

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	008
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	20-OCT-2009, 11:18:52
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	0.00040	0.00000	0.00100	0.00000	0.00040	
DATUM_B		CYL					
	DM	0.37500	0.37500	0.00050	-0.00050	0.00000	
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	0.99749	0.99800	0.00000	-0.00100	-0.00051	
FEATURE(2)		AXI					
	RADRUN	0.00010	0.00000	0.00100	0.00000	0.00010	
FEATURE(3)		PLA					
	Z	0.24167	0.24400	0.00000	-0.00500	-0.00233	
FEATURE(6)		CYL					
	FORM	0.00028					
	DM	0.28103	0.28100	0.00500	-0.00500	0.00003	
	X	-0.00542	0.00000			0.00542	
	Y	0.89934	0.90000			-0.00066	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01098	0.00000	0.03473	0.00000	0.01098	
FEATURE(7)		CYL					
	FORM	0.00040					
	DM	0.28114	0.28100	0.00500	-0.00500	0.00014	
	X	-0.64020	0.63630			0.00390	
	Y	0.63203	0.63630			-0.00427	
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	0.01169	0.00000	0.03474	0.00000	0.01169		

FEATURE(8)		CYL					
FORM	0.00031						
DM	0.28104	0.28100	0.00500	-0.00500	0.00004		
X	-0.90013	0.90000			0.00013		
Y	-0.00593	0.00000			0.00593		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01198	0.00000	0.03470	0.00000	0.01198		

FEATURE(9)		CYL					
FORM	0.00046						
DM	0.28115	0.28100	0.00500	-0.00500	0.00015		
X	-0.63279	0.63630			-0.00351		
Y	-0.64077	0.63630			0.00447		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01142	0.00000	0.03468	0.00000	0.01142		

FEATURE(10)		CYL					
FORM	0.00026						
DM	0.28105	0.28100	0.00500	-0.00500	0.00005		
X	0.00507	0.00000			0.00507		
Y	-0.90066	0.90000			0.00066		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.01024	0.00000	0.03478	0.00000	0.01024		

FEATURE(11)		CYL					
FORM	0.00038						
DM	0.28109	0.28100	0.00500	-0.00500	0.00009		
X	0.63995	0.63630			0.00365		
Y	-0.63331	0.63630			-0.00299		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.00954	0.00000	0.03471	0.00000	0.00954		

FEATURE(12)		CYL					
FORM	0.00029						
DM	0.28106	0.28100	0.00500	-0.00500	0.00006		
X	0.89981	0.90000			-0.00019		
Y	0.00461	0.00000			0.00461		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00933	0.00000	0.03479	0.00000	0.00933		

FEATURE(13)		CYL					
FORM	0.00060						
DM	0.28101	0.28100	0.00500	-0.00500	0.00001		
X	0.63260	0.63630			-0.00370		
Y	0.63945	0.63630			0.00315		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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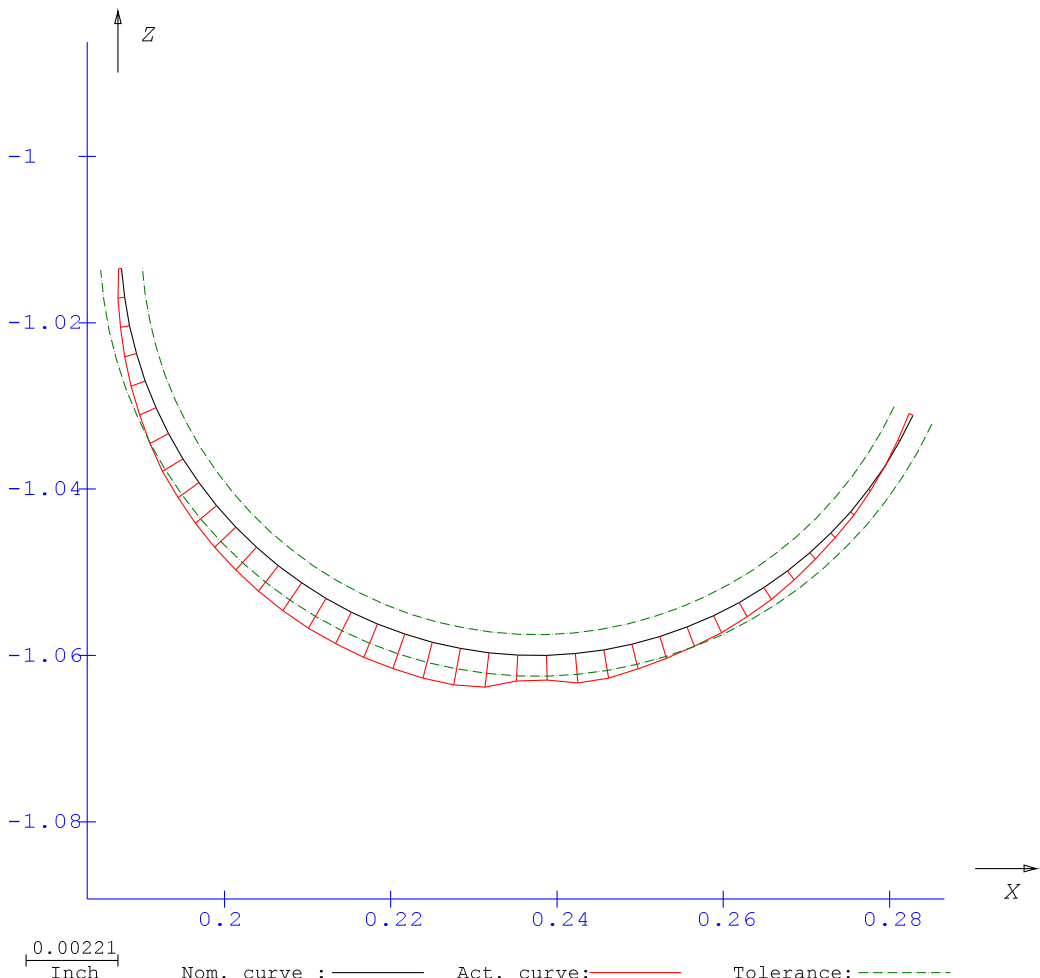
Date: 20-Oct-09, 11:18:52			NO\$NAME			Page 3 of 10	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
POS_FEATURE(13)		AXI					
	POSITN			0.03000			
	POSMC	0.00978	0.00000	0.03447	0.00000	0.00978	
FEATURE(14)		CYL					
	FORM	0.00026					
	DM	3.50006	3.50000	0.00500	-0.00500	0.00006	
FEATURE(15)		AXI					
	RADRUN	0.00027	0.00000	0.00100	0.00000	0.00027	
FEATURE(4)		AXI					
	DZ	-0.09696	0.09700	0.00500	-0.00500	-0.00004	
FEATURE(5)		CIR					
	FORM	0.00003					
	DM	0.87500	0.87500	0.00500	-0.00500	0.00000	
POS_FEA(5)		POI					
	POSITN	0.00009	0.00000	0.00500	0.00000	0.00009	
FEATURE(16)		CIR					
	FORM	0.00004					
	DM	0.62573	0.62600	0.00500	-0.00500	-0.00027	
FEATURE(17)		AXI					
	RADRUN	0.00007	0.00000	0.00100	0.00000	0.00007	
FEATURE(18)		CON					
	FORM	0.00002					
	CONANG_2	15.98875	16.00000			-0.01125	
	X	-0.00009	0.00000			0.00009	
	Y	0.00001	0.00000			0.00001	
FEATURE(19)		POI					
	Z	0.12210	0.12000	0.00500	-0.00500	0.00210	
FEA_20(1)		AXI					
	DY	-0.06090	0.06000	0.01000	-0.01000	0.00090	
POS\$FEA_20(1)		AXI					
	POSITN	0.00112	0.00000	0.01000	0.00000	0.00112	
FEA_20(2)		AXI					
	DX	0.06057	0.06000	0.01000	-0.01000	0.00057	
POS\$FEA_20(2)		AXI					
	POSITN	0.00033	0.00000	0.01000	0.00000	0.00033	
FEA_20(3)		AXI					
	DY	-0.06087	0.06000	0.01000	-0.01000	0.00087	
POS\$FEA_20(3)		AXI					
	POSITN	0.00080	0.00000	0.01000	0.00000	0.00080	
FEA_20(4)		AXI					
	DX	0.06064	0.06000	0.01000	-0.01000	0.00064	
POS\$FEA_20(4)		AXI					
	POSITN	0.00038	0.00000	0.01000	0.00000	0.00038	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEAT_21(1)			AXI				
DZ		0.05996	0.06000	0.00500	-0.00500	-0.00004	
FEAT_21(2)			AXI				
DZ		0.05986	0.06000	0.00500	-0.00500	-0.00014	
FEAT_21(3)			AXI				
DZ		0.05992	0.06000	0.00500	-0.00500	-0.00008	
FEAT_21(4)			AXI				
DZ		0.05993	0.06000	0.00500	-0.00500	-0.00007	
DAT_B_OP			CYL				
DM		0.37501					
FORM		0.00007					
FEATURE(22)			PLA				
FORM		0.00029					
Z		-0.56504					
FEATURE(23)			PLA				
PARALL		0.00034	0.00000	0.00100	0.00000	0.00034	
FEA(24)			PLA				
Z		-1.01079					
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		-1.01079	1.01000	0.00200	0.00000	0.00079	
FEAT_27(1)			AXI				
DZ		-0.07940	0.08000	0.01000	-0.01000	-0.00060	
FEAT_27(2)			AXI				
DZ		-0.07731	0.08000	0.01000	-0.01000	-0.00269	
FEATURE(28)			CIR				
FORM		0.00009					
DM		2.25091	2.25000	0.01000	-0.01000	0.00091	
FEAT(28)			AXI				
RADRUN		0.00013	0.00000	0.00500	0.00000	0.00013	
FEATURE(30)			CYL				
FORM		0.00018					
DM		0.99761	0.99800	0.00000	-0.01000	-0.00039	
FEATURE(31)			AXI				
RADRUN		0.00020	0.00000	0.00100	0.00000	0.00020	
FEA(36)			CYL				
DM		0.28122	0.28100	0.00500	-0.00500	0.00022	
XY		1.49983	1.50000			-0.00017	
PP_PXPY		-0.18440	0.00000			0.18440	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEA(36)		CYL					
DM		0.28123	0.28100	0.00500	-0.00500	0.00023	
XY		1.49984	1.50000			-0.00016	
PP_PXPY		-0.18441	0.00000			0.18441	
FEA(37)		CYL					
DM		0.28126	0.28100	0.00500	-0.00500	0.00026	
XY		1.49985	1.50000			-0.00015	
PP_PXPY		44.82170	45.00000			-0.17831	
FEA(38)		CYL					
DM		0.28114	0.28100	0.00500	-0.00500	0.00014	
XY		1.49957	1.50000			-0.00043	
PP_PXPY		89.83470	90.00000			-0.16530	
FEA(39)		CYL					
DM		0.28127	0.28100	0.00500	-0.00500	0.00027	
XY		1.49980	1.50000			-0.00020	
PP_PXPY		134.84275	135.00000			-0.15725	
FEA(40)		CYL					
DM		0.28124	0.28100	0.00500	-0.00500	0.00024	
XY		1.50009	1.50000			0.00009	
PP_PXPY		179.84835	180.00000			-0.15165	
POS_FEATURE(36)		AXI					
POSITN				0.03000			
POSMC		0.00967	0.00000	0.03506	0.00000	0.00967	
POS_FEATURE(37)		AXI					
POSITN				0.03000			
POSMC		0.00935	0.00000	0.03497	0.00000	0.00935	
POS_FEATURE(38)		AXI					
POSITN				0.03000			
POSMC		0.00871	0.00000	0.03499	0.00000	0.00871	
POS_FEATURE(39)		AXI					
POSITN				0.03000			
POSMC		0.00832	0.00000	0.03512	0.00000	0.00832	
POS_FEATURE(40)		AXI					
POSITN				0.03000			
POSMC		0.00799	0.00000	0.03510	0.00000	0.00799	
FEATURE(32)		AXI					
RADRUN		0.00016	0.00000	0.00100	0.00000	0.00016	
FEATURE(29)		TOR					
FORM		0.00052					
Cir_RA		0.04970	0.05000	0.00050	-0.00050	-0.00030	
OUT_DM		0.57367	0.57500	0.00100	-0.00100	-0.00133	
INN_DM		0.37486	0.37500			-0.00014	
X		0.00002					
Y		-0.00001					
FEA(33)		PLA					
FORM		0.00011					
Z		-1.06052					

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic	
FEATURE(34)			AXI					
	DZ	0.04973	0.05000	0.00050	-0.00050	-0.00027		
FEATURE(41)			CIR					
	FORM	0.00024						
	RA	0.01639	0.01600	0.00200	-0.00200	0.00039		
FEA_42(1)			AXI					
	Y	-0.20445	0.20000	0.01000	-0.01000	0.00445		
FEA_42(2)			AXI					
	Y	-0.19599	0.20000	0.01000	-0.01000	-0.00401		
FEATURE(43)			CIR					
	RA	0.12787	0.12500	0.00500	-0.00500	0.00287		
FEATURE(44)			CIR					
	FORM	0.00016						
	RA	1.24975	1.25000	0.01000	-0.01000	-0.00025		
FEATURE(45)			POI					
	POSITN	0.00045	0.00000	0.00500	0.00000	0.00045		
FEATURE(46)			CIR					
	FORM	0.00017						
	RA	1.65020	1.65000	0.01000	-0.01000	0.00020		
FEATURE(47)			POI					
	POSITN	0.00075	0.00000	0.00500	0.00000	0.00075		

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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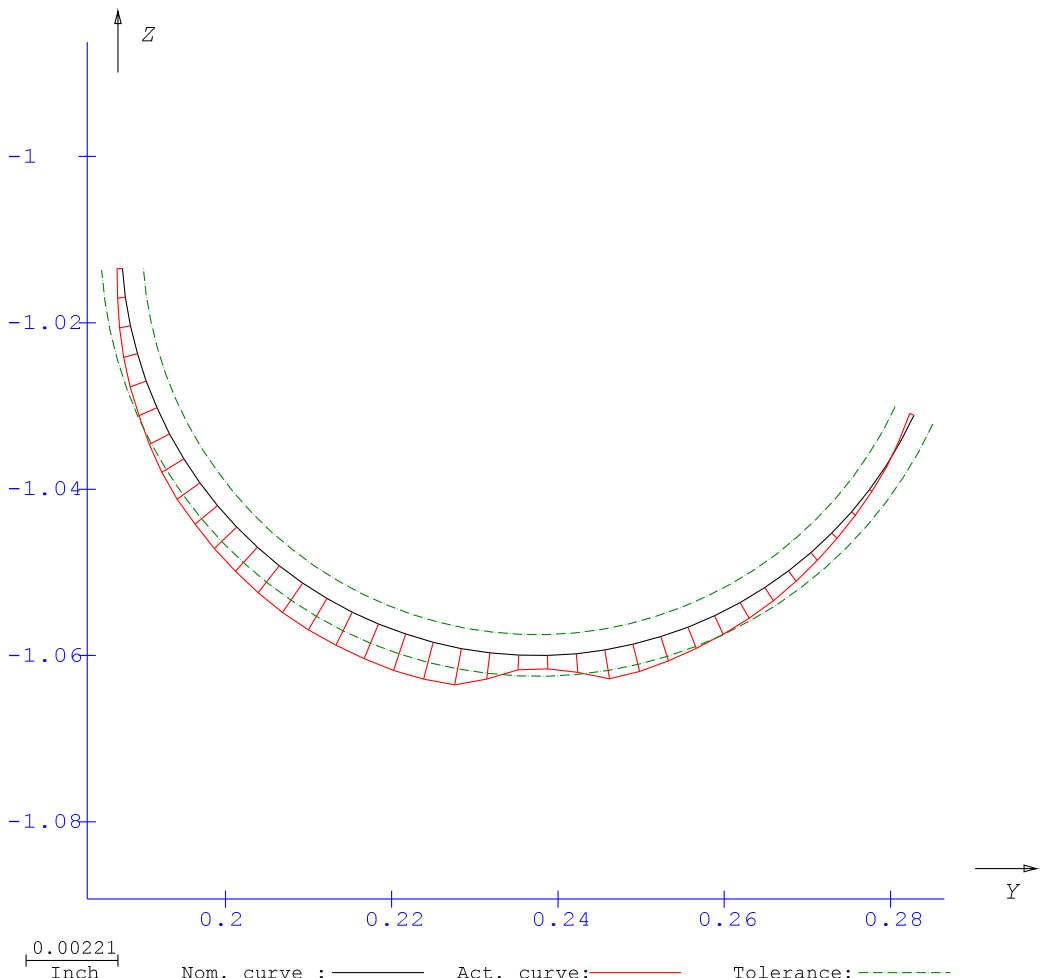
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

		X	Y	Z	Nr.	
Form	0.00100	Min. Deviat.:-0.00089	0.22499	0.00000	-1.05841	21
Lower Toler. :	-0.00050	Max. Deviat.: 0.00010	0.28282	0.00000	-1.03113	1
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 0°				
No. of points:	39					



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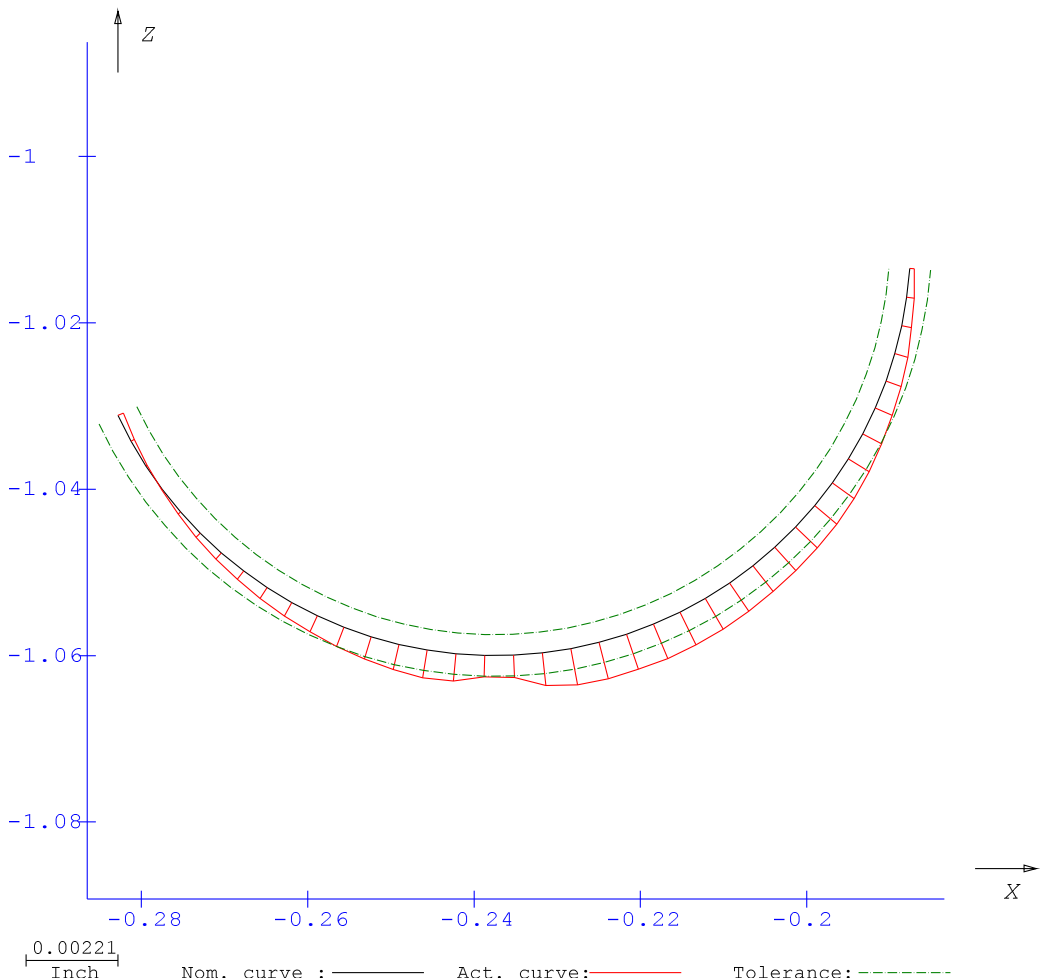
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

		X	Y	Z	Nr.	
Form	0.00103	Min. Deviat.:-0.00011	0.00000	0.28282	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00092	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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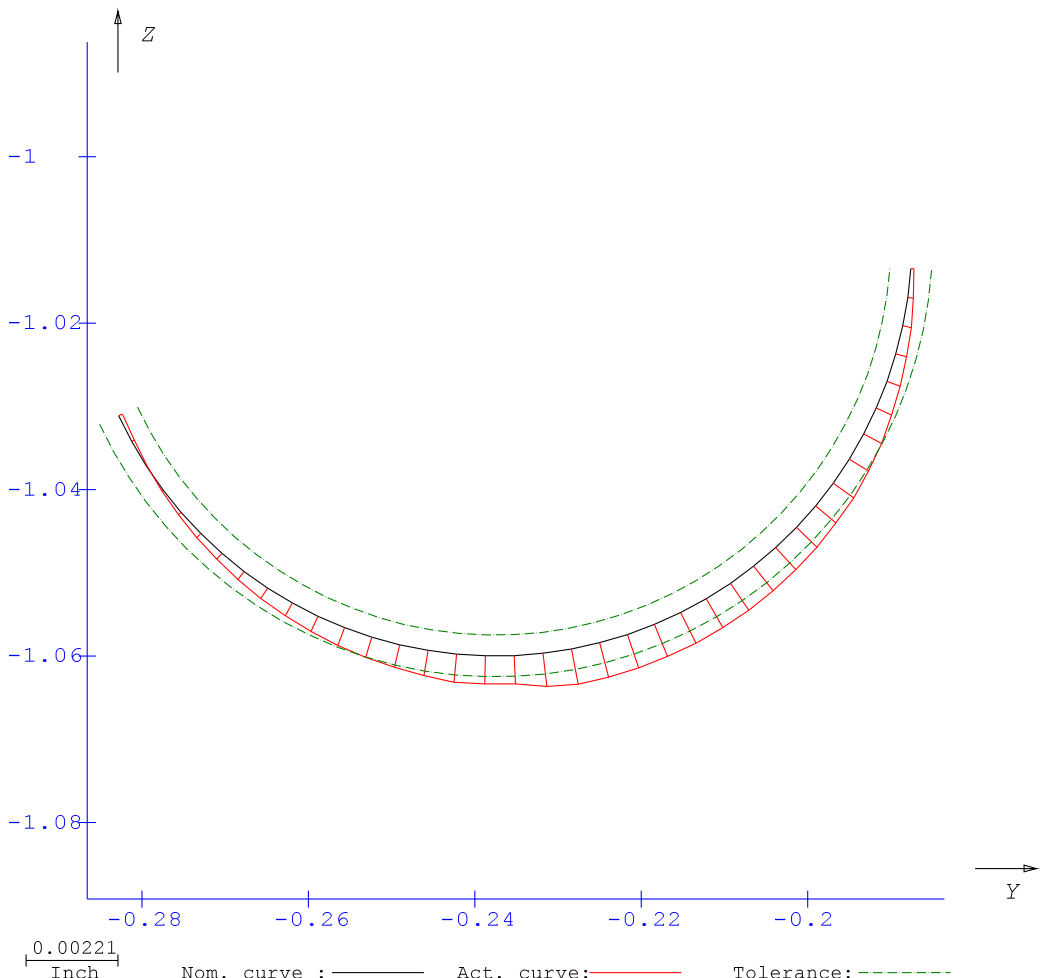
Notation : DRIFT TUBE 1 Producer : L. GARCIA Draw. No. : PF-700-913-11 R
 Ser. No. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.	
Form	0.00104	Min. Deviat.:-0.00014	-0.28282	0.00000	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00090	-0.22499	0.00000	-1.05841	21
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. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.		
Form	0.00097	Min. Deviat.:-0.00010	0.00000	-0.28282	-1.03113	1	
Lower Toler. :	-0.00050	Max. Deviat.:	0.00086	0.00000	-0.22838	-1.05916	20
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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