

# Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	005
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, 14:29:12
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	0.00046	0.00000	0.00100	0.00000	0.00046	
<b>DATUM_B</b>		<b>CYL</b>					
	DM	0.37515	0.37500	0.00050	-0.00050	0.00015	
<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	0.99709	0.99800	0.00000	-0.00100	-0.00091	
<b>FEATURE(2)</b>		<b>AXI</b>					
	RADRUN	0.00009	0.00000	0.00100	0.00000	0.00009	
<b>FEATURE(3)</b>		<b>PLA</b>					
	Z	0.24165	0.24400	0.00000	-0.00500	-0.00235	
<b>FEATURE(6)</b>		<b>CYL</b>					
	FORM	0.00025					
	DM	0.28115	0.28100	0.00500	-0.00500	0.00015	
	X	-0.00556	0.00000			0.00556	
	Y	0.89913	0.90000			-0.00087	
<b>POS_FEATURE(6)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01128	0.00000	0.03490	0.00000	0.01128	
<b>FEATURE(7)</b>		<b>CYL</b>					
	FORM	0.00039					
	DM	0.28131	0.28100	0.00500	-0.00500	0.00031	
	X	-0.64032	0.63630			0.00402	
	Y	0.63180	0.63630			-0.00450	
<b>POS_FEATURE(7)</b>		<b>AXI</b>					
	POSITN			0.03000			

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Date: 19-Oct-09, 14:29:13			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	0.01212	0.00000	0.03492	0.00000	0.01212		

<b>FEATURE(8)</b>		<b>CYL</b>					
FORM	0.00037						
DM	0.28110	0.28100	0.00500	-0.00500	0.00010		
X	-0.90026	0.90000			0.00026		
Y	-0.00612	0.00000			0.00612		

<b>POS_FEATURE(8)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01237	0.00000	0.03477	0.00000	0.01237		

<b>FEATURE(9)</b>		<b>CYL</b>					
FORM	0.00038						
DM	0.28121	0.28100	0.00500	-0.00500	0.00021		
X	-0.63293	0.63630			-0.00337		
Y	-0.64100	0.63630			0.00470		

<b>POS_FEATURE(9)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01158	0.00000	0.03482	0.00000	0.01158		

<b>FEATURE(10)</b>		<b>CYL</b>					
FORM	0.00024						
DM	0.28113	0.28100	0.00500	-0.00500	0.00013		
X	0.00490	0.00000			0.00490		
Y	-0.90087	0.90000			0.00087		

<b>POS_FEATURE(10)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00998	0.00000	0.03488	0.00000	0.00998		

<b>FEATURE(11)</b>		<b>CYL</b>					
FORM	0.00039						
DM	0.28130	0.28100	0.00500	-0.00500	0.00030		
X	0.63979	0.63630			0.00349		
Y	-0.63354	0.63630			-0.00276		

<b>POS_FEATURE(11)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00894	0.00000	0.03490	0.00000	0.00894		

<b>FEATURE(12)</b>		<b>CYL</b>					
FORM	0.00021						
DM	0.28120	0.28100	0.00500	-0.00500	0.00020		
X	0.89968	0.90000			-0.00032		
Y	0.00435	0.00000			0.00435		

<b>POS_FEATURE(12)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00876	0.00000	0.03500	0.00000	0.00876		

<b>FEATURE(13)</b>		<b>CYL</b>					
FORM	0.00041						
DM	0.28133	0.28100	0.00500	-0.00500	0.00033		
X	0.63241	0.63630			-0.00389		
Y	0.63925	0.63630			0.00295		

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>POS_FEATURE(13)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMC	0.00978	0.00000	0.03491	0.00000	0.00978	
<b>FEATURE(14)</b>		<b>CYL</b>					
	FORM	0.00029					
	DM	3.49968	3.50000	0.00500	-0.00500	-0.00032	
<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	0.87461	0.87500	0.00500	-0.00500	-0.00039	
<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	0.00005					
	DM	0.62587	0.62600	0.00500	-0.00500	-0.00013	
<b>FEATURE(17)</b>		<b>AXI</b>					
	RADRUN	0.00008	0.00000	0.00100	0.00000	0.00008	
<b>FEATURE(18)</b>		<b>CON</b>					
	FORM	0.00005					
	CONANG_2	15.98956	16.00000			-0.01044	
	X	-0.00001	0.00000			0.00001	
	Y	-0.00001	0.00000			0.00001	
<b>FEATURE(19)</b>		<b>POI</b>					
	Z	0.12195	0.12000	0.00500	-0.00500	0.00195	
<b>FEA_20(1)</b>		<b>AXI</b>					
	DY	-0.06091	0.06000	0.01000	-0.01000	0.00091	
<b>POS\$FEA_20(1)</b>		<b>AXI</b>					
	POSITN	0.00130	0.00000	0.01000	0.00000	0.00130	
<b>FEA_20(2)</b>		<b>AXI</b>					
	DX	0.06070	0.06000	0.01000	-0.01000	0.00070	
<b>POS\$FEA_20(2)</b>		<b>AXI</b>					
	POSITN	0.00059	0.00000	0.01000	0.00000	0.00059	
<b>FEA_20(3)</b>		<b>AXI</b>					
	DY	-0.06090	0.06000	0.01000	-0.01000	0.00090	
<b>POS\$FEA_20(3)</b>		<b>AXI</b>					
	POSITN	0.00150	0.00000	0.01000	0.00000	0.00150	
<b>FEA_20(4)</b>		<b>AXI</b>					
	DX	0.06059	0.06000	0.01000	-0.01000	0.00059	
<b>POS\$FEA_20(4)</b>		<b>AXI</b>					
	POSITN	0.00107	0.00000	0.01000	0.00000	0.00107	

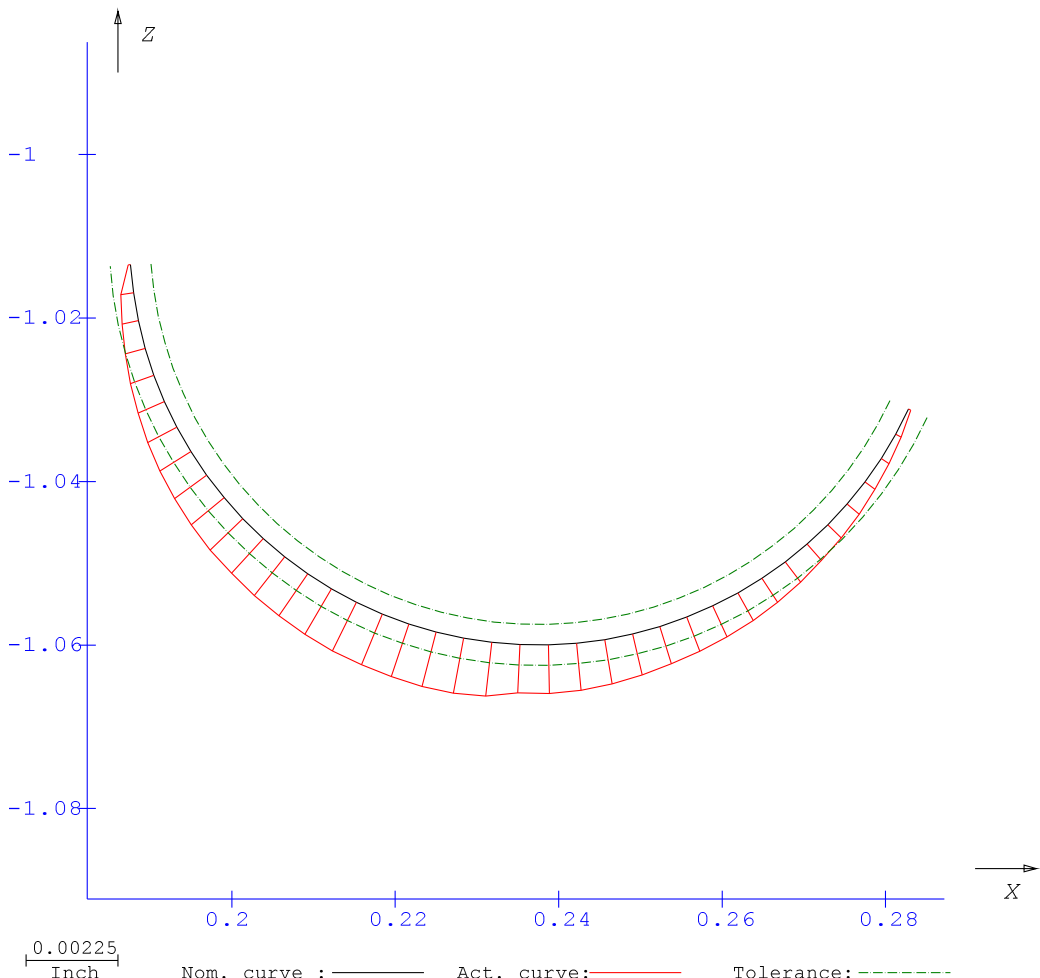
Date: 19-Oct-09, 14:29:13			NO\$NAME			Page 4 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEAT_21(1)</b>			<b>AXI</b>				
DZ		0.06097	0.06000	0.00500	-0.00500	0.00097	
<b>FEAT_21(2)</b>			<b>AXI</b>				
DZ		0.06093	0.06000	0.00500	-0.00500	0.00093	
<b>FEAT_21(3)</b>			<b>AXI</b>				
DZ		0.06073	0.06000	0.00500	-0.00500	0.00073	
<b>FEAT_21(4)</b>			<b>AXI</b>				
DZ		0.06069	0.06000	0.00500	-0.00500	0.00069	
<b>DAT_B_OP</b>			<b>CYL</b>				
DM		0.37516					
FORM		0.00007					
<b>FEATURE(22)</b>			<b>PLA</b>				
FORM		0.00028					
Z		-0.56552					
<b>FEATURE(23)</b>			<b>PLA</b>				
PARALL		0.00037	0.00000	0.00100	0.00000	0.00037	
<b>FEA(24)</b>			<b>PLA</b>				
Z		-1.01127					
FORM		0.00003					
<b>FEATURE(24)</b>			<b>PLA</b>				
PARALL		0.00005	0.00000	0.00100	0.00000	0.00005	
<b>FEATURE(25)</b>			<b>AXI</b>				
DZ		-0.44575	0.44500	0.00100	0.00000	0.00075	
<b>FEATURE(26)</b>			<b>AXI</b>				
Z		-1.01127	1.01000	0.00200	0.00000	0.00127	
<b>FEAT_27(1)</b>			<b>AXI</b>				
DZ		-0.07939	0.08000	0.01000	-0.01000	-0.00061	
<b>FEAT_27(2)</b>			<b>AXI</b>				
DZ		-0.07687	0.08000	0.01000	-0.01000	-0.00313	
<b>FEATURE(28)</b>			<b>CIR</b>				
FORM		0.00010					
DM		2.25064	2.25000	0.01000	-0.01000	0.00064	
<b>FEAT(28)</b>			<b>AXI</b>				
RADRUN		0.00010	0.00000	0.00500	0.00000	0.00010	
<b>FEATURE(30)</b>			<b>CYL</b>				
FORM		0.00004					
DM		0.99736	0.99800	0.00000	-0.01000	-0.00064	
<b>FEATURE(31)</b>			<b>AXI</b>				
RADRUN		0.00008	0.00000	0.00100	0.00000	0.00008	
<b>FEA(36)</b>			<b>CYL</b>				
DM		0.28141	0.28100	0.00500	-0.00500	0.00041	
XY		1.49983	1.50000			-0.00017	
PP_PXPY		-0.18544	0.00000			0.18544	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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Date: 19-Oct-09, 14:29:13			NO\$NAME			Page 5 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEA(36)</b>		<b>CYL</b>					
DM		0.28141	0.28100	0.00500	-0.00500	0.00041	
XY		1.49983	1.50000			-0.00017	
PP_PXPY		-0.18543	0.00000			0.18543	
<b>FEA(37)</b>		<b>CYL</b>					
DM		0.28145	0.28100	0.00500	-0.00500	0.00045	
XY		1.49966	1.50000			-0.00034	
PP_PXPY		44.82452	45.00000			-0.17548	
<b>FEA(38)</b>		<b>CYL</b>					
DM		0.28124	0.28100	0.00500	-0.00500	0.00024	
XY		1.49935	1.50000			-0.00065	
PP_PXPY		89.84132	90.00000			-0.15868	
<b>FEA(39)</b>		<b>CYL</b>					
DM		0.28142	0.28100	0.00500	-0.00500	0.00042	
XY		1.49967	1.50000			-0.00033	
PP_PXPY		134.85597	135.00000			-0.14403	
<b>FEA(40)</b>		<b>CYL</b>					
DM		0.28122	0.28100	0.00500	-0.00500	0.00022	
XY		1.49990	1.50000			-0.00010	
PP_PXPY		179.86604	180.00000			-0.13396	
<b>POS_FEATURE(36)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00975	0.00000	0.03531	0.00000	0.00975	
<b>POS_FEATURE(37)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00923	0.00000	0.03523	0.00000	0.00923	
<b>POS_FEATURE(38)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00846	0.00000	0.03505	0.00000	0.00846	
<b>POS_FEATURE(39)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00763	0.00000	0.03522	0.00000	0.00763	
<b>POS_FEATURE(40)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00704	0.00000	0.03497	0.00000	0.00704	
<b>FEATURE(32)</b>		<b>AXI</b>					
RADRUN		0.00005	0.00000	0.00100	0.00000	0.00005	
<b>FEATURE(29)</b>		<b>TOR</b>					
FORM		0.00076					
Cir_RA		0.04974	0.05000	0.00050	-0.00050	-0.00026	
OUT_DM		0.57365	0.57500	0.00100	-0.00100	-0.00135	
INN_DM		0.37467	0.37500			-0.00033	
X		0.00001					
Y		0.00003					
<b>FEA(33)</b>		<b>PLA</b>					
FORM		0.00023					
Z		-1.06093					

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEATURE(34)</b>		<b>AXI</b>					
DZ		0.04966	0.05000	0.00050	-0.00050	-0.00034	
<b>FEATURE(41)</b>		<b>CIR</b>					
FORM		0.00015					
RA		0.01690	0.01600	0.00200	-0.00200	0.00090	
<b>FEA_42(1)</b>		<b>AXI</b>					
Y		-0.20449	0.20000	0.01000	-0.01000	0.00449	
<b>FEA_42(2)</b>		<b>AXI</b>					
Y		-0.19643	0.20000	0.01000	-0.01000	-0.00357	
<b>FEATURE(43)</b>		<b>CIR</b>					
RA		0.12757	0.12500	0.00500	-0.00500	0.00257	
<b>FEATURE(44)</b>		<b>CIR</b>					
FORM		0.00015					
RA		1.24968	1.25000	0.01000	-0.01000	-0.00032	
<b>FEATURE(45)</b>		<b>POI</b>					
POSITN		0.00087	0.00000	0.00500	0.00000	0.00087	
<b>FEATURE(46)</b>		<b>CIR</b>					
FORM		0.00018					
RA		1.65018	1.65000	0.01000	-0.01000	0.00018	
<b>FEATURE(47)</b>		<b>POI</b>					
POSITN		0.00095	0.00000	0.00500	0.00000	0.00095	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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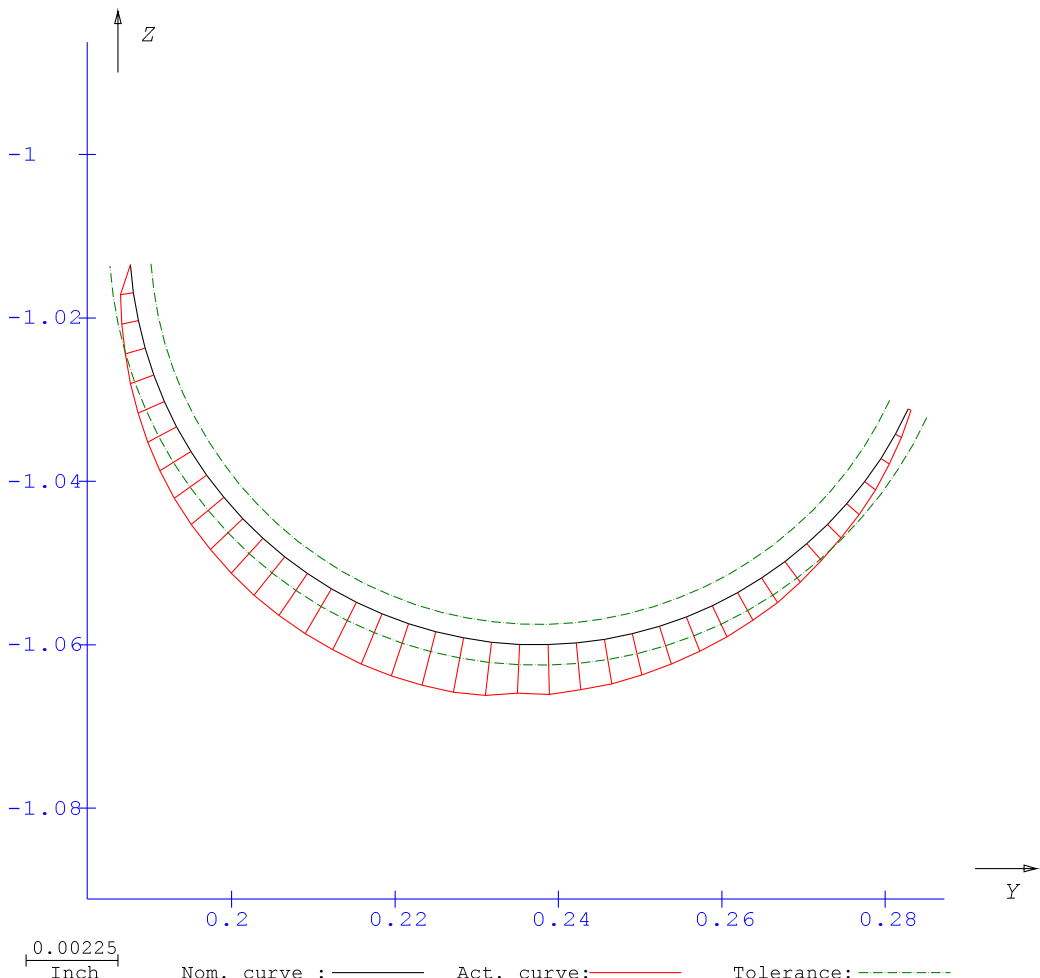
Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 005      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(1)

	X	Y	Z	Nr.		
Form .....	0.00132	Min. Deviat.:-0.00138	0.22499	0.00000	-1.05841	21
Lower Toler. :	-0.00050	Max. Deviat.:-0.00006	0.18762	0.00000	-1.01347	39
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 0°				
No. of points:	39					



## 2D - CONTOUR

Inspector.:kcaban  
 Date .....:19-OCT-2009  
 Time .....:14:29:12



Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 005      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(2)

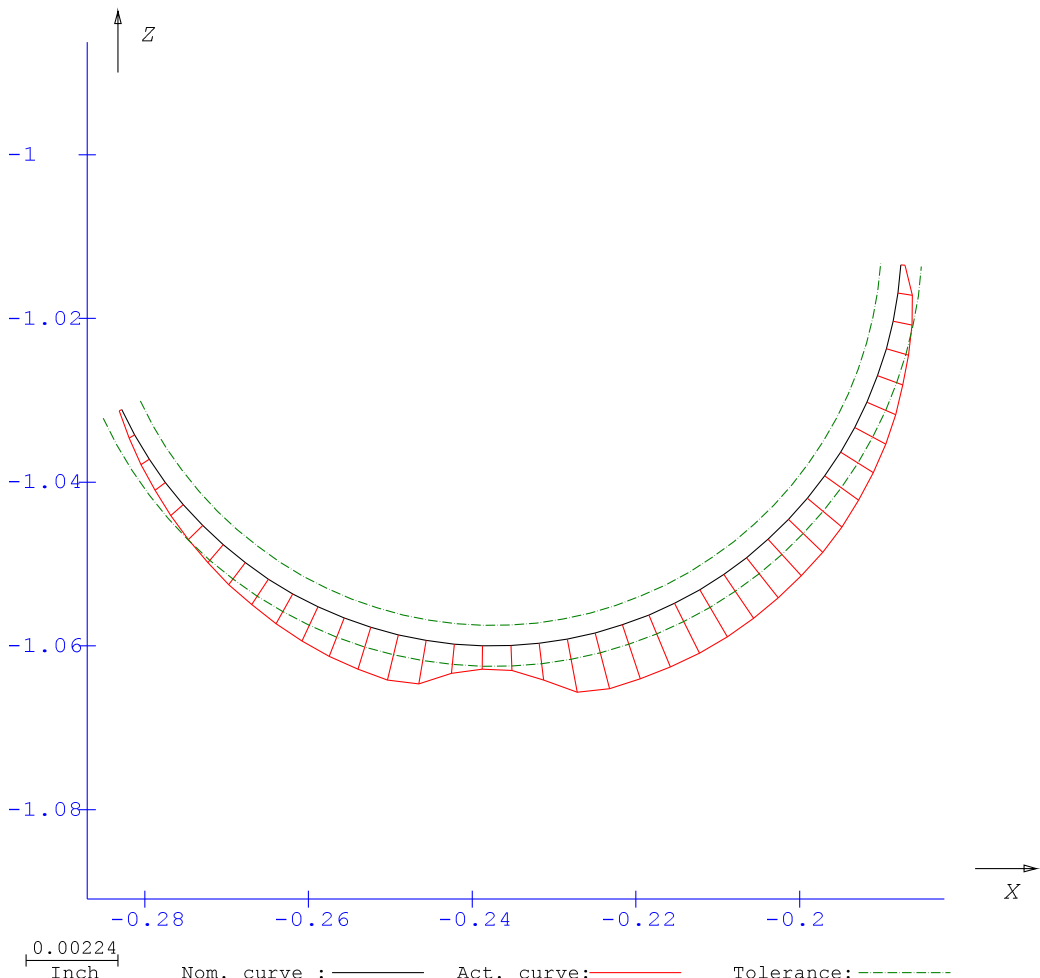
		X	Y	Z	Nr.
Form .....	0.00136	0.00000	0.18762	-1.01347	39
Lower Toler. :	-0.00050	0.00000	0.22838	-1.05916	20
Upper Toler. :	0.00050	Profile of Radius 0.0500			
Error Magnif.:	5	@ 90°			
No. of points:	39				



2D - CONTOUR

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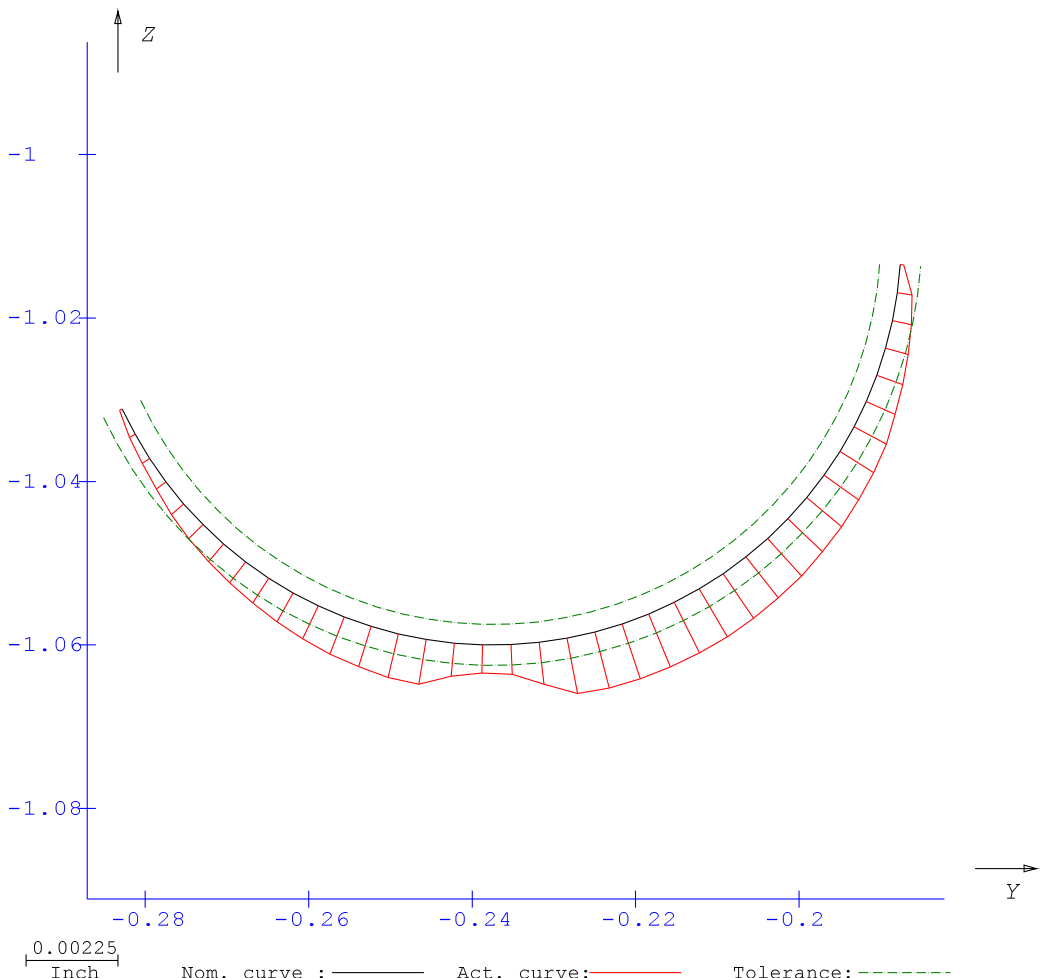
Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 005                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(3)

		X	Y	Z	Nr.		
Form .....	0.00134	Min. Deviat.:	0.00007	-0.28282	0.00000	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.:	0.00141	-0.22499	0.00000	-1.05841	21
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 .....:14:29:12



Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 005                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(4)

		X	Y	Z	Nr.
Form .....	0.00135	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.: 0.00007      Profile of Radius 0.0500  
 Max. Deviat.: 0.00142      @ 270°



2D - CONTOUR

Inspector.:kcaban  
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 Time .....:14:29:12