

# Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	009
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, 12:32:45
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	0.00039	0.00000	0.00100	0.00000	0.00039	
<b>DATUM_B</b>		<b>CYL</b>					
	DM	0.37521	0.37500	0.00050	-0.00050	0.00021	
<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	0.99700	0.99800	0.00000	-0.00100	-0.00100	
<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	0.24167	0.24400	0.00000	-0.00500	-0.00233	
<b>FEATURE(6)</b>		<b>CYL</b>					
	FORM	0.00030					
	DM	0.28107	0.28100	0.00500	-0.00500	0.00007	
	X	-0.00519	0.00000			0.00519	
	Y	0.89865	0.90000			-0.00135	
<b>POS_FEATURE(6)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01079	0.00000	0.03477	0.00000	0.01079	
<b>FEATURE(7)</b>		<b>CYL</b>					
	FORM	0.00039					
	DM	0.28121	0.28100	0.00500	-0.00500	0.00021	
	X	-0.63997	0.63630			0.00367	
	Y	0.63138	0.63630			-0.00492	
<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: 20-Oct-09, 12:32:45			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	0.01242	0.00000	0.03481	0.00000	0.01242		

<b>FEATURE(8)</b>		<b>CYL</b>					
FORM	0.00028						
DM	0.28103	0.28100	0.00500	-0.00500	0.00003		
X	-0.89995	0.90000			-0.00005		
Y	-0.00655	0.00000			0.00655		

<b>POS_FEATURE(8)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01320	0.00000	0.03470	0.00000	0.01320		

<b>FEATURE(9)</b>		<b>CYL</b>					
FORM	0.00040						
DM	0.28114	0.28100	0.00500	-0.00500	0.00014		
X	-0.63269	0.63630			-0.00361		
Y	-0.64145	0.63630			0.00515		

<b>POS_FEATURE(9)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01261	0.00000	0.03472	0.00000	0.01261		

<b>FEATURE(10)</b>		<b>CYL</b>					
FORM	0.00020						
DM	0.28100	0.28100	0.00500	-0.00500	0.00000		
X	0.00513	0.00000			0.00513		
Y	-0.90141	0.90000			0.00141		

<b>POS_FEATURE(10)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01065	0.00000	0.03479	0.00000	0.01065		

<b>FEATURE(11)</b>		<b>CYL</b>					
FORM	0.00039						
DM	0.28113	0.28100	0.00500	-0.00500	0.00013		
X	0.64003	0.63630			0.00373		
Y	-0.63411	0.63630			-0.00219		

<b>POS_FEATURE(11)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00871	0.00000	0.03472	0.00000	0.00871		

<b>FEATURE(12)</b>		<b>CYL</b>					
FORM	0.00031						
DM	0.28111	0.28100	0.00500	-0.00500	0.00011		
X	0.89995	0.90000			-0.00005		
Y	0.00379	0.00000			0.00379		

<b>POS_FEATURE(12)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00769	0.00000	0.03480	0.00000	0.00769		

<b>FEATURE(13)</b>		<b>CYL</b>					
FORM	0.00041						
DM	0.28114	0.28100	0.00500	-0.00500	0.00014		
X	0.63276	0.63630			-0.00354		
Y	0.63872	0.63630			0.00242		

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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Date: 20-Oct-09, 12:32:45			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			
	POSMMC	0.00866	0.00000	0.03474	0.00000	0.00866	
<b>FEATURE(14)</b>		<b>CYL</b>					
	FORM	0.00026					
	DM	3.49958	3.50000	0.00500	-0.00500	-0.00042	
<b>FEATURE(15)</b>		<b>AXI</b>					
	RADRUN	0.00032	0.00000	0.00100	0.00000	0.00032	
<b>FEATURE(4)</b>		<b>AXI</b>					
	DZ	-0.09699	0.09700	0.00500	-0.00500	-0.00001	
<b>FEATURE(5)</b>		<b>CIR</b>					
	FORM	0.00003					
	DM	0.87450	0.87500	0.00500	-0.00500	-0.00050	
<b>POS_FEA(5)</b>		<b>POI</b>					
	POSITN	0.00006	0.00000	0.00500	0.00000	0.00006	
<b>FEATURE(16)</b>		<b>CIR</b>					
	FORM	0.00007					
	DM	0.62595	0.62600	0.00500	-0.00500	-0.00005	
<b>FEATURE(17)</b>		<b>AXI</b>					
	RADRUN	0.00007	0.00000	0.00100	0.00000	0.00007	
<b>FEATURE(18)</b>		<b>CON</b>					
	FORM	0.00003					
	CONANG_2	15.99367	16.00000			-0.00633	
	X	-0.00005	0.00000			0.00005	
	Y	-0.00003	0.00000			0.00003	
<b>FEATURE(19)</b>		<b>POI</b>					
	Z	0.12222	0.12000	0.00500	-0.00500	0.00222	
<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	0.00212	0.00000	0.01000	0.00000	0.00212	
<b>FEA_20(2)</b>		<b>AXI</b>					
	DX	0.06062	0.06000	0.01000	-0.01000	0.00062	
<b>POS\$FEA_20(2)</b>		<b>AXI</b>					
	POSITN	0.00055	0.00000	0.01000	0.00000	0.00055	
<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	0.00210	0.00000	0.01000	0.00000	0.00210	
<b>FEA_20(4)</b>		<b>AXI</b>					
	DX	0.06062	0.06000	0.01000	-0.01000	0.00062	
<b>POS\$FEA_20(4)</b>		<b>AXI</b>					
	POSITN	0.00057	0.00000	0.01000	0.00000	0.00057	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEAT_21(1)</b>			<b>AXI</b>				
DZ		0.05995	0.06000	0.00500	-0.00500	-0.00005	
<b>FEAT_21(2)</b>			<b>AXI</b>				
DZ		0.05979	0.06000	0.00500	-0.00500	-0.00021	
<b>FEAT_21(3)</b>			<b>AXI</b>				
DZ		0.05989	0.06000	0.00500	-0.00500	-0.00011	
<b>FEAT_21(4)</b>			<b>AXI</b>				
DZ		0.05997	0.06000	0.00500	-0.00500	-0.00003	
<b>DAT_B_OP</b>			<b>CYL</b>				
DM		0.37521					
FORM		0.00005					
<b>FEATURE(22)</b>			<b>PLA</b>				
FORM		0.00032					
Z		-0.56502					
<b>FEATURE(23)</b>			<b>PLA</b>				
PARALL		0.00059	0.00000	0.00100	0.00000	0.00059	
<b>FEA(24)</b>			<b>PLA</b>				
Z		-1.01077					
FORM		0.00003					
<b>FEATURE(24)</b>			<b>PLA</b>				
PARALL		0.00011	0.00000	0.00100	0.00000	0.00011	
<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		-1.01077	1.01000	0.00200	0.00000	0.00077	
<b>FEAT_27(1)</b>			<b>AXI</b>				
DZ		-0.07935	0.08000	0.01000	-0.01000	-0.00065	
<b>FEAT_27(2)</b>			<b>AXI</b>				
DZ		-0.07726	0.08000	0.01000	-0.01000	-0.00274	
<b>FEATURE(28)</b>			<b>CIR</b>				
FORM		0.00025					
DM		2.25047	2.25000	0.01000	-0.01000	0.00047	
<b>FEAT(28)</b>			<b>AXI</b>				
RADRUN		0.00026	0.00000	0.00500	0.00000	0.00026	
<b>FEATURE(30)</b>			<b>CYL</b>				
FORM		0.00005					
DM		0.99726	0.99800	0.00000	-0.01000	-0.00074	
<b>FEATURE(31)</b>			<b>AXI</b>				
RADRUN		0.00018	0.00000	0.00100	0.00000	0.00018	
<b>FEA(36)</b>			<b>CYL</b>				
DM		0.28128	0.28100	0.00500	-0.00500	0.00028	
XY		1.49977	1.50000			-0.00023	
PP_PXPY		-0.19665	0.00000			0.19665	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

FEA(36)		CYL					
DM	0.28128	0.28100	0.00500	-0.00500	0.00028		
XY	1.49977	1.50000			-0.00023		
PP_PXPY	-0.19664	0.00000			0.19664		

FEA(37)		CYL					
DM	0.28132	0.28100	0.00500	-0.00500	0.00032		
XY	1.49934	1.50000			-0.00066		
PP_PXPY	44.81755	45.00000			-0.18245		

FEA(38)		CYL					
DM	0.28121	0.28100	0.00500	-0.00500	0.00021		
XY	1.49894	1.50000			-0.00106		
PP_PXPY	89.84863	90.00000			-0.15137		

FEA(39)		CYL					
DM	0.28132	0.28100	0.00500	-0.00500	0.00032		
XY	1.49932	1.50000			-0.00068		
PP_PXPY	134.87420	135.00000			-0.12580		

FEA(40)		CYL					
DM	0.28128	0.28100	0.00500	-0.00500	0.00028		
XY	1.50005	1.50000			0.00005		
PP_PXPY	179.88727	180.00000			-0.11273		

POS_FEATURE(36)		AXI					
POSITN					0.03000		
POSMC	0.01032	0.00000	0.03517	0.00000	0.01032		

POS_FEATURE(37)		AXI					
POSITN					0.03000		
POSMC	0.00970	0.00000	0.03508	0.00000	0.00970		

POS_FEATURE(38)		AXI					
POSITN					0.03000		
POSMC	0.00823	0.00000	0.03497	0.00000	0.00823		

POS_FEATURE(39)		AXI					
POSITN					0.03000		
POSMC	0.00676	0.00000	0.03509	0.00000	0.00676		

POS_FEATURE(40)		AXI					
POSITN					0.03000		
POSMC	0.00594	0.00000	0.03519	0.00000	0.00594		

FEATURE(32)		AXI					
RADRUN	0.00019	0.00000	0.00100	0.00000	0.00019		

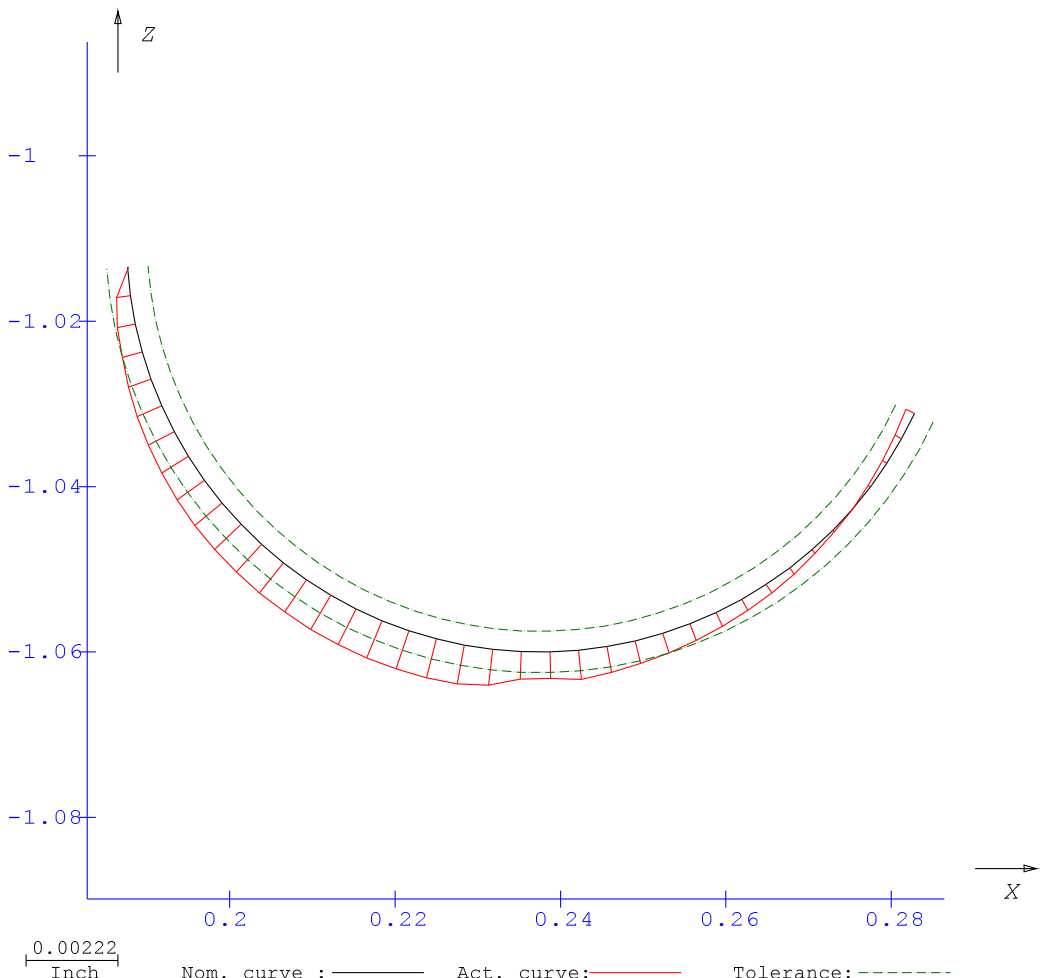
FEATURE(29)		TOR					
FORM	0.00050						
Cir_RA	0.04969	0.05000	0.00050	-0.00050	-0.00031		
OUT_DM	0.57341	0.57500	0.00100	-0.00100	-0.00159		
INN_DM	0.37464	0.37500			-0.00036		
X	-0.00004						
Y	0.00004						

FEA(33)		PLA					
FORM	0.00008						
Z	-1.06049						

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEATURE(34)</b>			<b>AXI</b>				
DZ		0.04972	0.05000	0.00050	-0.00050	-0.00028	
<b>FEATURE(41)</b>			<b>CIR</b>				
FORM		0.00013					
RA		0.01668	0.01600	0.00200	-0.00200	0.00068	
<b>FEA_42(1)</b>			<b>AXI</b>				
Y		-0.20480	0.20000	0.01000	-0.01000	0.00480	
<b>FEA_42(2)</b>			<b>AXI</b>				
Y		-0.19700	0.20000	0.01000	-0.01000	-0.00300	
<b>FEATURE(43)</b>			<b>CIR</b>				
RA		0.12876	0.12500	0.00500	-0.00500	0.00376	
<b>FEATURE(44)</b>			<b>CIR</b>				
FORM		0.00010					
RA		1.24973	1.25000	0.01000	-0.01000	-0.00027	
<b>FEATURE(45)</b>			<b>POI</b>				
POSITN		0.00179	0.00000	0.00500	0.00000	0.00179	
<b>FEATURE(46)</b>			<b>CIR</b>				
FORM		0.00022					
RA		1.65013	1.65000	0.01000	-0.01000	0.00013	
<b>FEATURE(47)</b>			<b>POI</b>				
POSITN		0.00191	0.00000	0.00500	0.00000	0.00191	

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. : 009                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(1)

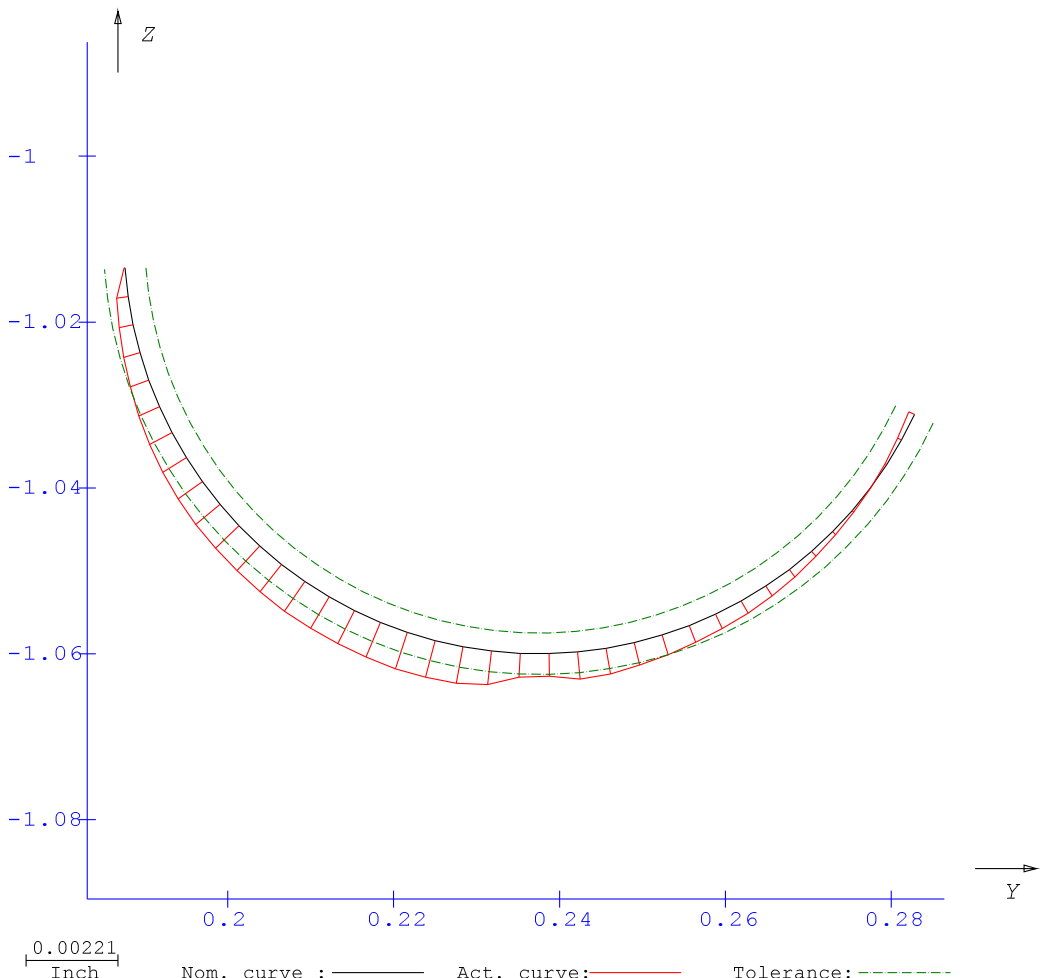
		X	Y	Z	Nr.
Form .....	0.00120	0.21842	0.00000	-1.05622	23
Lower Toler. :	-0.00050	0.28282	0.00000	-1.03113	1
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00097      Profile of Radius 0.0500  
 Max. Deviat.: 0.00023      @ 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. : 009                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(2)

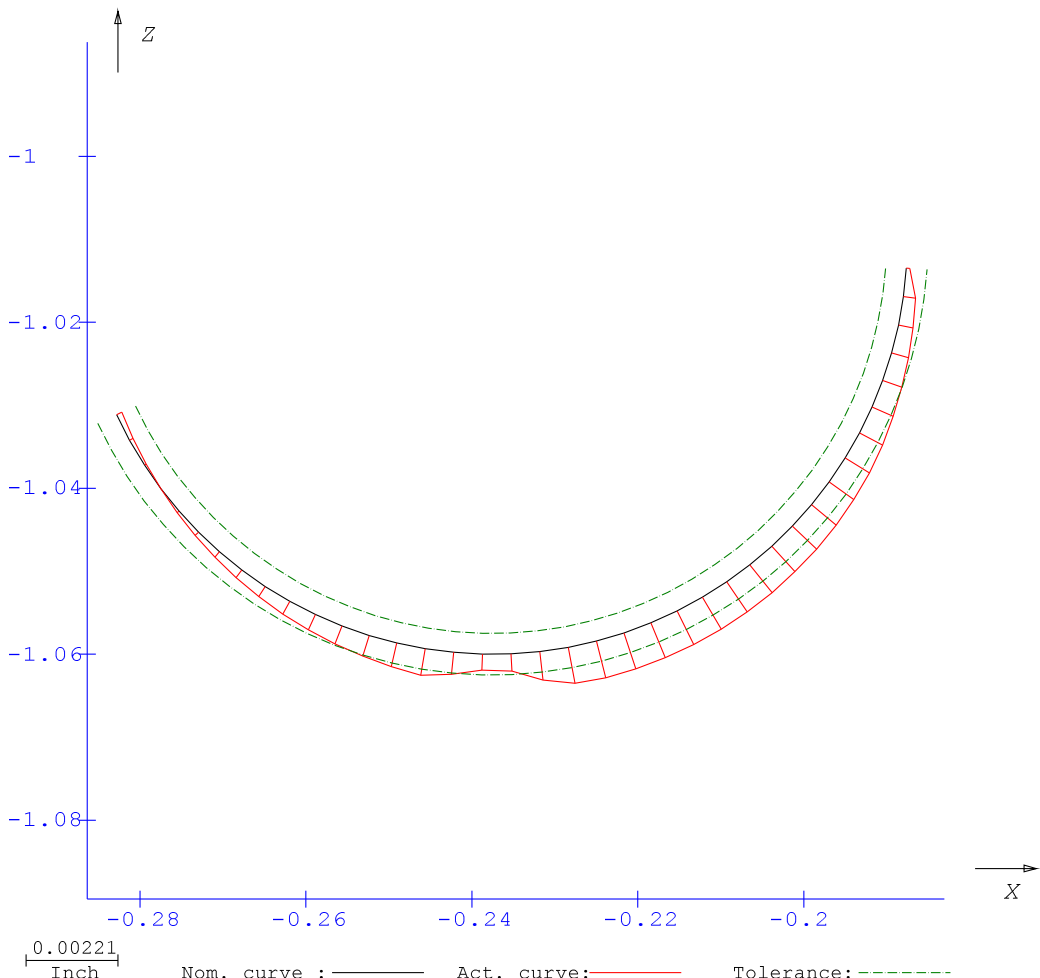
		X	Y	Z	Nr.	
Form .....	0.00107	Min. Deviat.:-0.00015	0.00000	0.28282	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00092	0.00000	0.22167	-1.05743	22
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 90°				
No. of points:	39					



2D - CONTOUR

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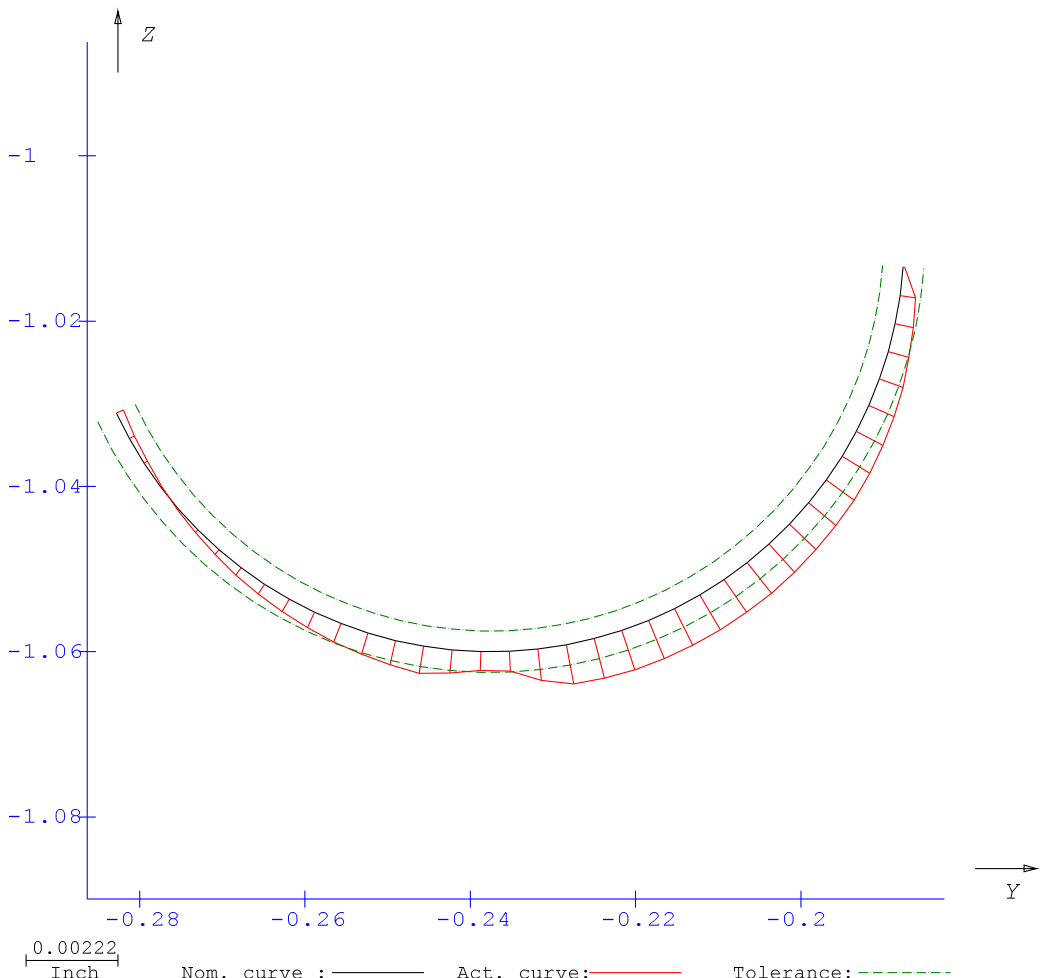
Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 009                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(3)

		X	Y	Z	Nr.	
Form .....	0.00106	Min. Deviat.:-0.00014	-0.28282	0.00000	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00092	-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

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Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 009      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(4)

		X	Y	Z	Nr.	
Form .....	0.00119	Min. Deviat.:-0.00019	0.00000	-0.28282	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00100	0.00000	-0.22167	-1.05743	22
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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 Time .....:12:32:45