

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	004
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	718203	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	21-OCT-2009, 13:46:28
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	0.37503	0.37500	0.00050	-0.00050	0.00003	
CYL_B		CYL					
	CYLFRM	0.00014	0.00000	0.00050	0.00000	0.00014	
SQR_B		AXI					
	SQRNES	0.00011	0.00000	0.00100	0.00000	0.00011	
FEATURE(1)		CYL					
	DM	0.99765	0.99800	0.00000	-0.00100	-0.00035	
FEATURE(2)		AXI					
	RADRUN	0.00023	0.00000	0.00100	0.00000	0.00023	
FEATURE(3)		PLA					
	Z	0.29595	0.29600	0.00500	-0.00500	-0.00005	
FEATURE(6)		CYL					
	FORM	0.00043					
	DM	0.28126	0.28100	0.00500	-0.00500	0.00026	
	X	-0.00540	0.00000			0.00540	
	Y	0.89876	0.90000			-0.00124	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01187	0.00000	0.03480	0.00000	0.01187	
FEATURE(7)		CYL					
	FORM	0.00002					
	DM	0.28074	0.28100	0.00500	-0.00500	-0.00026	
	X	-0.64041	0.63630			0.00411	
	Y	0.63186	0.63630			-0.00444	
POS_FEATURE(7)		AXI					
	POSITN			0.03000			

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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POS_FEATURE(7)		AXI					
POSMMC	0.01212	0.00000	0.03472	0.00000	0.01212		

FEATURE(8)		CYL					
FORM	0.00002						
DM	0.28075	0.28100	0.00500	-0.00500	-0.00025		
X	-0.90038	0.90000			0.00038		
Y	-0.00612	0.00000			0.00612		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01234	0.00000	0.03474	0.00000	0.01234		

FEATURE(9)		CYL					
FORM	0.00002						
DM	0.28078	0.28100	0.00500	-0.00500	-0.00022		
X	-0.63317	0.63630			-0.00313		
Y	-0.64082	0.63630			0.00452		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01115	0.00000	0.03476	0.00000	0.01115		

FEATURE(10)		CYL					
FORM	0.00005						
DM	0.28081	0.28100	0.00500	-0.00500	-0.00019		
X	0.00478	0.00000			0.00478		
Y	-0.90103	0.90000			0.00103		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.00992	0.00000	0.03476	0.00000	0.00992		

FEATURE(11)		CYL					
FORM	0.00002						
DM	0.28081	0.28100	0.00500	-0.00500	-0.00019		
X	0.63957	0.63630			0.00327		
Y	-0.63364	0.63630			-0.00266		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.00856	0.00000	0.03478	0.00000	0.00856		

FEATURE(12)		CYL					
FORM	0.00003						
DM	0.28084	0.28100	0.00500	-0.00500	-0.00016		
X	0.89934	0.90000			-0.00066		
Y	0.00443	0.00000			0.00443		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00901	0.00000	0.03481	0.00000	0.00901		

FEATURE(13)		CYL					
FORM	0.00001						
DM	0.28084	0.28100	0.00500	-0.00500	-0.00016		
X	0.63209	0.63630			-0.00421		
Y	0.63929	0.63630			0.00299		

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
POS_FEATURE(13)		AXI					
	POSITN			0.03000			
	POSMMC	0.01033	0.00000	0.03483	0.00000	0.01033	
FEATURE(14)		CYL					
	FORM	0.00042					
	DM	3.50013	3.50000	0.00500	-0.00500	0.00013	
FEATURE(15)		AXI					
	RADRUN	0.00047	0.00000	0.00100	0.00000	0.00047	
FEATURE(4)		CIR					
	DM	0.37612	0.37500	0.00500	-0.00500	0.00112	
FEATURE(5)		AXI					
	DY	-1.37102	1.37000	0.01000	-0.01000	0.00102	
FEATURE(16)		CIR					
	FORM	0.00021					
	DM	0.37675	0.37500	0.00500	-0.00500	0.00175	
FEATURE(17)		AXI					
	DZ	-0.47918	0.48000	0.01000	-0.01000	-0.00082	
FEATURE(18)		CIR					
	FORM	0.00027					
	DM	0.47024	0.46900	0.00200	0.00000	0.00124	
FEATURE_18A		AXI					
	DY	-0.06197	0.06000	0.01000	-0.01000	0.00197	
FEATURE_18B		AXI					
	DY	0.38193	0.38000	0.01000	-0.01000	0.00193	
FEA_20(1)		AXI					
	DY	-0.06183	0.06000	0.01000	-0.01000	0.00183	
POS\$FEA_20(1)		AXI					
	POSITN	0.00260	0.00000	0.01000	0.00000	0.00260	
FEA_20(2)		AXI					
	DX	0.06149	0.06000	0.01000	-0.01000	0.00149	
POS\$FEA_20(2)		AXI					
	POSITN	0.00015	0.00000	0.01000	0.00000	0.00015	
FEA_20(3)		AXI					
	DY	-0.06182	0.06000	0.01000	-0.01000	0.00182	
POS\$FEA_20(3)		AXI					
	POSITN	0.00242	0.00000	0.01000	0.00000	0.00242	
FEA_20(4)		AXI					
	DX	0.06163	0.06000	0.01000	-0.01000	0.00163	
POS\$FEA_20(4)		AXI					
	POSITN	0.00011	0.00000	0.01000	0.00000	0.00011	
FEAT_21(1)		AXI					
	DZ	0.06926	0.07000	0.01000	-0.01000	-0.00074	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
FEAT_21(2)			AXI				
DZ		0.06917	0.07000	0.01000	-0.01000	-0.00083	
FEAT_21(3)			AXI				
DZ		0.06920	0.07000	0.01000	-0.01000	-0.00080	
FEAT_21(4)			AXI				
DZ		0.06930	0.07000	0.01000	-0.01000	-0.00070	
DAT_B_OP			CYL				
DM		0.37504					
FORM		0.00016					
FEATURE(22)			PLA				
FORM		0.00004					
Z		-2.26143					
FEATURE(23)			PLA				
PARALL		0.00025	0.00000	0.00100	0.00000	0.00025	
FEA(24)			PLA				
Z		-2.49685	2.49700	0.00200	0.00000	-0.00015	-0.00015 ◀
FORM		0.00007					
FEATURE(24)			PLA				
PARALL		0.00011	0.00000	0.00100	0.00000	0.00011	
FEATURE(25)			AXI				
DZ		-0.23542	0.23500	0.00100	0.00000	0.00042	
FEATURE(26)			AXI				
Z		-2.49685	2.49700	0.00200	0.00000	-0.00015	-0.00015 ◀
FEATURE(27)			AXI				
DZ		-0.07906	0.08000	0.01000	-0.01000	-0.00094	
FEATURE(28)			CIR				
FORM		0.00007					
DM		3.29796	3.30000	0.01000	-0.01000	-0.00204	
FEAT(28)			AXI				
RADRUN		0.00017	0.00000	0.00500	0.00000	0.00017	
FEATURE(30)			CYL				
FORM		0.00007					
DM		0.99754	0.99800	0.00000	-0.00100	-0.00046	
FEATURE(31)			AXI				
RADRUN		0.00013	0.00000	0.00100	0.00000	0.00013	
FEATURE(32)			AXI				
RADRUN		0.00034	0.00000	0.00100	0.00000	0.00034	
FEATURE(29)			TOR				
FORM		0.00089					
Cir_RA		0.04991	0.05000	0.00050	-0.00050	-0.00009	
OUT_DM		0.57437	0.57500	0.00100	-0.00100	-0.00063	
INN_DM		0.37472	0.37500			-0.00028	
X		-0.00006					
Y		-0.00003					

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


FEA(33)

PLA

FORM 0.00011
 Z -2.54636


FEATURE(34)

AXI

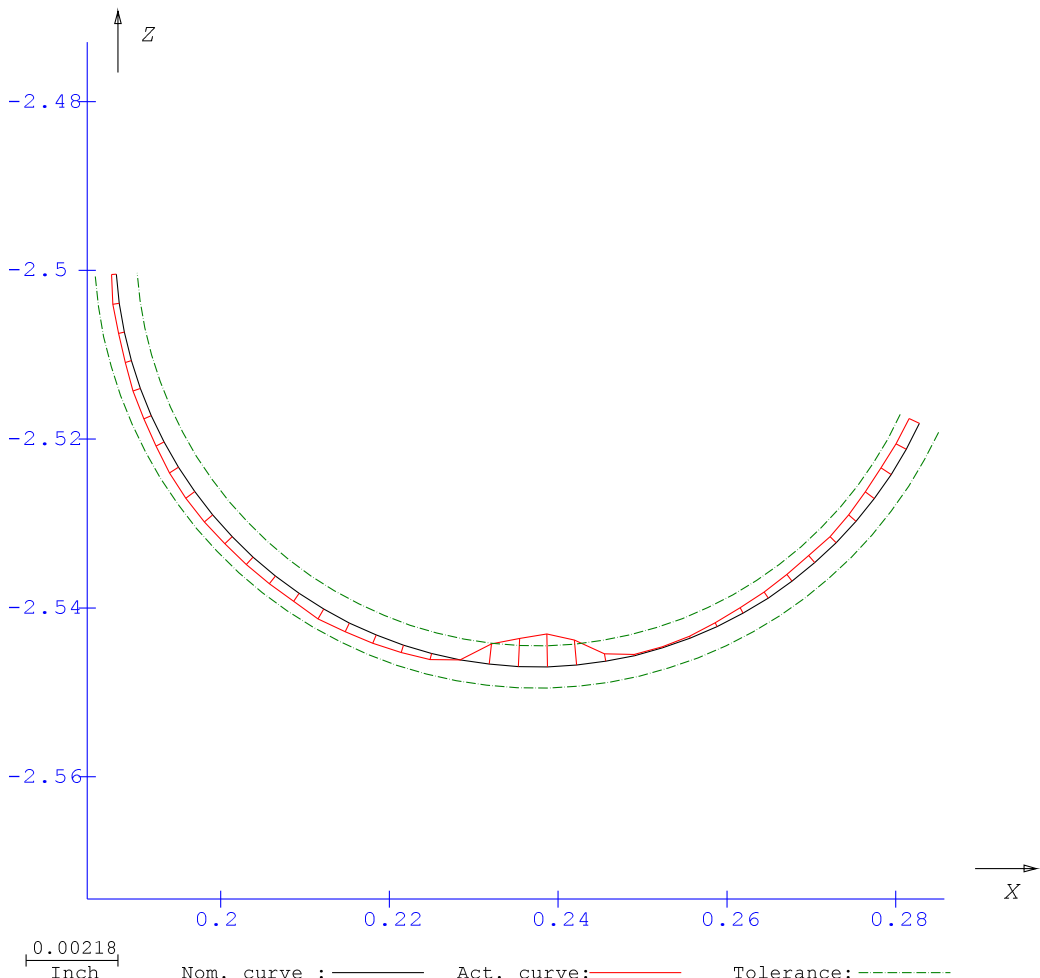
DZ 0.04951 0.05000 0.00050 -0.00050 -0.00049 

FEATURE(41)

CIR

FORM 0.00022
 RA 0.01681 0.01600 0.00200 -0.00200 0.00081 

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

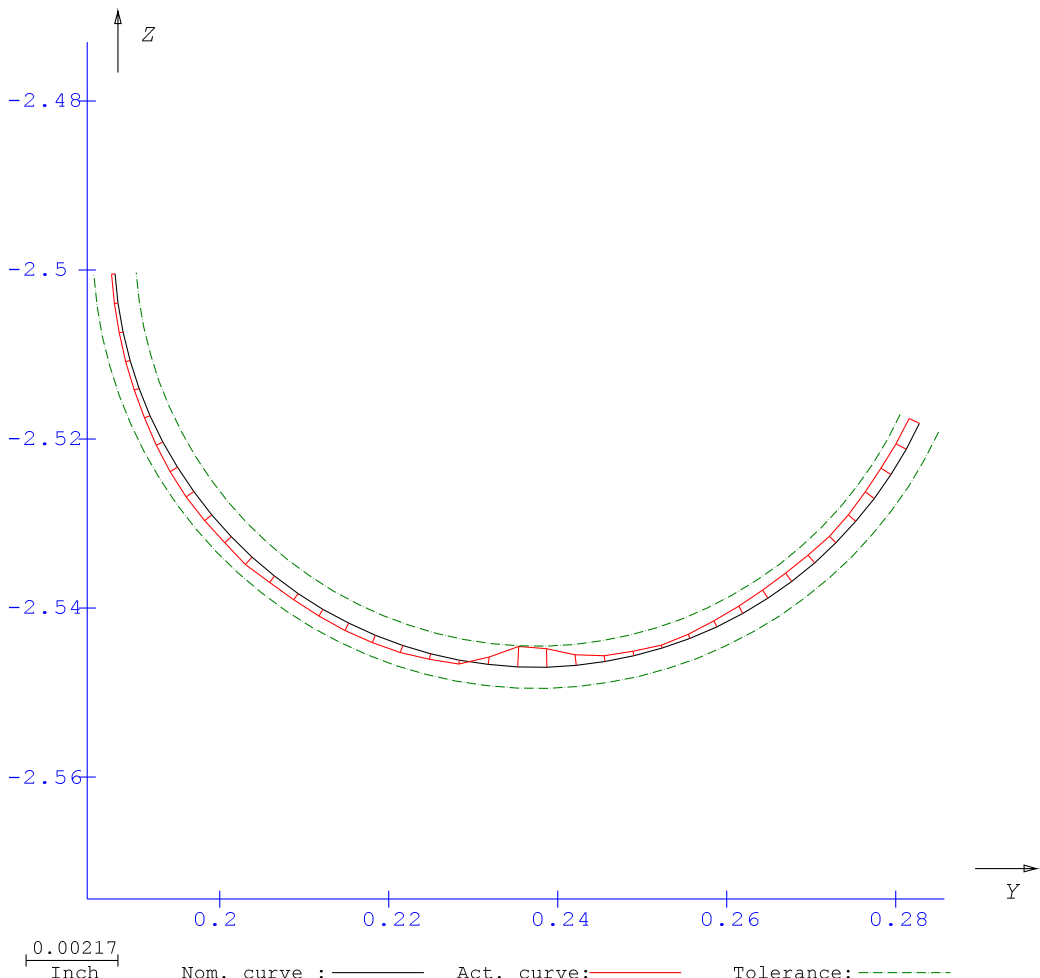
		X	Y	Z	Nr.
Form	0.00105	0.21221	0.00000	-2.54013	25
Lower Toler. :	-0.00050	0.23873	0.00000	-2.54698	17
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00027 Profile of Radius 0.0500
 Max. Deviat.: 0.00078 @ 0°



2D - CONTOUR

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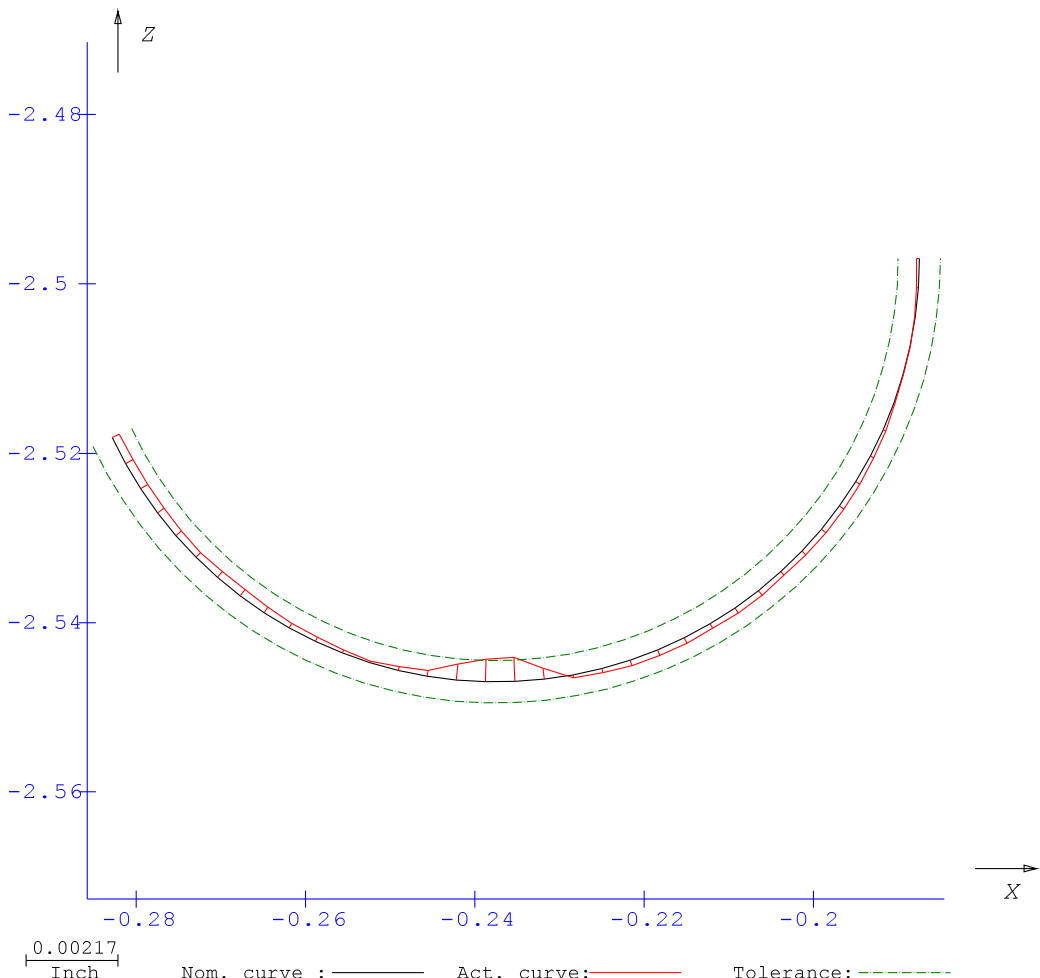
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 004 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

	X	Y	Z	Nr.
Form	0.00071	0.00000	-2.54695	18
Lower Toler. :-	-0.00050	0.00000	-2.53398	28
Upper Toler. :	0.00050	0.00000	-2.53398	28
Error Magnif.:	5	Profile of Radius 0.0500 @ 90°		
No. of points:	39			



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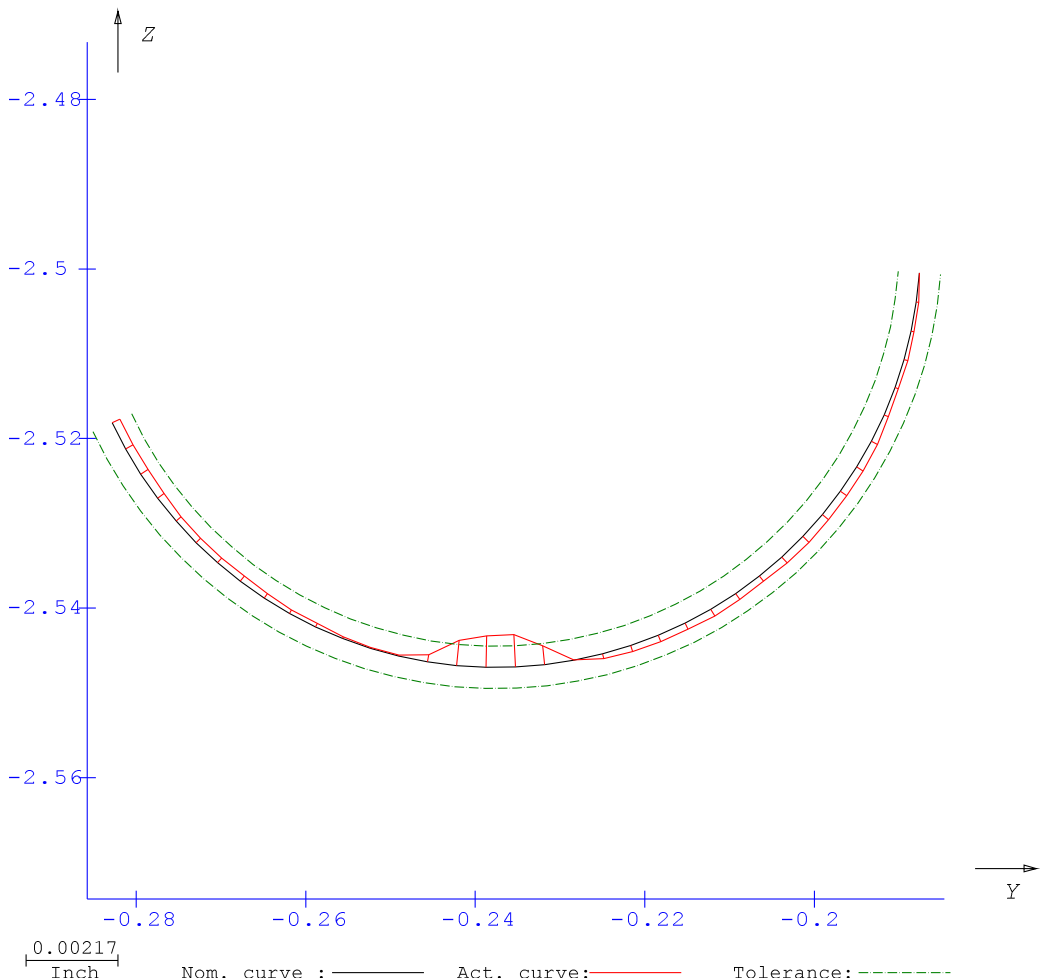
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 004 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.	
Form	0.00072	Min. Deviat.:-0.00057	-0.23526	0.00000	-2.54695	18
Lower Toler. :	-0.00050	Max. Deviat.: 0.00015	-0.21842	0.00000	-2.54322	23
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 180°				
No. of points:	40					



2D - CONTOUR

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Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 004 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.
Form	0.00097	0.00000	-0.23526	-2.54695	18
Lower Toler. :	-0.00050	0.00000	-0.20136	-2.53156	29
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00077 Profile of Radius 0.0500
 Max. Deviat.: 0.00020 @ 270°



2D - CONTOUR

Inspector.:kcaban
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