviat.: 0.00063      @ 0°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:19-OCT-2009  
 Time .....:11:50:12



Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 003      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(2)

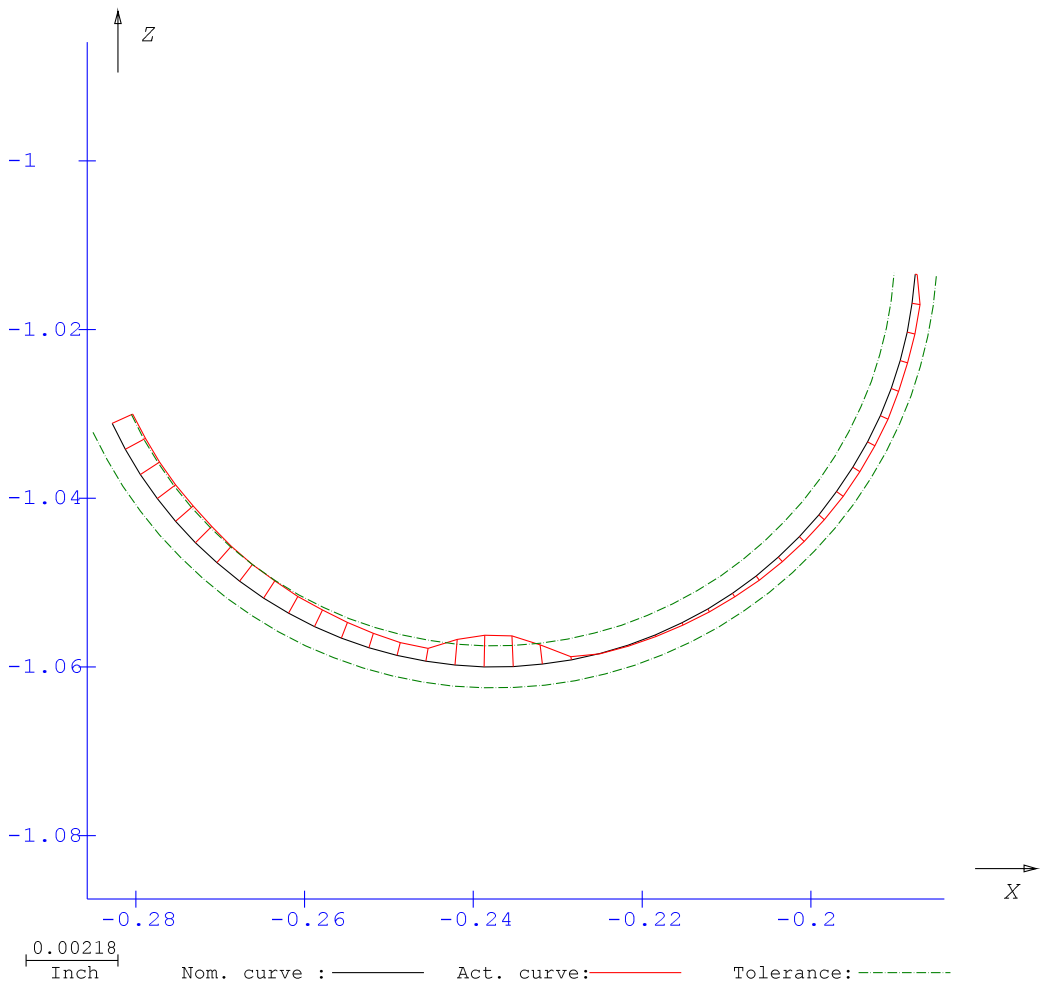
		X	Y	Z	Nr.	
Form .....	0.00105	Min. Deviat.:-0.00083	0.00000	0.23873	-1.05998	17
Lower Toler. :	-0.00050	Max. Deviat.: 0.00022	0.00000	0.19328	-1.03334	33
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 90°				
No. of points:	39					



2D - CONTOUR

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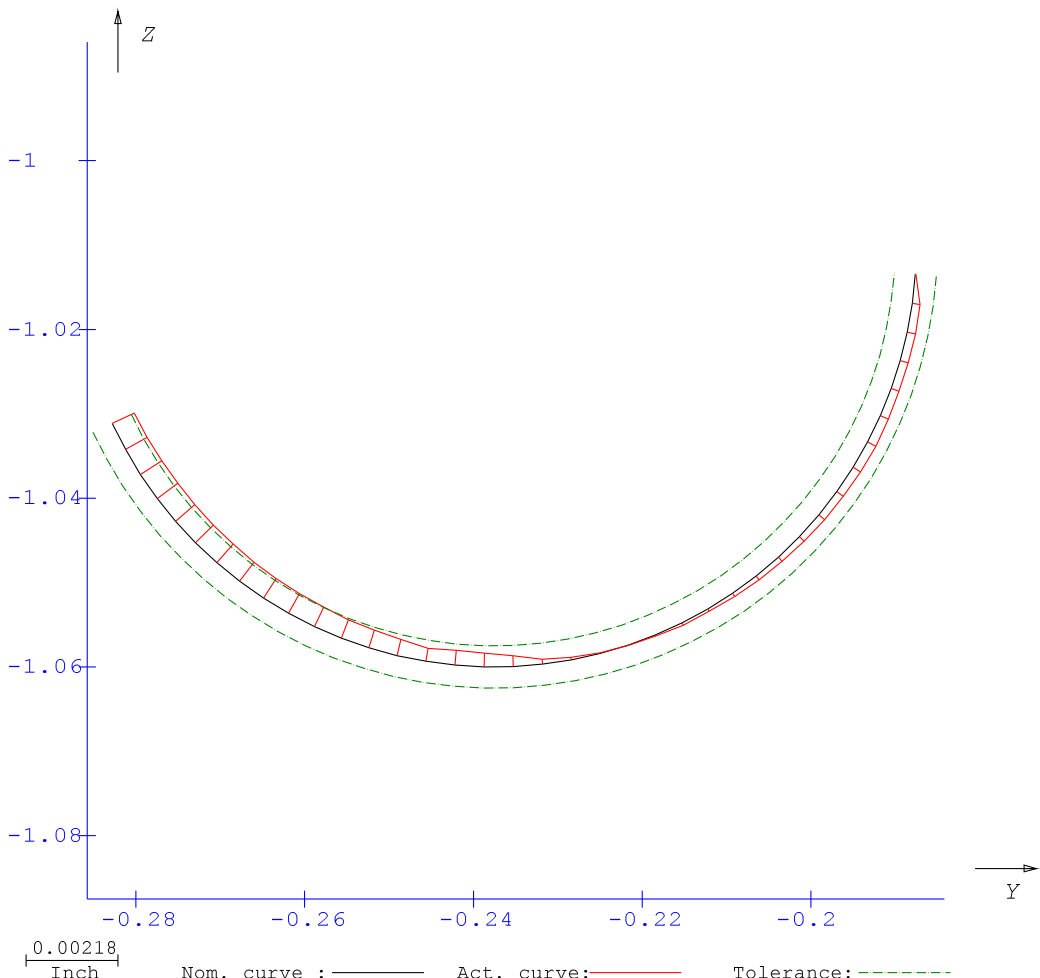
Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 003                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(3)

		X	Y	Z	Nr.	
Form .....	0.00095	Min. Deviat.: -0.00074	-0.23873	0.00000	-1.05998	17
Lower Toler. :	-0.00050	Max. Deviat.: 0.00020	-0.19177	0.00000	-1.03021	34
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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Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 003                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(4)

	X	Y	Z	Nr.
Form .....	0.00083	0.00000	-1.04004	4
Lower Toler. :	-0.00050	0.00000	-1.03334	33
Upper Toler. :	0.00050			
Error Magnif.:	5			
No. of points:	39			

Min. Deviat.: -0.00060      Profile of Radius 0.0500  
 Max. Deviat.: 0.00022      @ 270°



## 2D - CONTOUR

Inspector.:kcaban  
 Date .....:19-OCT-2009  
 Time .....:11:50:12