

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	001
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	710074	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	21-OCT-2009, 10:30:01
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9294
User Name	kcaban	WKP Name	NO\$NAME

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DATUM_A		PLA					
	FLATNS	0.00023	0.00000	0.00100	0.00000	0.00023	
DATUM_B		CYL					
	DM	0.37510	0.37500	0.00050	-0.00050	0.00010	
CYL_B		CYL					
	CYLFRM	0.00022	0.00000	0.00050	0.00000	0.00022	
SQR_B		AXI					
	SQRNES	0.00005	0.00000	0.00100	0.00000	0.00005	
FEATURE(1)		CYL					
	DM	0.99768	0.99800	0.00000	-0.00100	-0.00032	
FEATURE(2)		AXI					
	RADRUN	0.00022	0.00000	0.00100	0.00000	0.00022	
FEATURE(3)		PLA					
	Z	0.29600	0.29600	0.00500	-0.00500	0.00000	
FEATURE(6)		CYL					
	FORM	0.00002					
	DM	0.28060	0.28100	0.00500	-0.00500	-0.00040	
	X	-0.00547	0.00000			0.00547	
	Y	0.89808	0.90000			-0.00192	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01170	0.00000	0.03458	0.00000	0.01170	
FEATURE(7)		CYL					
	FORM	0.00003					
	DM	0.28050	0.28100	0.00500	-0.00500	-0.00050	
	X	-0.64063	0.63630			0.00433	
	Y	0.63120	0.63630			-0.00510	
POS_FEATURE(7)		AXI					
	POSITN			0.03000			

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 21-Oct-09, 10:30:04		NO\$NAME				Page 1 of 9	

Date: 21-Oct-09, 10:30:04			NO\$NAME			Page 2 of 9	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

POS_FEATURE(7)		AXI					
POSMMC	0.01367	0.00000	0.03448	0.00000	0.01367		

FEATURE(8)		CYL					
FORM	0.00006						
DM	0.28044	0.28100	0.00500	-0.00500	-0.00056		
X	-0.90029	0.90000			0.00029		
Y	-0.00646	0.00000			0.00646		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01316	0.00000	0.03438	0.00000	0.01316		

FEATURE(9)		CYL					
FORM	0.00003						
DM	0.28052	0.28100	0.00500	-0.00500	-0.00048		
X	-0.63263	0.63630			-0.00367		
Y	-0.64151	0.63630			0.00521		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01297	0.00000	0.03449	0.00000	0.01297		

FEATURE(10)		CYL					
FORM	0.00004						
DM	0.28056	0.28100	0.00500	-0.00500	-0.00044		
X	0.00554	0.00000			0.00554		
Y	-0.90151	0.90000			0.00151		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.01178	0.00000	0.03452	0.00000	0.01178		

FEATURE(11)		CYL					
FORM	0.00004						
DM	0.28055	0.28100	0.00500	-0.00500	-0.00045		
X	0.63989	0.63630			0.00359		
Y	-0.63449	0.63630			-0.00181		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.00869	0.00000	0.03451	0.00000	0.00869		

FEATURE(12)		CYL					
FORM	0.00001						
DM	0.28052	0.28100	0.00500	-0.00500	-0.00048		
X	0.89949	0.90000			-0.00051		
Y	0.00357	0.00000			0.00357		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00723	0.00000	0.03451	0.00000	0.00723		

FEATURE(13)		CYL					
FORM	0.00001						
DM	0.28055	0.28100	0.00500	-0.00500	-0.00045		
X	0.63224	0.63630			-0.00406		
Y	0.63863	0.63630			0.00233		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 21-Oct-09, 10:30:04			NO\$NAME			Page 2 of 9	

Date: 21-Oct-09, 10:30:04			NO\$NAME			Page 3 of 9	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
POS_FEATURE(13)			AXI				
	POSITN			0.03000			
	POSMMC	0.00944	0.00000	0.03454	0.00000	0.00944	
FEATURE(14)			CYL				
	FORM	0.00050					
	DM	3.49981	3.50000	0.00500	-0.00500	-0.00019	
FEATURE(15)			AXI				
	RADRUN	0.00051	0.00000	0.00100	0.00000	0.00051	
FEATURE(4)			CIR				
	DM	0.37599	0.37500	0.00500	-0.00500	0.00099	
FEATURE(5)			AXI				
	DY	-1.37126	1.37000	0.01000	-0.01000	0.00126	
FEATURE(16)			CIR				
	FORM	0.00023					
	DM	0.37678	0.37500	0.00500	-0.00500	0.00178	
FEATURE(17)			AXI				
	DZ	-0.47783	0.48000	0.01000	-0.01000	-0.00217	
FEATURE(18)			CIR				
	FORM	0.00033					
	DM	0.47028	0.46900	0.00200	0.00000	0.00128	
FEATURE_18A			AXI				
	DY	-0.06108	0.06000	0.01000	-0.01000	0.00108	
FEATURE_18B			AXI				
	DY	0.38103	0.38000	0.01000	-0.01000	0.00103	
FEA_20(1)			AXI				
	DY	-0.06175	0.06000	0.01000	-0.01000	0.00175	
POS\$FEA_20(1)			AXI				
	POSITN	0.00278	0.00000	0.01000	0.00000	0.00278	
FEA_20(2)			AXI				
	DX	0.06150	0.06000	0.01000	-0.01000	0.00150	
POS\$FEA_20(2)			AXI				
	POSITN	0.00022	0.00000	0.01000	0.00000	0.00022	
FEA_20(3)			AXI				
	DY	-0.06185	0.06000	0.01000	-0.01000	0.00185	
POS\$FEA_20(3)			AXI				
	POSITN	0.00288	0.00000	0.01000	0.00000	0.00288	
FEA_20(4)			AXI				
	DX	0.06150	0.06000	0.01000	-0.01000	0.00150	
POS\$FEA_20(4)			AXI				
	POSITN	0.00019	0.00000	0.01000	0.00000	0.00019	
FEAT_21(1)			AXI				
	DZ	0.07123	0.07000	0.01000	-0.01000	0.00123	

Date: 21-Oct-09, 10:30:04			NO\$NAME			Page 4 of 9	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
FEAT_21(2)			AXI				
DZ		0.07113	0.07000	0.01000	-0.01000	0.00113	
FEAT_21(3)			AXI				
DZ		0.07114	0.07000	0.01000	-0.01000	0.00114	
FEAT_21(4)			AXI				
DZ		0.07134	0.07000	0.01000	-0.01000	0.00134	
DAT_B_OP			CYL				
DM		0.37512					
FORM		0.00007					
FEATURE(22)			PLA				
FORM		0.00005					
Z		-2.26269					
FEATURE(23)			PLA				
PARALL		0.00024	0.00000	0.00100	0.00000	0.00024	
FEA(24)			PLA				
Z		-2.49818	2.49700	0.00200	0.00000	0.00118	
FORM		0.00003					
FEATURE(24)			PLA				
PARALL		0.00008	0.00000	0.00100	0.00000	0.00008	
FEATURE(25)			AXI				
DZ		-0.23549	0.23500	0.00100	0.00000	0.00049	
FEATURE(26)			AXI				
Z		-2.49818	2.49700	0.00200	0.00000	0.00118	
FEATURE(27)			AXI				
DZ		-0.07910	0.08000	0.01000	-0.01000	-0.00090	
FEATURE(28)			CIR				
FORM		0.00021					
DM		3.29760	3.30000	0.01000	-0.01000	-0.00240	
FEAT(28)			AXI				
RADRUN		0.00021	0.00000	0.00500	0.00000	0.00021	
FEATURE(30)			CYL				
FORM		0.00047					
DM		0.99729	0.99800	0.00000	-0.00100	-0.00071	
FEATURE(31)			AXI				
RADRUN		0.00048	0.00000	0.00100	0.00000	0.00048	
FEATURE(32)			AXI				
RADRUN		0.00031	0.00000	0.00100	0.00000	0.00031	
FEATURE(29)			TOR				
FORM		0.00071					
Cir_RA		0.04976	0.05000	0.00050	-0.00050	-0.00024	
OUT_DM		0.57365	0.57500	0.00100	-0.00100	-0.00135	
INN_DM		0.37461	0.37500			-0.00039	
X		0.00001					
Y		-0.00010					

-0.00035

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 21-Oct-09, 10:30:04			NO\$NAME			Page 4 of 9	

Date: 21-Oct-09, 10:30:04			NO\$NAME			Page 5 of 9	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic


FEA(33)

PLA

FORM 0.00013
 Z -2.54782


FEATURE(34)

AXI

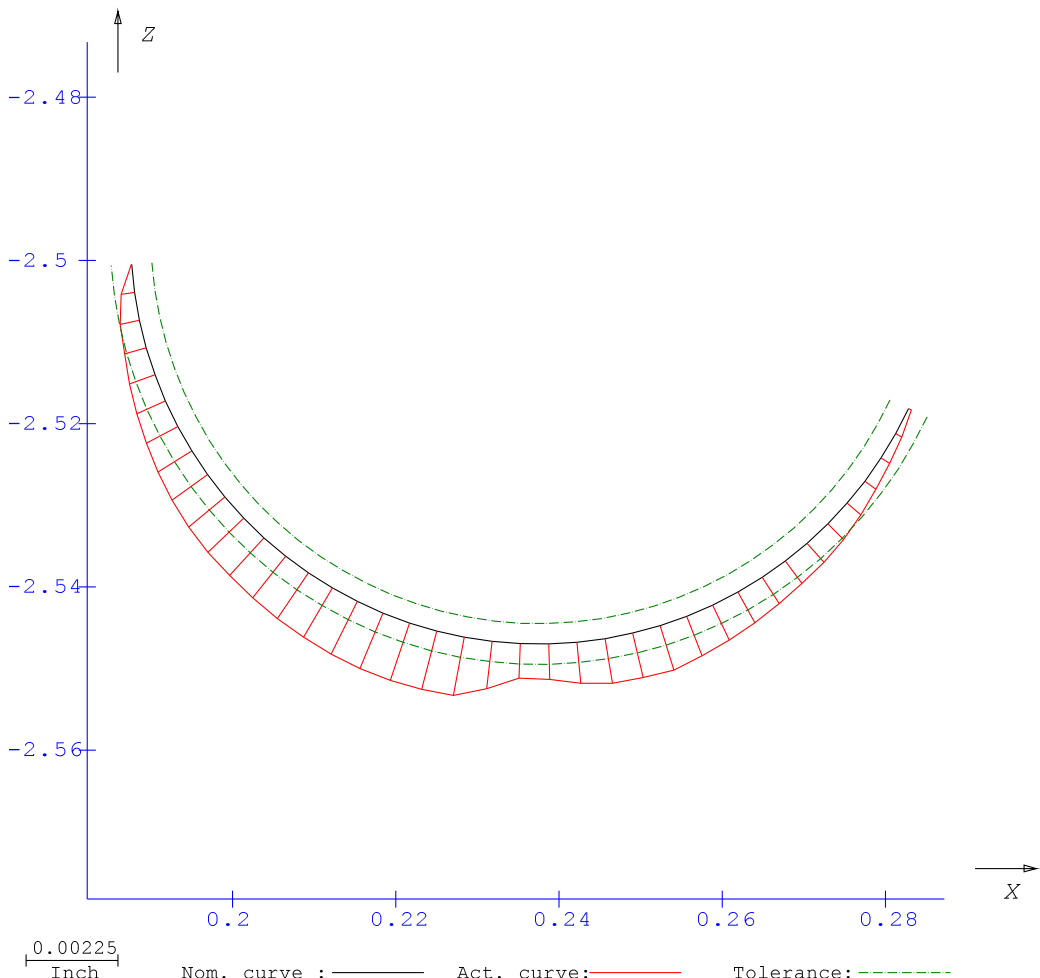
DZ 0.04964 0.05000 0.00050 -0.00050 -0.00036 

FEATURE(41)

CIR

FORM 0.00025
 RA 0.01699 0.01600 0.00200 -0.00200 0.00099 

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 21-Oct-09, 10:30:04			NO\$NAME			Page 5 of 9	



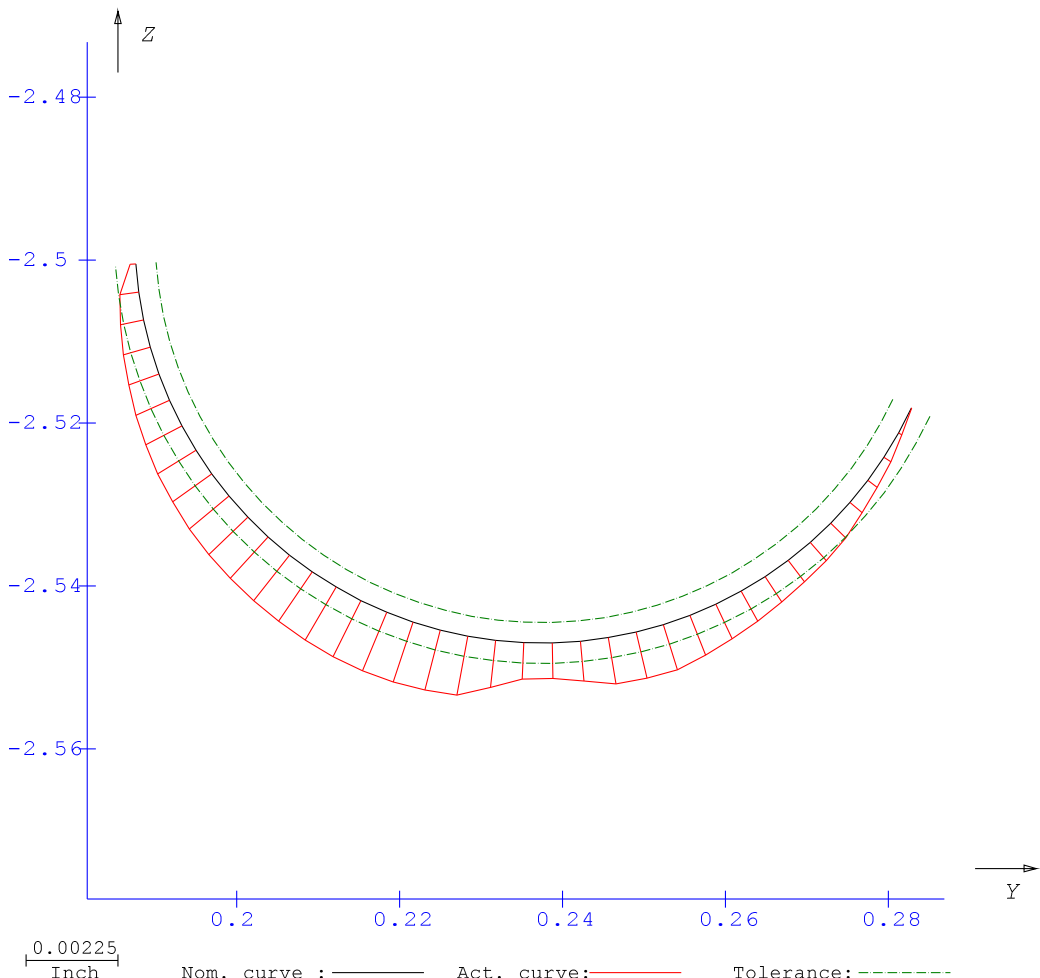
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

	X	Y	Z	Nr.		
Form	0.00148	Min. Deviat.:-0.00148	0.22167	0.00000	-2.54443	22
Lower Toler. :	-0.00050	Max. Deviat.:-0.00001	0.18762	0.00000	-2.50047	39
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 0°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban
 Date:21-OCT-2009
 Time:10:30:01



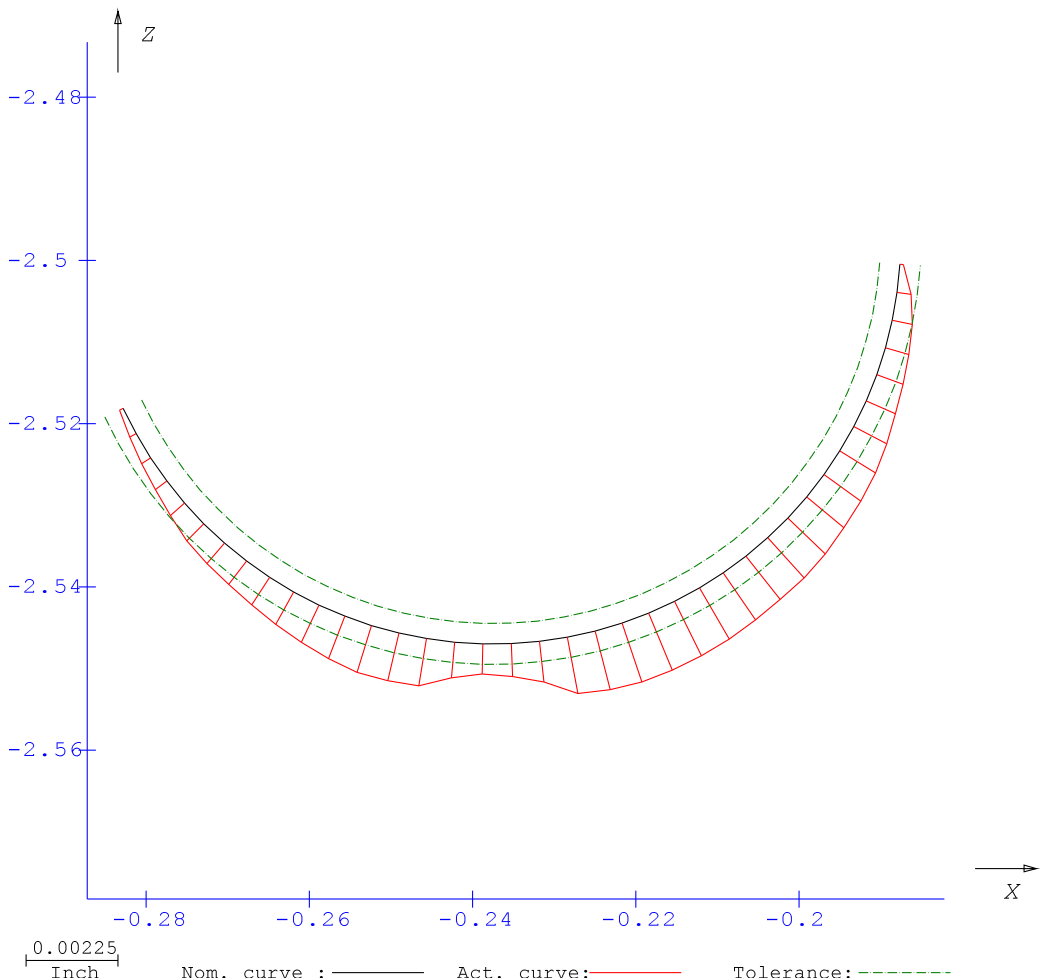
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

	X	Y	Z	Nr.
Form	0.00154	0.00000	-2.51813	1
Lower Toler. :-	-0.00050	0.00000	-2.54322	23
Upper Toler. :	0.00050			
Error Magnif.:	5	Profile of Radius 0.0500 @ 90°		
No. of points:	39			



2D - CONTOUR

Inspector.:kcaban
 Date:21-OCT-2009
 Time:10:30:01



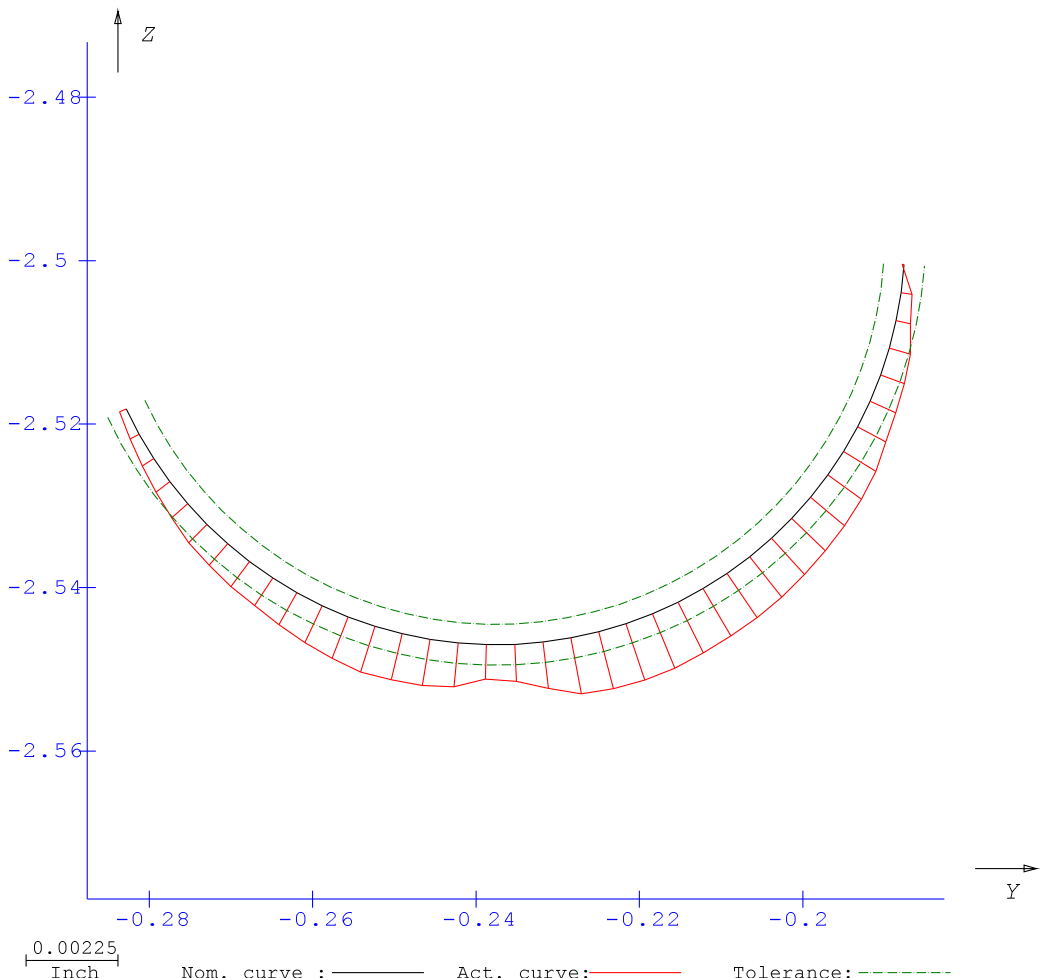
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.		
Form	0.00144	Min. Deviat.:	0.00008	-0.18762	0.00000	-2.50047	39
Lower Toler. :	-0.00050	Max. Deviat.:	0.00152	-0.22167	0.00000	-2.54443	22
Upper Toler. :	0.00050	Profile of Radius 0.0500					
Error Magnif.:	5	@ 180°					
No. of points:	39						



2D - CONTOUR

Inspector.:kcaban
 Date:21-OCT-2009
 Time:10:30:01



Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.		
Form	0.00150	Min. Deviat.:-0.00005	0.00000	-0.18762	-2.50047	39	
Lower Toler. :	-0.00050	Max. Deviat.:	0.00145	0.00000	-0.22167	-2.54443	22
Upper Toler. :	0.00050	Profile of Radius 0.0500					
Error Magnif.:	5	@ 270°					
No. of points:	39						



2D - CONTOUR

Inspector.:kcaban
 Date:21-OCT-2009
 Time:10:30:01