

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	006
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	8552100	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	19-OCT-2009, 15:37:06
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	0.00041	0.00000	0.00100	0.00000	0.00041	
DATUM_B		CYL					
	DM	0.37541	0.37500	0.00050	-0.00050	0.00041	
CYL_B		CYL					
	CYLFRM	0.00004	0.00000	0.00050	0.00000	0.00004	
SQR_B		AXI					
	SQRNES	0.00002	0.00000	0.00100	0.00000	0.00002	
FEATURE(1)		CIR					
	DM	0.99735	0.99800	0.00000	-0.00100	-0.00065	
FEATURE(2)		AXI					
	RADRUN	0.00008	0.00000	0.00100	0.00000	0.00008	
FEATURE(3)		PLA					
	Z	0.24171	0.24400	0.00000	-0.00500	-0.00229	
FEATURE(6)		CYL					
	FORM	0.00033					
	DM	0.28109	0.28100	0.00500	-0.00500	0.00009	
	X	-0.00007	0.00000			0.00007	
	Y	0.89999	0.90000			-0.00001	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.00017	0.00000	0.03474	0.00000	0.00017	
FEATURE(7)		CYL					
	FORM	0.00043					
	DM	0.28117	0.28100	0.00500	-0.00500	0.00017	
	X	-0.63636	0.63630			0.00006	
	Y	0.63635	0.63630			0.00005	
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	0.00021	0.00000	0.03472	0.00000	0.00021		

FEATURE(8)		CYL					
FORM	0.00030						
DM	0.28107	0.28100	0.00500	-0.00500	0.00007		
X	-0.90000	0.90000			0.00000		
Y	-0.00009	0.00000			0.00009		

POS_FEATURE(8)		AXI					
POSITN				0.03000			
POSMC	0.00030	0.00000	0.03477	0.00000	0.00030		

FEATURE(9)		CYL					
FORM	0.00042						
DM	0.28108	0.28100	0.00500	-0.00500	0.00008		
X	-0.63637	0.63630			0.00007		
Y	-0.63649	0.63630			0.00019		

POS_FEATURE(9)		AXI					
POSITN				0.03000			
POSMC	0.00049	0.00000	0.03467	0.00000	0.00049		

FEATURE(10)		CYL					
FORM	0.00035						
DM	0.28109	0.28100	0.00500	-0.00500	0.00009		
X	-0.00008	0.00000			0.00008		
Y	-0.90010	0.90000			0.00010		

POS_FEATURE(10)		AXI					
POSITN				0.03000			
POSMC	0.00031	0.00000	0.03473	0.00000	0.00031		

FEATURE(11)		CYL					
FORM	0.00040						
DM	0.28114	0.28100	0.00500	-0.00500	0.00014		
X	0.63639	0.63630			0.00009		
Y	-0.63648	0.63630			0.00018		

POS_FEATURE(11)		AXI					
POSITN				0.03000			
POSMC	0.00046	0.00000	0.03474	0.00000	0.00046		

FEATURE(12)		CYL					
FORM	0.00031						
DM	0.28105	0.28100	0.00500	-0.00500	0.00005		
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	0.03471	0.00000	0.00027		

FEATURE(13)		CYL					
FORM	0.00047						
DM	0.28118	0.28100	0.00500	-0.00500	0.00018		
X	0.63642	0.63630			0.00012		
Y	0.63642	0.63630			0.00012		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 20-Oct-09, 09:39:01			NO\$NAME			Page 2 of 10	

Date: 20-Oct-09, 09:39:01			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	0.00041	0.00000	0.03469	0.00000	0.00041	
FEATURE(14)		CYL					
	FORM	0.00025					
	DM	3.49992	3.50000	0.00500	-0.00500	-0.00008	
FEATURE(15)		AXI					
	RADRUN	0.00028	0.00000	0.00100	0.00000	0.00028	
FEATURE(4)		AXI					
	DZ	-0.09702	0.09700	0.00500	-0.00500	0.00002	
FEATURE(5)		CIR					
	FORM	0.00004					
	DM	0.87486	0.87500	0.00500	-0.00500	-0.00014	
POS_FEA(5)		POI					
	POSITN	0.00005	0.00000	0.00500	0.00000	0.00005	
FEATURE(16)		CIR					
	FORM	0.00002					
	DM	0.62620	0.62600	0.00500	-0.00500	0.00020	
FEATURE(17)		AXI					
	RADRUN	0.00005	0.00000	0.00100	0.00000	0.00005	
FEATURE(18)		CON					
	FORM	0.00002					
	CONANG_2	15.98970	16.00000			-0.01030	
	X	0.00002	0.00000			0.00002	
	Y	0.00001	0.00000			0.00001	
FEATURE(19)		POI					
	Z	0.12199	0.12000	0.00500	-0.00500	0.00199	
FEA_20(1)		AXI					
	DY	-0.06084	0.06000	0.01000	-0.01000	0.00084	
POS\$FEA_20(1)		AXI					
	POSITN	0.00141	0.00000	0.01000	0.00000	0.00141	
FEA_20(2)		AXI					
	DX	0.06056	0.06000	0.01000	-0.01000	0.00056	
POS\$FEA_20(2)		AXI					
	POSITN	0.00047	0.00000	0.01000	0.00000	0.00047	
FEA_20(3)		AXI					
	DY	-0.06089	0.06000	0.01000	-0.01000	0.00089	
POS\$FEA_20(3)		AXI					
	POSITN	0.00135	0.00000	0.01000	0.00000	0.00135	
FEA_20(4)		AXI					
	DX	0.06054	0.06000	0.01000	-0.01000	0.00054	
POS\$FEA_20(4)		AXI					
	POSITN	0.00004	0.00000	0.01000	0.00000	0.00004	

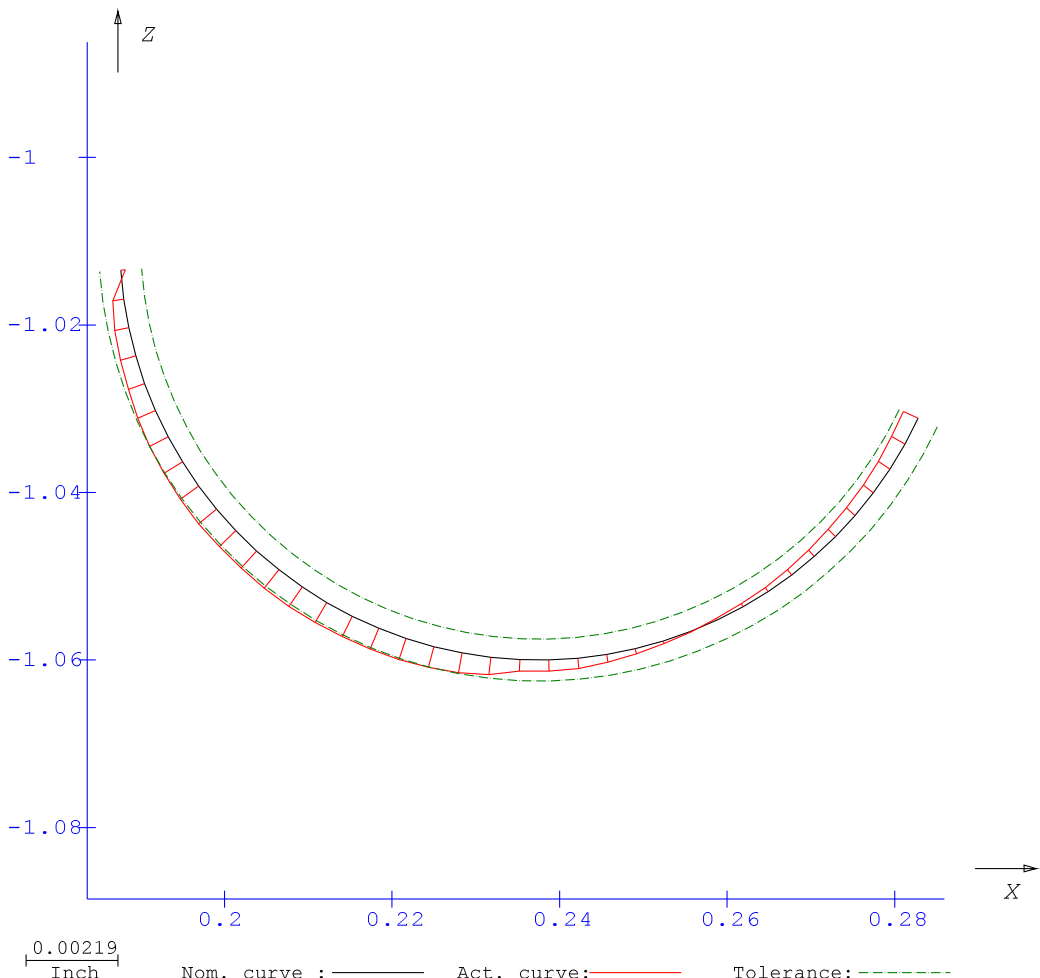
Date: 20-Oct-09, 09:39:01			NO\$NAME			Page 4 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEAT_21(1)			AXI				
DZ		0.05970	0.06000	0.00500	-0.00500	-0.00030	
FEAT_21(2)			AXI				
DZ		0.05970	0.06000	0.00500	-0.00500	-0.00030	
FEAT_21(3)			AXI				
DZ		0.05967	0.06000	0.00500	-0.00500	-0.00033	
FEAT_21(4)			AXI				
DZ		0.05963	0.06000	0.00500	-0.00500	-0.00037	
DAT_B_OP			CYL				
DM		0.37540					
FORM		0.00005					
FEATURE(22)			PLA				
FORM		0.00029					
Z		-0.56465					
FEATURE(23)			PLA				
PARALL		0.00052	0.00000	0.00100	0.00000	0.00052	
FEA(24)			PLA				
Z		-1.01037					
FORM		0.00003					
FEATURE(24)			PLA				
PARALL		0.00010	0.00000	0.00100	0.00000	0.00010	
FEATURE(25)			AXI				
DZ		-0.44571	0.44500	0.00100	0.00000	0.00071	
FEATURE(26)			AXI				
Z		-1.01037	1.01000	0.00200	0.00000	0.00037	
FEAT_27(1)			AXI				
DZ		-0.07945	0.08000	0.01000	-0.01000	-0.00055	
FEAT_27(2)			AXI				
DZ		-0.07575	0.08000	0.01000	-0.01000	-0.00425	
FEATURE(28)			CIR				
FORM		0.00033					
DM		2.25034	2.25000	0.01000	-0.01000	0.00034	
FEAT(28)			AXI				
RADRUN		0.00038	0.00000	0.00500	0.00000	0.00038	
FEATURE(30)			CYL				
FORM		0.00004					
DM		0.99725	0.99800	0.00000	-0.01000	-0.00075	
FEATURE(31)			AXI				
RADRUN		0.00007	0.00000	0.00100	0.00000	0.00007	
FEA(36)			CYL				
DM		0.28122	0.28100	0.00500	-0.00500	0.00022	
XY		1.49977	1.50000			-0.00023	
PP_PXPY		-0.17940	0.00000			0.17940	

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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		1.49977	1.50000			-0.00023	
PP_PXPY		-0.17940	0.00000			0.17940	
FEA(37)		CYL					
DM		0.28125	0.28100	0.00500	-0.00500	0.00025	
XY		1.49989	1.50000			-0.00011	
PP_PXPY		44.82578	45.00000			-0.17422	
FEA(38)		CYL					
DM		0.28117	0.28100	0.00500	-0.00500	0.00017	
XY		1.49974	1.50000			-0.00026	
PP_PXPY		89.83705	90.00000			-0.16295	
FEA(39)		CYL					
DM		0.28131	0.28100	0.00500	-0.00500	0.00031	
XY		1.49995	1.50000			-0.00005	
PP_PXPY		134.84198	135.00000			-0.15802	
FEA(40)		CYL					
DM		0.28125	0.28100	0.00500	-0.00500	0.00025	
XY		1.50017	1.50000			0.00017	
PP_PXPY		179.84551	180.00000			-0.15449	
POS_FEATURE(36)		AXI					
POSITN				0.03000			
POSMC		0.00940	0.00000	0.03508	0.00000	0.00940	
POS_FEATURE(37)		AXI					
POSITN				0.03000			
POSMC		0.00914	0.00000	0.03492	0.00000	0.00914	
POS_FEATURE(38)		AXI					
POSITN				0.03000			
POSMC		0.00858	0.00000	0.03497	0.00000	0.00858	
POS_FEATURE(39)		AXI					
POSITN				0.03000			
POSMC		0.00830	0.00000	0.03512	0.00000	0.00830	
POS_FEATURE(40)		AXI					
POSITN				0.03000			
POSMC		0.00811	0.00000	0.03511	0.00000	0.00811	
FEATURE(32)		AXI					
RADRUN		0.00021	0.00000	0.00100	0.00000	0.00021	
FEATURE(29)		TOR					
FORM		0.00074					
Cir_RA		0.04969	0.05000	0.00050	-0.00050	-0.00031	
OUT_DM		0.57334	0.57500	0.00100	-0.00100	-0.00166	
INN_DM		0.37458	0.37500			-0.00042	
X		0.00002					
Y		-0.00001					
FEA(33)		PLA					
FORM		0.00007					
Z		-1.05999					

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 20-Oct-09, 09:39:01			NO\$NAME			Page 5 of 10	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEATURE(34)			AXI				
DZ		0.04962	0.05000	0.00050	-0.00050	-0.00038	
FEATURE(41)			CIR				
FORM		0.00026					
RA		0.01738	0.01600	0.00200	-0.00200	0.00138	
FEA_42(1)			AXI				
Y		-0.20440	0.20000	0.01000	-0.01000	0.00440	
FEA_42(2)			AXI				
Y		-0.19591	0.20000	0.01000	-0.01000	-0.00409	
FEATURE(43)			CIR				
RA		0.12765	0.12500	0.00500	-0.00500	0.00265	
FEATURE(44)			CIR				
FORM		0.00009					
RA		1.24982	1.25000	0.01000	-0.01000	-0.00018	
FEATURE(45)			POI				
POSITN		0.00053	0.00000	0.00500	0.00000	0.00053	
FEATURE(46)			CIR				
FORM		0.00019					
RA		1.65013	1.65000	0.01000	-0.01000	0.00013	
FEATURE(47)			POI				
POSITN		0.00031	0.00000	0.00500	0.00000	0.00031	

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. : 006 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

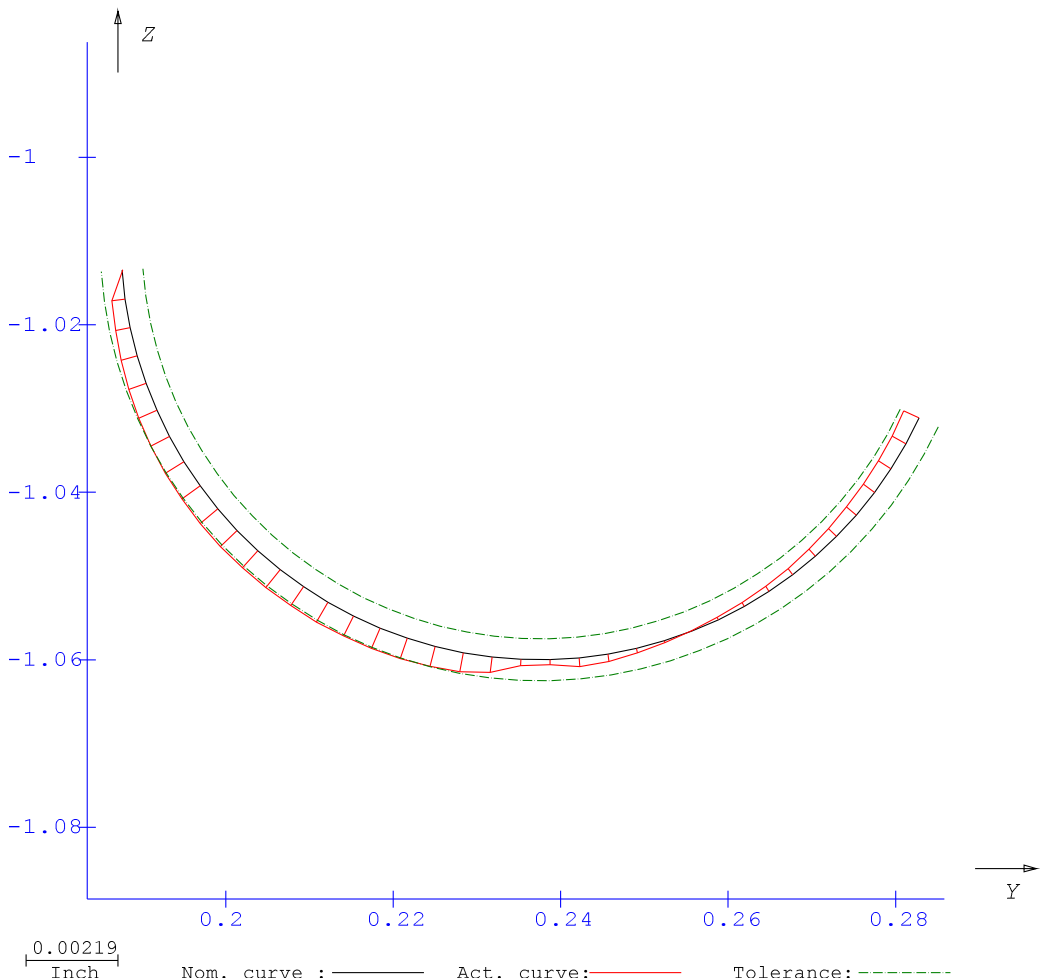
		X	Y	Z	Nr.
Form	0.00095	0.20649	0.00000	-1.04922	27
Lower Toler. :	-0.00050	0.28282	0.00000	-1.03113	1
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00057 Profile of Radius 0.0500
 Max. Deviat.: 0.00039 @ 0°



2D - CONTOUR

Inspector.:kcaban
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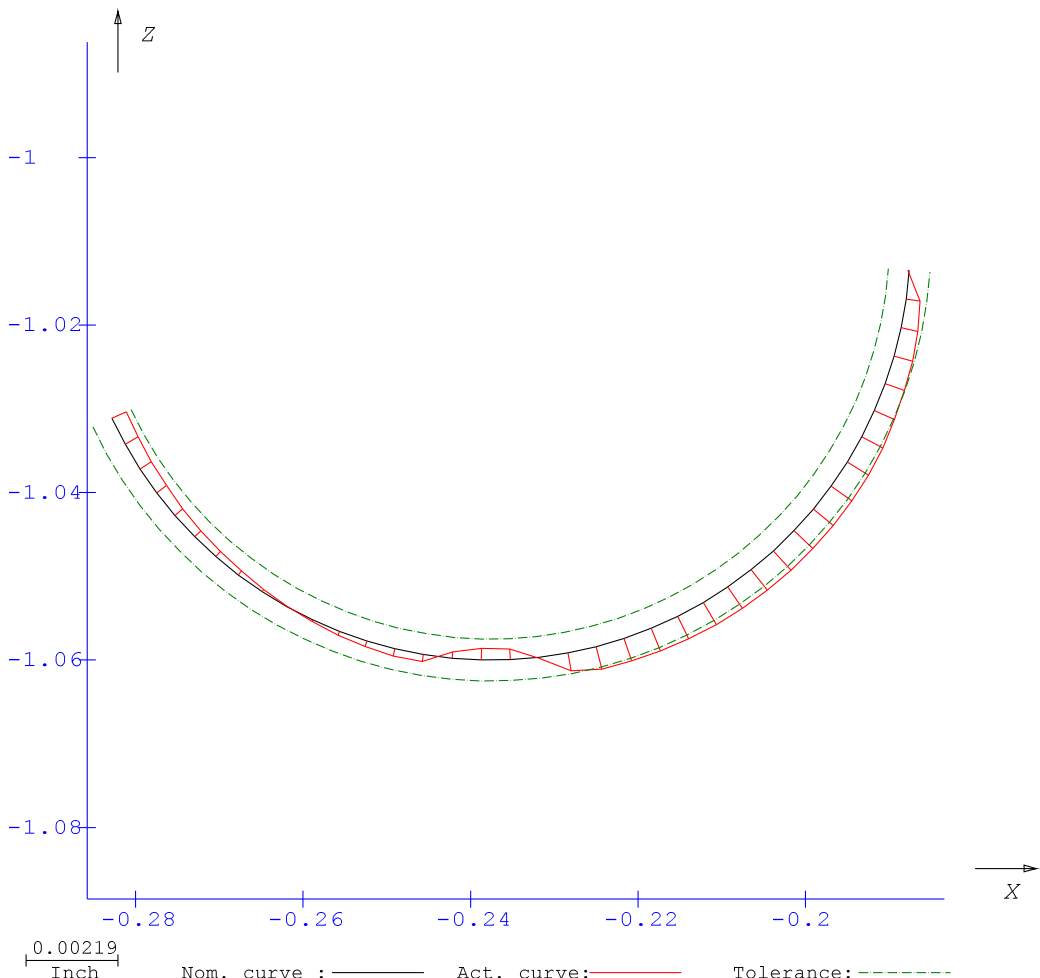
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 006 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

		X	Y	Z	Nr.	
Form	0.00096	Min. Deviat.:-0.00041	0.00000	0.28282	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00056	0.00000	0.20136	-1.04456	29
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 90°				
No. of points:	39					



2D - CONTOUR

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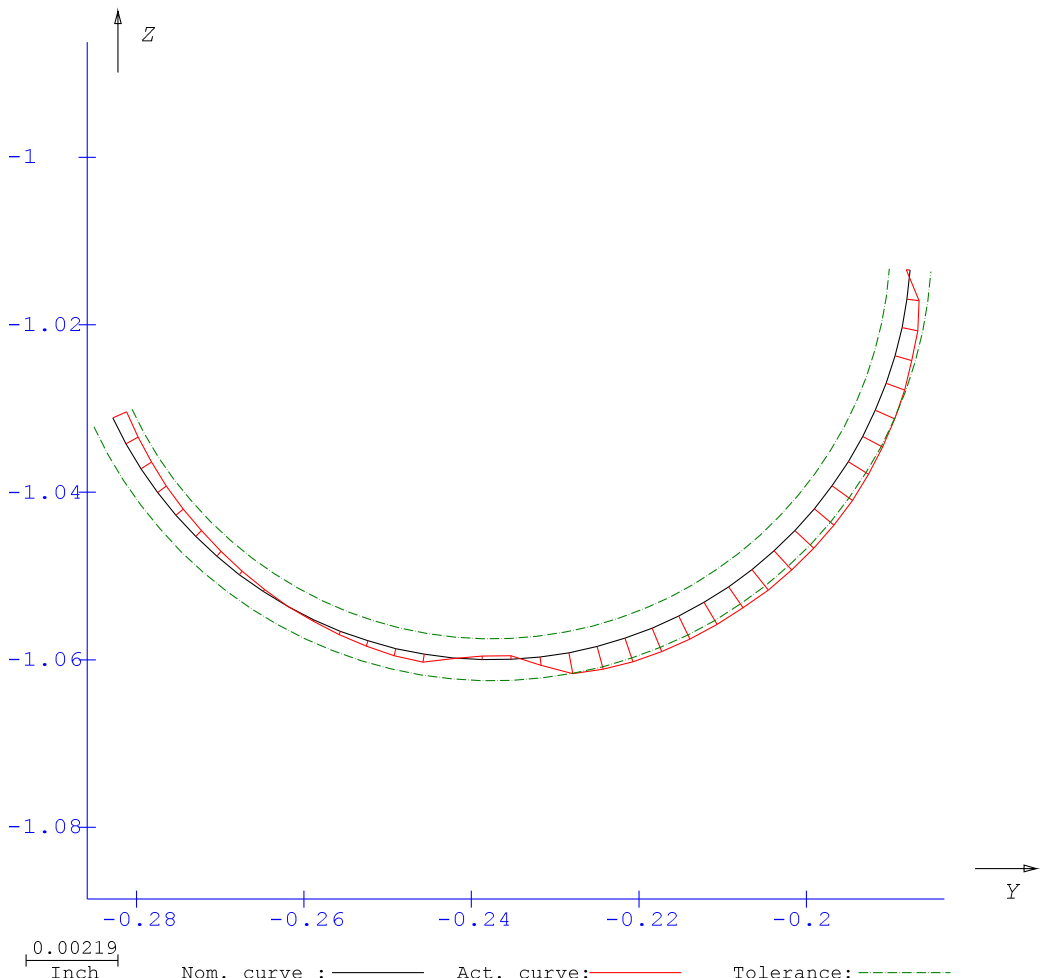
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 006 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.		
Form	0.00100	Min. Deviat.:-0.00038	-0.28282	0.00000	-1.03113	1	
Lower Toler. :	-0.00050	Max. Deviat.:	0.00062	-0.20384	0.00000	-1.04698	28
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. : 006 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.	
Form	0.00099	Min. Deviat.:-0.00036	0.00000	-0.28282	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00063	0.00000	-0.20649	-1.04922	27
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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