

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	004
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	718203	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	19-OCT-2009, 13:05:10
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	0.00042	0.00000	0.00100	0.00000	0.00042	
DATUM_B		CYL					
	DM	0.37507	0.37500	0.00050	-0.00050	0.00007	
CYL_B		CYL					
	CYLFRM	0.00005	0.00000	0.00050	0.00000	0.00005	
SQR_B		AXI					
	SQRNES	0.00003	0.00000	0.00100	0.00000	0.00003	
FEATURE(1)		CIR					
	DM	0.99708	0.99800	0.00000	-0.00100	-0.00092	
FEATURE(2)		AXI					
	RADRUN	0.00004	0.00000	0.00100	0.00000	0.00004	
FEATURE(3)		PLA					
	Z	0.24167	0.24400	0.00000	-0.00500	-0.00233	
FEATURE(6)		CYL					
	FORM	0.00031					
	DM	0.28113	0.28100	0.00500	-0.00500	0.00013	
	X	-0.00532	0.00000			0.00532	
	Y	0.89952	0.90000			-0.00048	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01070	0.00000	0.03480	0.00000	0.01070	
FEATURE(7)		CYL					
	FORM	0.00038					
	DM	0.28118	0.28100	0.00500	-0.00500	0.00018	
	X	-0.64007	0.63630			0.00377	
	Y	0.63212	0.63630			-0.00418	
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	0.01133	0.00000	0.03477	0.00000	0.01133		

FEATURE(8)		CYL					
FORM	0.00038						
DM	0.28112	0.28100	0.00500	-0.00500	0.00012		
X	-0.89999	0.90000			-0.00001		
Y	-0.00579	0.00000			0.00579		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01161	0.00000	0.03471	0.00000	0.01161		

FEATURE(9)		CYL					
FORM	0.00030						
DM	0.28114	0.28100	0.00500	-0.00500	0.00014		
X	-0.63276	0.63630			-0.00354		
Y	-0.64065	0.63630			0.00435		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01122	0.00000	0.03488	0.00000	0.01122		

FEATURE(10)		CYL					
FORM	0.00024						
DM	0.28110	0.28100	0.00500	-0.00500	0.00010		
X	0.00508	0.00000			0.00508		
Y	-0.90064	0.90000			0.00064		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.01032	0.00000	0.03485	0.00000	0.01032		

FEATURE(11)		CYL					
FORM	0.00043						
DM	0.28114	0.28100	0.00500	-0.00500	0.00014		
X	0.63995	0.63630			0.00365		
Y	-0.63324	0.63630			-0.00306		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.00962	0.00000	0.03470	0.00000	0.00962		

FEATURE(12)		CYL					
FORM	0.00028						
DM	0.28112	0.28100	0.00500	-0.00500	0.00012		
X	0.89990	0.90000			-0.00010		
Y	0.00463	0.00000			0.00463		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00937	0.00000	0.03486	0.00000	0.00937		

FEATURE(13)		CYL					
FORM	0.00043						
DM	0.28114	0.28100	0.00500	-0.00500	0.00014		
X	0.63263	0.63630			-0.00367		
Y	0.63953	0.63630			0.00323		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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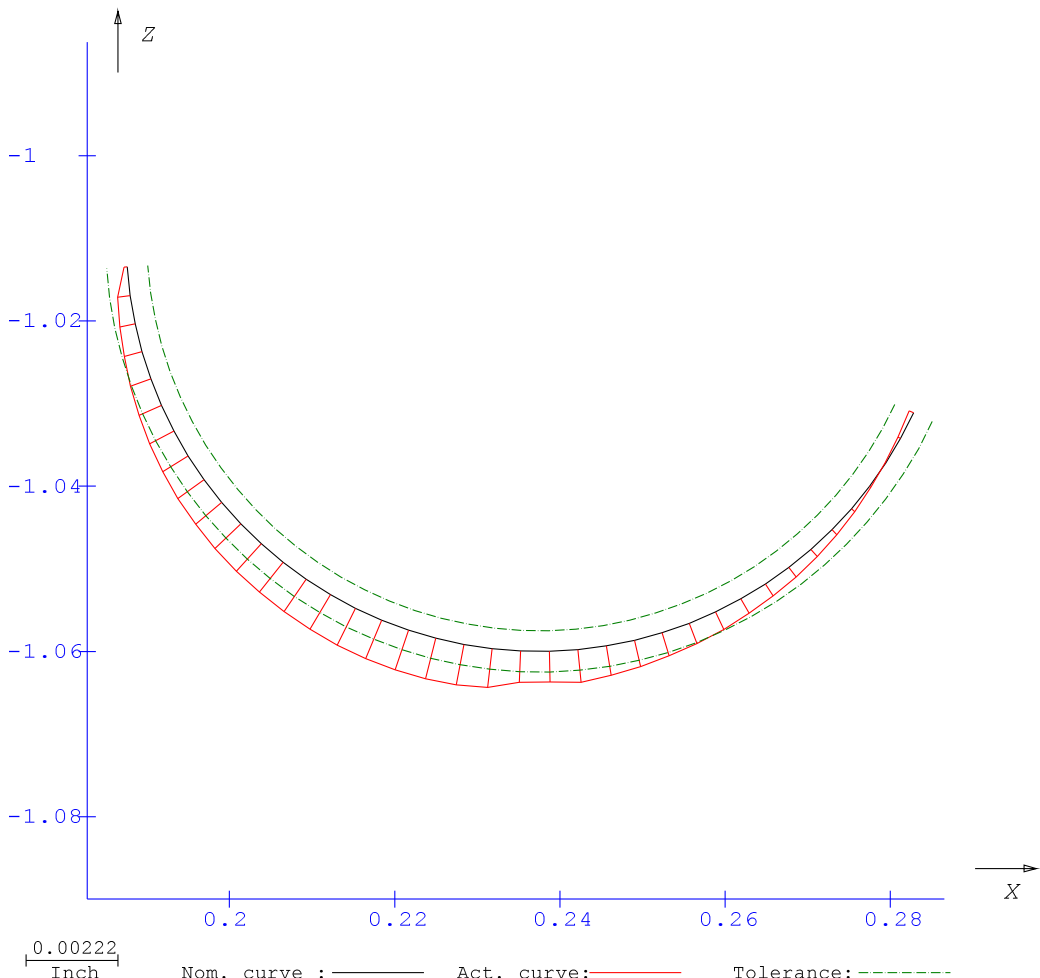
Date: 19-Oct-09, 13:05:11			NO\$NAME			Page 3 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
POS_FEATURE(13)		AXI					
	POSITN			0.03000			
	POSMMC	0.00986	0.00000	0.03468	0.00000	0.00986	
FEATURE(14)		CYL					
	FORM	0.00026					
	DM	3.49966	3.50000	0.00500	-0.00500	-0.00034	
FEATURE(15)		AXI					
	RADRUN	0.00028	0.00000	0.00100	0.00000	0.00028	
FEATURE(4)		AXI					
	DZ	-0.09701	0.09700	0.00500	-0.00500	0.00001	
FEATURE(5)		CIR					
	FORM	0.00003					
	DM	0.87460	0.87500	0.00500	-0.00500	-0.00040	
POS_FEA(5)		POI					
	POSITN	0.00004	0.00000	0.00500	0.00000	0.00004	
FEATURE(16)		CIR					
	FORM	0.00005					
	DM	0.62583	0.62600	0.00500	-0.00500	-0.00017	
FEATURE(17)		AXI					
	RADRUN	0.00011	0.00000	0.00100	0.00000	0.00011	
FEATURE(18)		CON					
	FORM	0.00004					
	CONANG_2	15.99372	16.00000			-0.00628	
	X	0.00002	0.00000			0.00002	
	Y	-0.00007	0.00000			0.00007	
FEATURE(19)		POI					
	Z	0.12234	0.12000	0.00500	-0.00500	0.00234	
FEA_20(1)		AXI					
	DY	-0.06099	0.06000	0.01000	-0.01000	0.00099	
POS\$FEA_20(1)		AXI					
	POSITN	0.00245	0.00000	0.01000	0.00000	0.00245	
FEA_20(2)		AXI					
	DX	0.06065	0.06000	0.01000	-0.01000	0.00065	
POS\$FEA_20(2)		AXI					
	POSITN	0.00032	0.00000	0.01000	0.00000	0.00032	
FEA_20(3)		AXI					
	DY	-0.06090	0.06000	0.01000	-0.01000	0.00090	
POS\$FEA_20(3)		AXI					
	POSITN	0.00171	0.00000	0.01000	0.00000	0.00171	
FEA_20(4)		AXI					
	DX	0.06069	0.06000	0.01000	-0.01000	0.00069	
POS\$FEA_20(4)		AXI					
	POSITN	0.00077	0.00000	0.01000	0.00000	0.00077	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEAT_21(1)			AXI				
	DZ	0.06029	0.06000	0.00500	-0.00500	0.00029	
FEAT_21(2)			AXI				
	DZ	0.06020	0.06000	0.00500	-0.00500	0.00020	
FEAT_21(3)			AXI				
	DZ	0.06026	0.06000	0.00500	-0.00500	0.00026	
FEAT_21(4)			AXI				
	DZ	0.06023	0.06000	0.00500	-0.00500	0.00023	
DAT_B_OP			CYL				
	DM	0.37508					
	FORM	0.00006					
FEATURE(22)			PLA				
	FORM	0.00035					
	Z	-0.56510					
FEATURE(23)			PLA				
	PARALL	0.00040	0.00000	0.00100	0.00000	0.00040	
FEA(24)			PLA				
	Z	-1.01086					
	FORM	0.00003					
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	-1.01086	1.01000	0.00200	0.00000	0.00086	
FEAT_27(1)			AXI				
	DZ	-0.07937	0.08000	0.01000	-0.01000	-0.00063	
FEAT_27(2)			AXI				
	DZ	-0.07820	0.08000	0.01000	-0.01000	-0.00180	
FEATURE(28)			CIR				
	FORM	0.00008					
	DM	2.25058	2.25000	0.01000	-0.01000	0.00058	
FEAT(28)			AXI				
	RADRUN	0.00019	0.00000	0.00500	0.00000	0.00019	
FEATURE(30)			CYL				
	FORM	0.00026					
	DM	0.99738	0.99800	0.00000	-0.01000	-0.00062	
FEATURE(31)			AXI				
	RADRUN	0.00028	0.00000	0.00100	0.00000	0.00028	
FEA(36)			CYL				
	DM	0.28130	0.28100	0.00500	-0.00500	0.00030	
	XY	1.49986	1.50000			-0.00014	
	PP_PXPY	-0.37369	0.00000			0.37369	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEA(36)		CYL					
DM		0.28131	0.28100	0.00500	-0.00500	0.00031	
XY		1.49986	1.50000			-0.00014	
PP_PXPY		-0.37376	0.00000			0.37376	
FEA(37)		CYL					
DM		0.28124	0.28100	0.00500	-0.00500	0.00024	
XY		1.49952	1.50000			-0.00048	
PP_PXPY		44.63743	45.00000			-0.36257	
FEA(38)		CYL					
DM		0.28122	0.28100	0.00500	-0.00500	0.00022	
XY		1.49912	1.50000			-0.00088	
PP_PXPY		89.66164	90.00000			-0.33836	
FEA(39)		CYL					
DM		0.28128	0.28100	0.00500	-0.00500	0.00028	
XY		1.49945	1.50000			-0.00055	
PP_PXPY		134.68171	135.00000			-0.31829	
FEA(40)		CYL					
DM		0.28126	0.28100	0.00500	-0.00500	0.00026	
XY		1.49998	1.50000			-0.00002	
PP_PXPY		179.69473	180.00000			-0.30527	
POS_FEATURE(36)		AXI					
POSITN				0.03000			
POSMC		0.01959	0.00000	0.03517	0.00000	0.01959	
POS_FEATURE(37)		AXI					
POSITN				0.03000			
POSMC		0.01903	0.00000	0.03494	0.00000	0.01903	
POS_FEATURE(38)		AXI					
POSITN				0.03000			
POSMC		0.01783	0.00000	0.03510	0.00000	0.01783	
POS_FEATURE(39)		AXI					
POSITN				0.03000			
POSMC		0.01679	0.00000	0.03512	0.00000	0.01679	
POS_FEATURE(40)		AXI					
POSITN				0.03000			
POSMC		0.01601	0.00000	0.03519	0.00000	0.01601	
FEATURE(32)		AXI					
RADRUN		0.00024	0.00000	0.00100	0.00000	0.00024	
FEATURE(29)		TOR					
FORM		0.00056					
Cir_RA		0.04972	0.05000	0.00050	-0.00050	-0.00028	
OUT_DM		0.57348	0.57500	0.00100	-0.00100	-0.00152	
INN_DM		0.37462	0.37500			-0.00038	
X		0.00003					
Y		-0.00005					
FEA(33)		PLA					
FORM		0.00005					
Z		-1.06055					

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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		0.00018					
RA		0.01659	0.01600	0.00200	-0.00200	0.00059	
FEA_42(1)			AXI				
Y		-0.20921	0.20000	0.01000	-0.01000	0.00921	
FEA_42(2)			AXI				
Y		-0.19211	0.20000	0.01000	-0.01000	-0.00789	
FEATURE(43)			CIR				
RA		0.12855	0.12500	0.00500	-0.00500	0.00355	
FEATURE(44)			CIR				
FORM		0.00011					
RA		1.24974	1.25000	0.01000	-0.01000	-0.00026	
FEATURE(45)			POI				
POSITN		0.00140	0.00000	0.00500	0.00000	0.00140	
FEATURE(46)			CIR				
FORM		0.00018					
RA		1.65017	1.65000	0.01000	-0.01000	0.00017	
FEATURE(47)			POI				
POSITN		0.00147	0.00000	0.00500	0.00000	0.00147	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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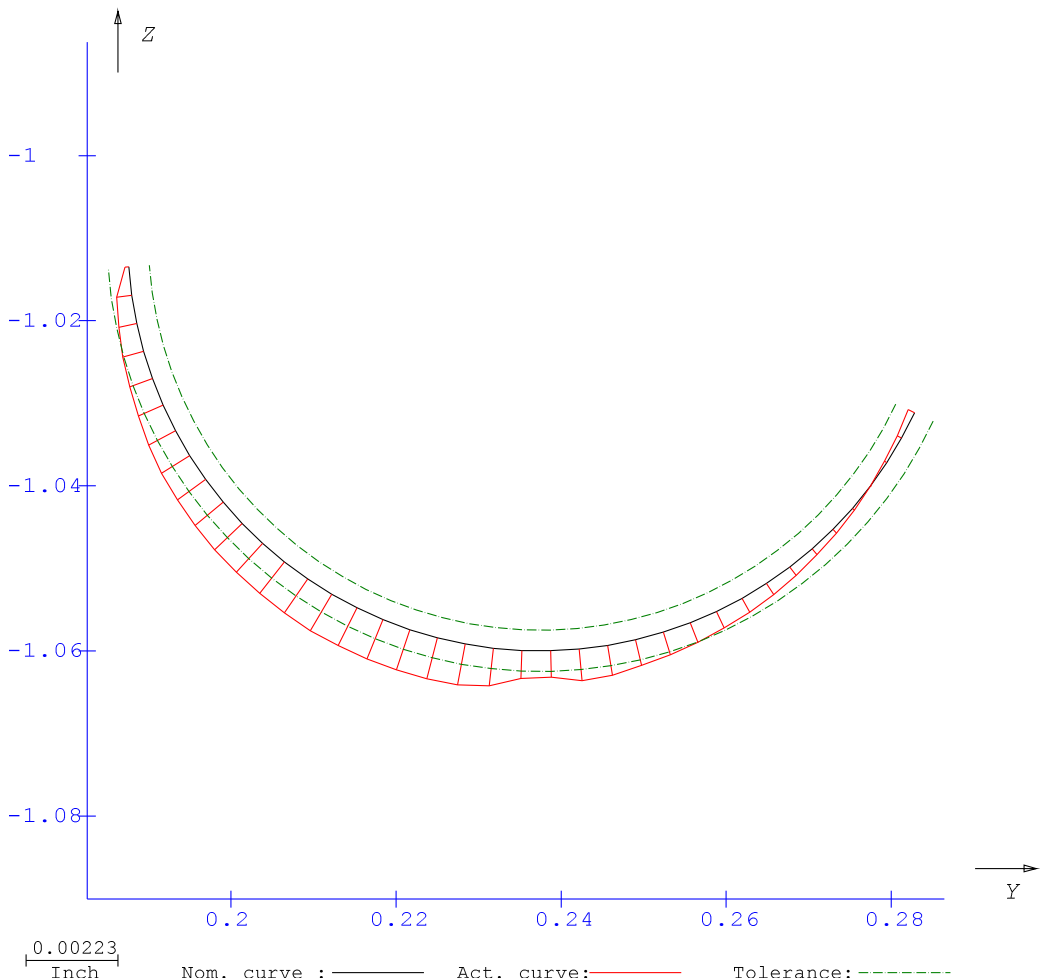
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 004 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

		X	Y	Z	Nr.
Form	0.00113	0.22167	0.00000	-1.05743	22
Lower Toler. :	-0.00050	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

Inspector.:kcaban
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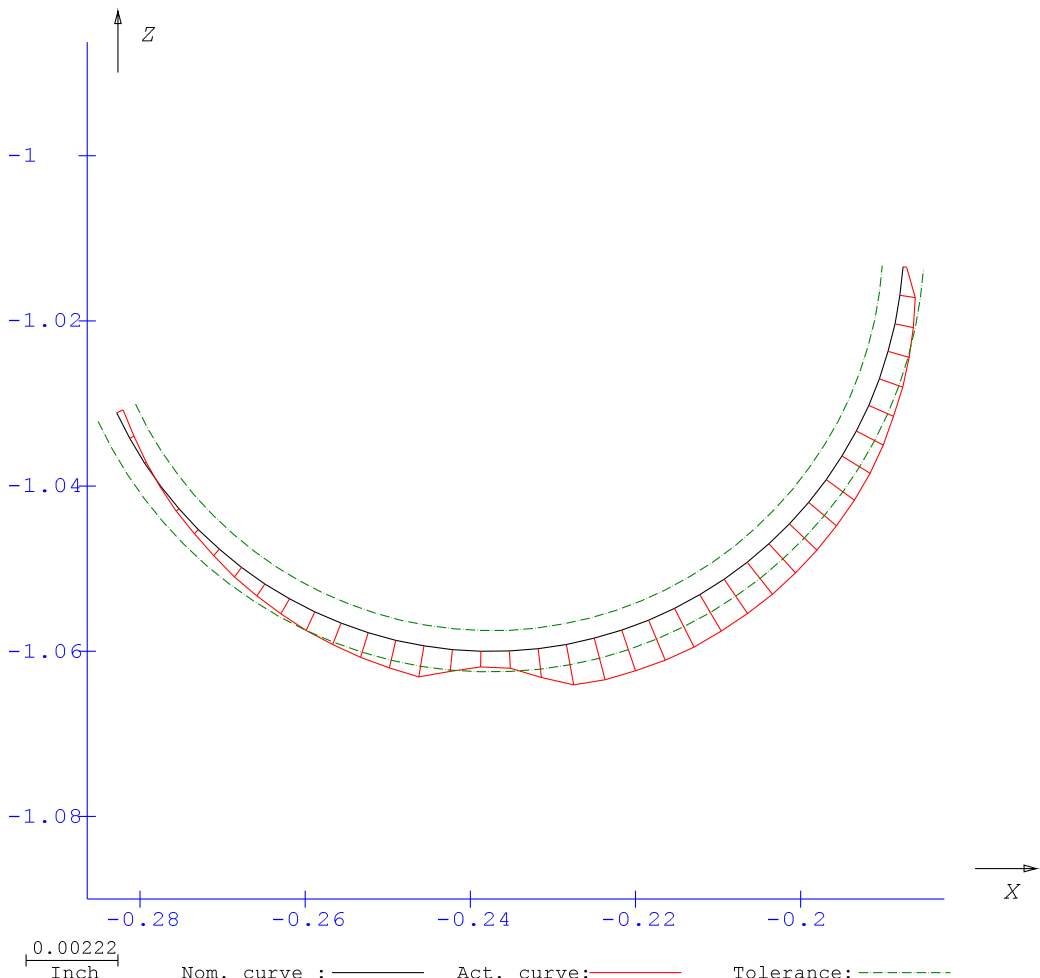
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 004 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

	X	Y	Z	Nr.		
Form	0.00120	Min. Deviat.: -0.00017	0.00000	0.28282	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00103	0.00000	0.22167	-1.05743	22
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 90°				
No. of points:	39					



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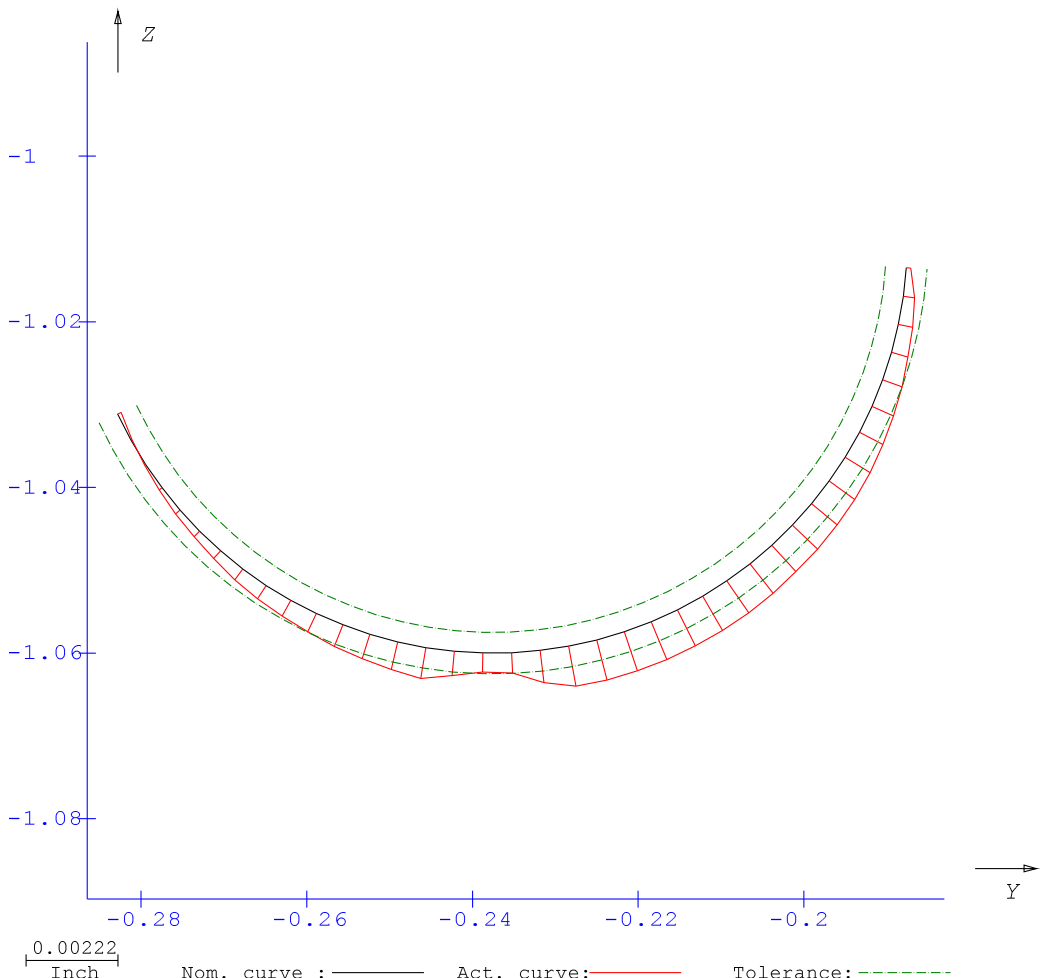
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 004 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

	X	Y	Z	Nr.		
Form	0.00122	Min. Deviat.:-0.00017	-0.28282	0.00000	-1.03113	1
Lower Toler. :-	0.00050	Max. Deviat.: 0.00105	-0.21842	0.00000	-1.05622	23
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. : 004 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.
Form	0.00109	0.00000	-0.28282	-1.03113	1
Lower Toler. :	-0.00050	0.00000	-0.22499	-1.05841	21
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00009 Profile of Radius 0.0500
 Max. Deviat.: 0.00100 @ 270°



2D - CONTOUR

Inspector.:kcaban
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