

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	003
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	710008	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	21-OCT-2009, 12:43:54
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	0.00020	0.00000	0.00100	0.00000	0.00020	
DATUM_B		CYL					
	DM	0.37496	0.37500	0.00050	-0.00050	-0.00004	
CYL_B		CYL					
	CYLFRM	0.00014	0.00000	0.00050	0.00000	0.00014	
SQR_B		AXI					
	SQRNES	0.00005	0.00000	0.00100	0.00000	0.00005	
FEATURE(1)		CYL					
	DM	0.99762	0.99800	0.00000	-0.00100	-0.00038	
FEATURE(2)		AXI					
	RADRUN	0.00011	0.00000	0.00100	0.00000	0.00011	
FEATURE(3)		PLA					
	Z	0.29595	0.29600	0.00500	-0.00500	-0.00005	
FEATURE(6)		CYL					
	FORM	0.00002					
	DM	0.28070	0.28100	0.00500	-0.00500	-0.00030	
	X	-0.00601	0.00000			0.00601	
	Y	0.89878	0.90000			-0.00122	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01230	0.00000	0.03468	0.00000	0.01230	
FEATURE(7)		CYL					
	FORM	0.00005					
	DM	0.28056	0.28100	0.00500	-0.00500	-0.00044	
	X	-0.64045	0.63630			0.00415	
	Y	0.63151	0.63630			-0.00479	
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	0.01279	0.00000	0.03453	0.00000	0.01279		

FEATURE(8)		CYL					
FORM	0.00002						
DM	0.28062	0.28100	0.00500	-0.00500	-0.00038		
X	-0.90051	0.90000			0.00051		
Y	-0.00632	0.00000			0.00632		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01278	0.00000	0.03460	0.00000	0.01278		

FEATURE(9)		CYL					
FORM	0.00002						
DM	0.28063	0.28100	0.00500	-0.00500	-0.00037		
X	-0.63290	0.63630			-0.00340		
Y	-0.64112	0.63630			0.00482		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01197	0.00000	0.03461	0.00000	0.01197		

FEATURE(10)		CYL					
FORM	0.00005						
DM	0.28066	0.28100	0.00500	-0.00500	-0.00034		
X	0.00484	0.00000			0.00484		
Y	-0.90123	0.90000			0.00123		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.01006	0.00000	0.03461	0.00000	0.01006		

FEATURE(11)		CYL					
FORM	0.00003						
DM	0.28065	0.28100	0.00500	-0.00500	-0.00035		
X	0.63983	0.63630			0.00353		
Y	-0.63385	0.63630			-0.00245		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.00866	0.00000	0.03462	0.00000	0.00866		

FEATURE(12)		CYL					
FORM	0.00003						
DM	0.28064	0.28100	0.00500	-0.00500	-0.00036		
X	0.89976	0.90000			-0.00024		
Y	0.00428	0.00000			0.00428		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00864	0.00000	0.03462	0.00000	0.00864		

FEATURE(13)		CYL					
FORM	0.00001						
DM	0.28066	0.28100	0.00500	-0.00500	-0.00034		
X	0.63236	0.63630			-0.00394		
Y	0.63904	0.63630			0.00274		

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(13)		AXI					
	POSITN			0.03000			
	POSMMC	0.00967	0.00000	0.03465	0.00000	0.00967	
FEATURE(14)		CYL					
	FORM	0.00050					
	DM	3.50039	3.50000	0.00500	-0.00500	0.00039	
FEATURE(15)		AXI					
	RADRUN	0.00052	0.00000	0.00100	0.00000	0.00052	
FEATURE(4)		CIR					
	DM	0.37606	0.37500	0.00500	-0.00500	0.00106	
FEATURE(5)		AXI					
	DY	-1.37092	1.37000	0.01000	-0.01000	0.00092	
FEATURE(16)		CIR					
	FORM	0.00021					
	DM	0.37674	0.37500	0.00500	-0.00500	0.00174	
FEATURE(17)		AXI					
	DZ	-0.47874	0.48000	0.01000	-0.01000	-0.00126	
FEATURE(18)		CIR					
	FORM	0.00028					
	DM	0.47025	0.46900	0.00200	0.00000	0.00125	
FEATURE_18A		AXI					
	DY	-0.06179	0.06000	0.01000	-0.01000	0.00179	
FEATURE_18B		AXI					
	DY	0.38182	0.38000	0.01000	-0.01000	0.00182	
FEA_20(1)		AXI					
	DY	-0.06181	0.06000	0.01000	-0.01000	0.00181	
POS\$FEA_20(1)		AXI					
	POSITN	0.00234	0.00000	0.01000	0.00000	0.00234	
FEA_20(2)		AXI					
	DX	0.06143	0.06000	0.01000	-0.01000	0.00143	
POS\$FEA_20(2)		AXI					
	POSITN	0.00000	0.00000	0.01000	0.00000	0.00000	
FEA_20(3)		AXI					
	DY	-0.06182	0.06000	0.01000	-0.01000	0.00182	
POS\$FEA_20(3)		AXI					
	POSITN	0.00240	0.00000	0.01000	0.00000	0.00240	
FEA_20(4)		AXI					
	DX	0.06150	0.06000	0.01000	-0.01000	0.00150	
POS\$FEA_20(4)		AXI					
	POSITN	0.00010	0.00000	0.01000	0.00000	0.00010	
FEAT_21(1)		AXI					
	DZ	0.06954	0.07000	0.01000	-0.01000	-0.00046	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
FEAT_21(2)			AXI				
DZ		0.06950	0.07000	0.01000	-0.01000	-0.00050	
FEAT_21(3)			AXI				
DZ		0.06958	0.07000	0.01000	-0.01000	-0.00042	
FEAT_21(4)			AXI				
DZ		0.06968	0.07000	0.01000	-0.01000	-0.00032	
DAT_B_OP			CYL				
DM		0.37494					
FORM		0.00007					
FEATURE(22)			PLA				
FORM		0.00005					
Z		-2.26140					
FEATURE(23)			PLA				
PARALL		0.00006	0.00000	0.00100	0.00000	0.00006	
FEA(24)			PLA				
Z		-2.49682	2.49700	0.00200	0.00000	-0.00018	-0.00018 ◀
FORM		0.00012					
FEATURE(24)			PLA				
PARALL		0.00014	0.00000	0.00100	0.00000	0.00014	
FEATURE(25)			AXI				
DZ		-0.23542	0.23500	0.00100	0.00000	0.00042	
FEATURE(26)			AXI				
Z		-2.49682	2.49700	0.00200	0.00000	-0.00018	-0.00018 ◀
FEATURE(27)			AXI				
DZ		-0.07943	0.08000	0.01000	-0.01000	-0.00057	
FEATURE(28)			CIR				
FORM		0.00006					
DM		3.29975	3.30000	0.01000	-0.01000	-0.00025	
FEAT(28)			AXI				
RADRUN		0.00012	0.00000	0.00500	0.00000	0.00012	
FEATURE(30)			CYL				
FORM		0.00006					
DM		0.99737	0.99800	0.00000	-0.00100	-0.00063	
FEATURE(31)			AXI				
RADRUN		0.00014	0.00000	0.00100	0.00000	0.00014	
FEATURE(32)			AXI				
RADRUN		0.00027	0.00000	0.00100	0.00000	0.00027	
FEATURE(29)			TOR				
FORM		0.00094					
Cir_RA		0.05002	0.05000	0.00050	-0.00050	0.00002	
OUT_DM		0.57433	0.57500	0.00100	-0.00100	-0.00067	
INN_DM		0.37424	0.37500			-0.00076	
X		-0.00002					
Y		-0.00001					

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

FEA(33)

PLA

FORM 0.00009
 Z -2.54631


FEATURE(34)

AXI

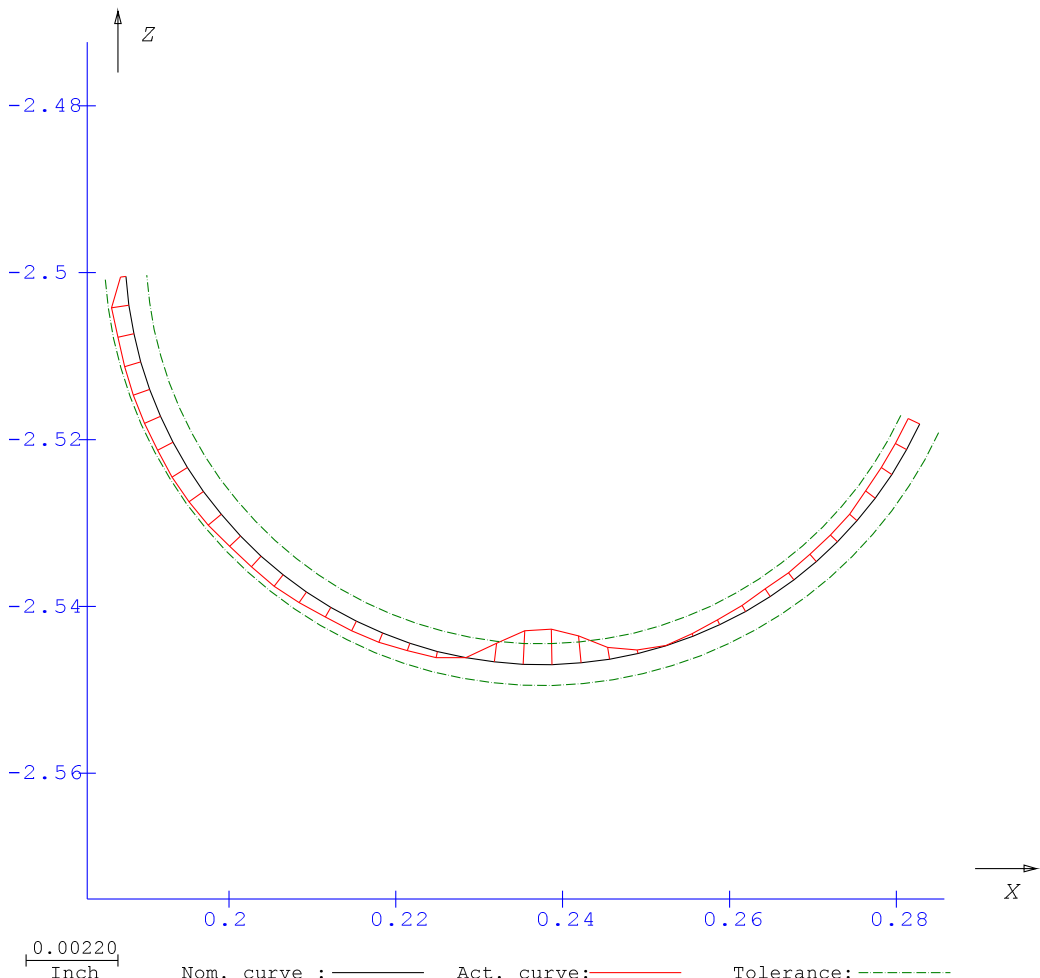
DZ 0.04949 0.05000 0.00050 -0.00050 -0.00051 -0.00001 ◀

FEATURE(41)

CIR

FORM 0.00018
 RA 0.01677 0.01600 0.00200 -0.00200 0.00077 

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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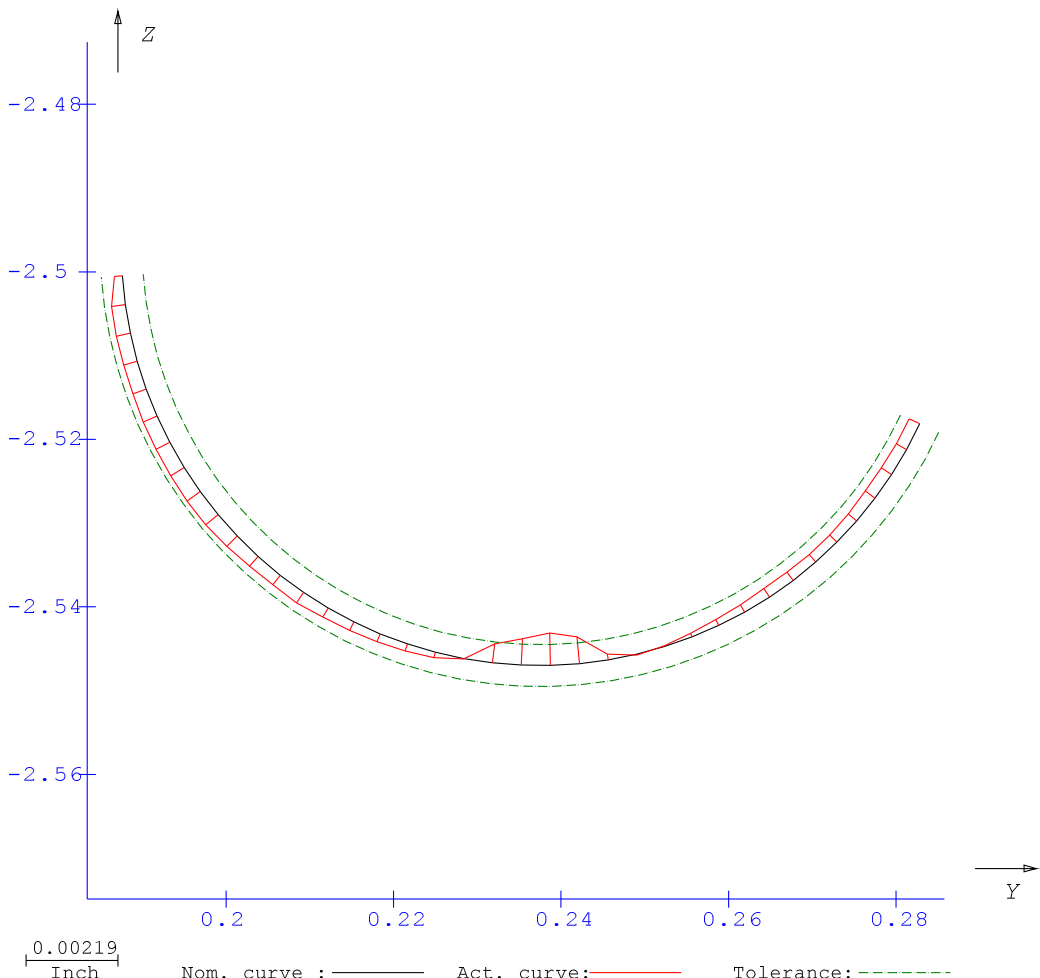
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 003 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

		X	Y	Z	Nr.	
Form	0.00129	Min. Deviat.:-0.00044	0.19500	0.00000	-2.52334	32
Lower Toler. :	-0.00050	Max. Deviat.: 0.00085	0.23873	0.00000	-2.54698	17
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 0°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban
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Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 003 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

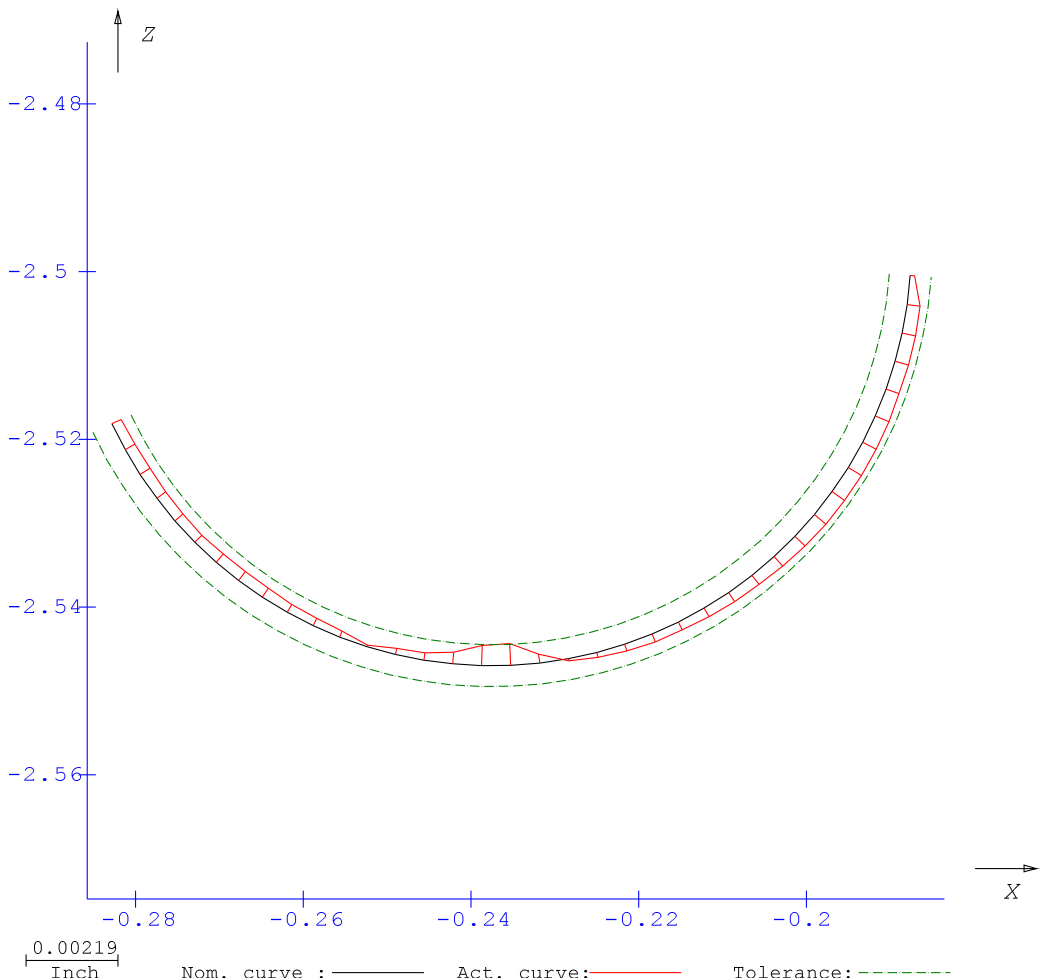
	X	Y	Z	Nr.
Form	0.00116	0.00000	-2.54698	17
Lower Toler. :	-0.00050	0.00000	-2.52897	30
Upper Toler. :	0.00050			
Error Magnif.:	5			
No. of points:	39			

Min. Deviat.: -0.00077 Profile of Radius 0.0500
 Max. Deviat.: 0.00039 @ 90°



2D - CONTOUR

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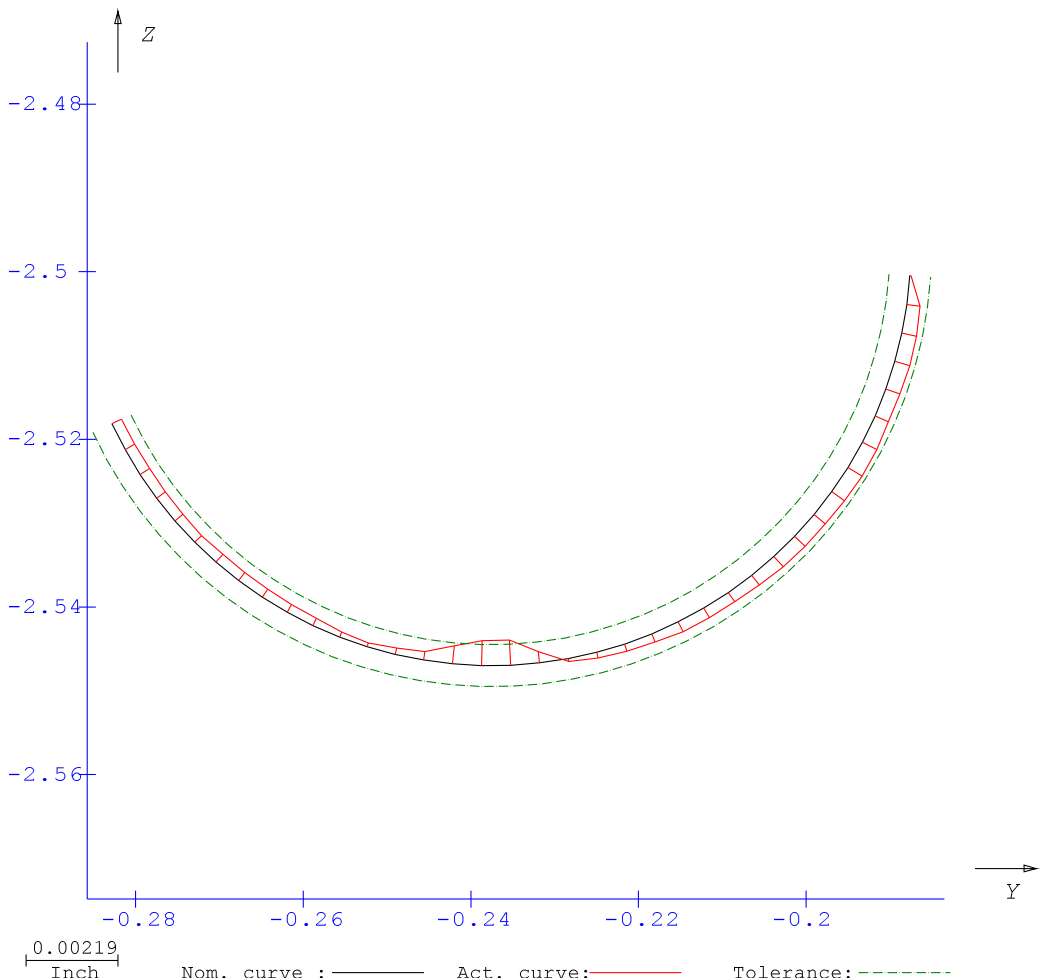
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 003 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.	
Form	0.00088	Min. Deviat.:-0.00052	-0.23526	0.00000	-2.54695	18
Lower Toler. :	-0.00050	Max. Deviat.: 0.00037	-0.19500	0.00000	-2.52334	32
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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Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 003 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

	X	Y	Z	Nr.		
Form	0.00101	Min. Deviat.:-0.00061	0.00000	-0.23526	-2.54695	18
Lower Toler. :	-0.00050	Max. Deviat.: 0.00040	0.00000	-0.19500	-2.52334	32
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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