

# Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	005
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, 14:47:21
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
<b>DATUM_A</b>		<b>PLA</b>					
	FLATNS	0.00028	0.00000	0.00100	0.00000	0.00028	
<b>DATUM_B</b>		<b>CYL</b>					
	DM	0.37503	0.37500	0.00050	-0.00050	0.00003	
<b>CYL_B</b>		<b>CYL</b>					
	CYLFRM	0.00016	0.00000	0.00050	0.00000	0.00016	
<b>SQR_B</b>		<b>AXI</b>					
	SQRNES	0.00003	0.00000	0.00100	0.00000	0.00003	
<b>FEATURE(1)</b>		<b>CYL</b>					
	DM	0.99758	0.99800	0.00000	-0.00100	-0.00042	
<b>FEATURE(2)</b>		<b>AXI</b>					
	RADRUN	0.00014	0.00000	0.00100	0.00000	0.00014	
<b>FEATURE(3)</b>		<b>PLA</b>					
	Z	0.29596	0.29600	0.00500	-0.00500	-0.00004	
<b>FEATURE(6)</b>		<b>CYL</b>					
	FORM	0.00003					
	DM	0.28130	0.28100	0.00500	-0.00500	0.00030	
	X	-0.00529	0.00000			0.00529	
	Y	0.89851	0.90000			-0.00149	
<b>POS_FEATURE(6)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01115	0.00000	0.03527	0.00000	0.01115	
<b>FEATURE(7)</b>		<b>CYL</b>					
	FORM	0.00006					
	DM	0.28127	0.28100	0.00500	-0.00500	0.00027	
	X	-0.63991	0.63630			0.00361	
	Y	0.63102	0.63630			-0.00528	
<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: 22-Oct-09, 12:56:14			NO\$NAME			Page 2 of 9	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>POS_FEATURE(7)</b>		<b>AXI</b>					
	POSMMC	0.01282	0.00000	0.03522	0.00000	0.01282	
<b>FEATURE(8)</b>		<b>CYL</b>					
	FORM	0.00005					
	DM	0.28125	0.28100	0.00500	-0.00500	0.00025	
	X	-0.90034	0.90000			0.00034	
	Y	-0.00686	0.00000			0.00686	
<b>POS_FEATURE(8)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01381	0.00000	0.03522	0.00000	0.01381	
<b>FEATURE(9)</b>		<b>CYL</b>					
	FORM	0.00012					
	DM	0.28123	0.28100	0.00500	-0.00500	0.00023	
	X	-0.63250	0.63630			-0.00380	
	Y	-0.64172	0.63630			0.00542	
<b>POS_FEATURE(9)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01338	0.00000	0.03515	0.00000	0.01338	
<b>FEATURE(10)</b>		<b>CYL</b>					
	FORM	0.00001					
	DM	0.28130	0.28100	0.00500	-0.00500	0.00030	
	X	0.00570	0.00000			0.00570	
	Y	-0.90161	0.90000			0.00161	
<b>POS_FEATURE(10)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01195	0.00000	0.03528	0.00000	0.01195	
<b>FEATURE(11)</b>		<b>CYL</b>					
	FORM	0.00006					
	DM	0.28125	0.28100	0.00500	-0.00500	0.00025	
	X	0.64028	0.63630			0.00398	
	Y	-0.63464	0.63630			-0.00166	
<b>POS_FEATURE(11)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.00868	0.00000	0.03520	0.00000	0.00868	
<b>FEATURE(12)</b>		<b>CYL</b>					
	FORM	0.00005					
	DM	0.28124	0.28100	0.00500	-0.00500	0.00024	
	X	0.89997	0.90000			-0.00003	
	Y	0.00357	0.00000			0.00357	
<b>POS_FEATURE(12)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.00723	0.00000	0.03519	0.00000	0.00723	
<b>FEATURE(13)</b>		<b>CYL</b>					
	FORM	0.00015					
	DM	0.28118	0.28100	0.00500	-0.00500	0.00018	
	X	0.63274	0.63630			-0.00356	
	Y	0.63852	0.63630			0.00222	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Date: 22-Oct-09, 12:56:14			NO\$NAME			Page 3 of 9	
Text	Eva1.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>POS_FEATURE(13)</b>			<b>AXI</b>				
	POSITN			0.03000			
	POSMMC	0.00853	0.00000	0.03506	0.00000	0.00853	
<b>FEATURE(14)</b>			<b>CYL</b>				
	FORM	0.00061					
	DM	3.49987	3.50000	0.00500	-0.00500	-0.00013	
<b>FEATURE(15)</b>			<b>AXI</b>				
	RADRUN	0.00063	0.00000	0.00100	0.00000	0.00063	
<b>FEATURE(4)</b>			<b>CIR</b>				
	DM	0.37596	0.37500	0.00500	-0.00500	0.00096	
<b>FEATURE(5)</b>			<b>AXI</b>				
	DY	-1.37102	1.37000	0.01000	-0.01000	0.00102	
<b>FEATURE(16)</b>			<b>CIR</b>				
	FORM	0.00041					
	DM	0.37653	0.37500	0.00500	-0.00500	0.00153	
<b>FEATURE(17)</b>			<b>AXI</b>				
	DZ	-0.47868	0.48000	0.01000	-0.01000	-0.00132	
<b>FEATURE(18)</b>			<b>CIR</b>				
	FORM	0.00026					
	DM	0.47028	0.46900	0.00200	0.00000	0.00128	
<b>FEATURE_18A</b>			<b>AXI</b>				
	DY	-0.06161	0.06000	0.01000	-0.01000	0.00161	
<b>FEATURE_18B</b>			<b>AXI</b>				
	DY	0.38145	0.38000	0.01000	-0.01000	0.00145	
<b>FEA_20(1)</b>			<b>AXI</b>				
	DY	-0.06187	0.06000	0.01000	-0.01000	0.00187	
<b>POS\$FEA_20(1)</b>			<b>AXI</b>				
	POSITN	0.00202	0.00000	0.01000	0.00000	0.00202	
<b>FEA_20(2)</b>			<b>AXI</b>				
	DX	0.06156	0.06000	0.01000	-0.01000	0.00156	
<b>POS\$FEA_20(2)</b>			<b>AXI</b>				
	POSITN	0.00066	0.00000	0.01000	0.00000	0.00066	
<b>FEA_20(3)</b>			<b>AXI</b>				
	DY	-0.06184	0.06000	0.01000	-0.01000	0.00184	
<b>POS\$FEA_20(3)</b>			<b>AXI</b>				
	POSITN	0.00212	0.00000	0.01000	0.00000	0.00212	
<b>FEA_20(4)</b>			<b>AXI</b>				
	DX	0.06154	0.06000	0.01000	-0.01000	0.00154	
<b>POS\$FEA_20(4)</b>			<b>AXI</b>				
	POSITN	0.00071	0.00000	0.01000	0.00000	0.00071	
<b>FEAT_21(1)</b>			<b>AXI</b>				
	DZ	0.07223	0.07000	0.01000	-0.01000	0.00223	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>FEAT_21(2)</b>			<b>AXI</b>				
DZ		0.07223	0.07000	0.01000	-0.01000	0.00223	
<b>FEAT_21(3)</b>			<b>AXI</b>				
DZ		0.07213	0.07000	0.01000	-0.01000	0.00213	
<b>FEAT_21(4)</b>			<b>AXI</b>				
DZ		0.07222	0.07000	0.01000	-0.01000	0.00222	
<b>DAT_B_OP</b>			<b>CYL</b>				
DM		0.37506					
FORM		0.00007					
<b>FEATURE(22)</b>			<b>PLA</b>				
FORM		0.00005					
Z		-2.26204					
<b>FEATURE(23)</b>			<b>PLA</b>				
PARALL		0.00011	0.00000	0.00100	0.00000	0.00011	
<b>FEA(24)</b>			<b>PLA</b>				
Z		-2.49750	2.49700	0.00200	0.00000	0.00050	
FORM		0.00006					
<b>FEATURE(24)</b>			<b>PLA</b>				
PARALL		0.00006	0.00000	0.00100	0.00000	0.00006	
<b>FEATURE(25)</b>			<b>AXI</b>				
DZ		-0.23546	0.23500	0.00100	0.00000	0.00046	
<b>FEATURE(26)</b>			<b>AXI</b>				
Z		-2.49750	2.49700	0.00200	0.00000	0.00050	
<b>FEATURE(27)</b>			<b>AXI</b>				
DZ		-0.07902	0.08000	0.01000	-0.01000	-0.00098	
<b>FEATURE(28)</b>			<b>CIR</b>				
FORM		0.00009					
DM		3.29802	3.30000	0.01000	-0.01000	-0.00198	
<b>FEAT(28)</b>			<b>AXI</b>				
RADRUN		0.00014	0.00000	0.00500	0.00000	0.00014	
<b>FEATURE(30)</b>			<b>CYL</b>				
FORM		0.00010					
DM		0.99760	0.99800	0.00000	-0.00100	-0.00040	
<b>FEATURE(31)</b>			<b>AXI</b>				
RADRUN		0.00015	0.00000	0.00100	0.00000	0.00015	
<b>FEATURE(32)</b>			<b>AXI</b>				
RADRUN		0.00033	0.00000	0.00100	0.00000	0.00033	
<b>FEATURE(29)</b>			<b>TOR</b>				
FORM		0.00066					
Cir_RA		0.04986	0.05000	0.00050	-0.00050	-0.00014	
OUT_DM		0.57427	0.57500	0.00100	-0.00100	-0.00073	
INN_DM		0.37484	0.37500			-0.00016	
X		-0.00001					
Y		-0.00006					

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


**FEA(33)**

**PLA**

FORM            0.00013  
 Z                -2.54715


**FEATURE(34)**

**AXI**

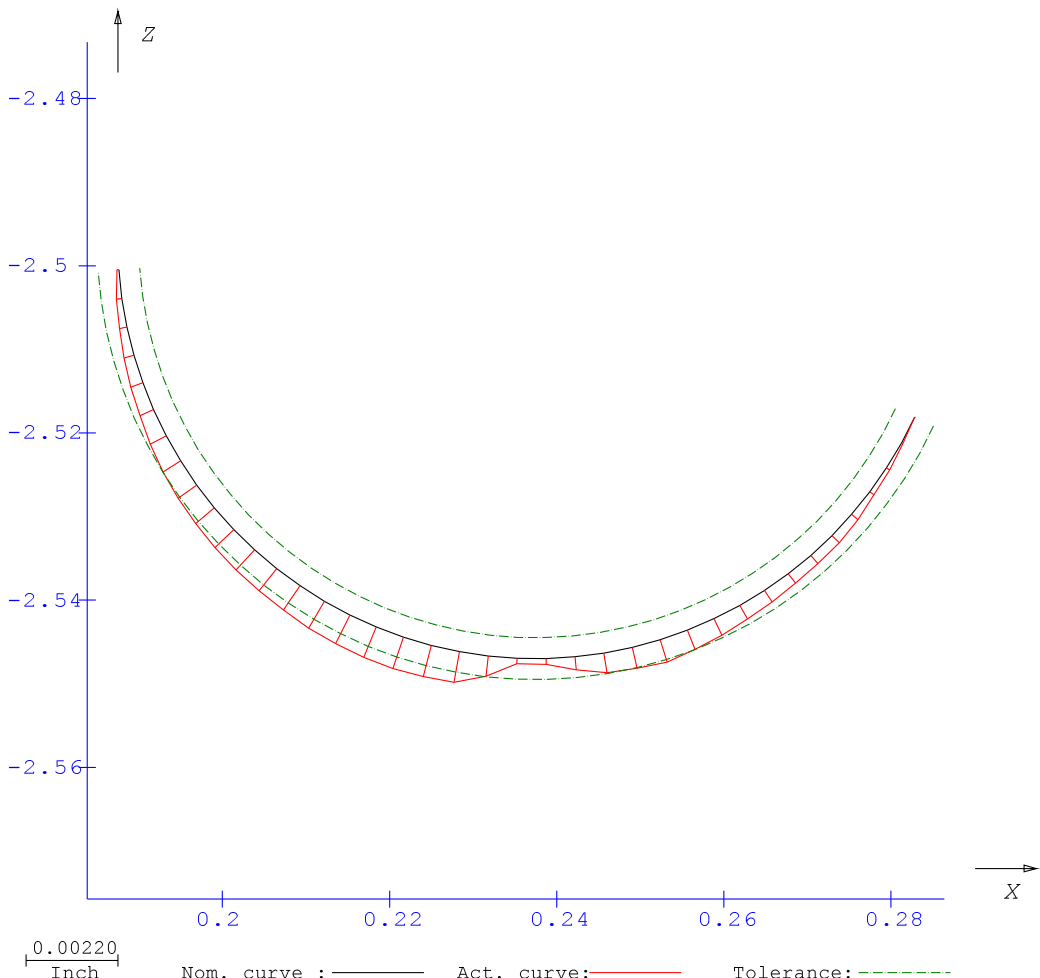
DZ                0.04965    0.05000    0.00050    -0.00050    -0.00035    

**FEATURE(41)**

**CIR**

FORM            0.00020  
 RA               0.01683    0.01600    0.00200    -0.00200    0.00083    

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

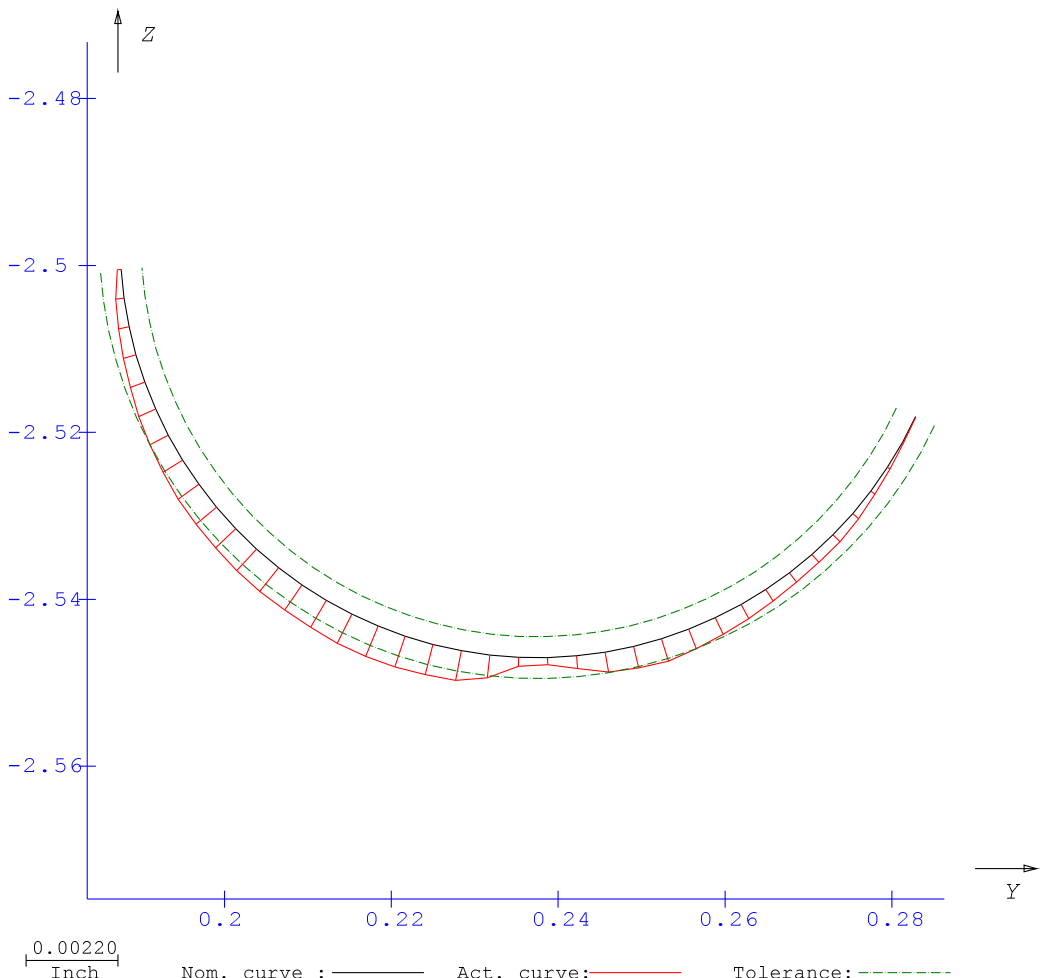
		X	Y	Z	Nr.
Form .....	0.00078	0.22167	0.00000	-2.54443	22
Lower Toler. :	-0.00050	0.28282	0.00000	-2.51813	1
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00079      Profile of Radius 0.0500  
 Max. Deviat.: -0.00001      @ 0°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:21-OCT-2009  
 Time .....:14:47:21



Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 005                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(2)

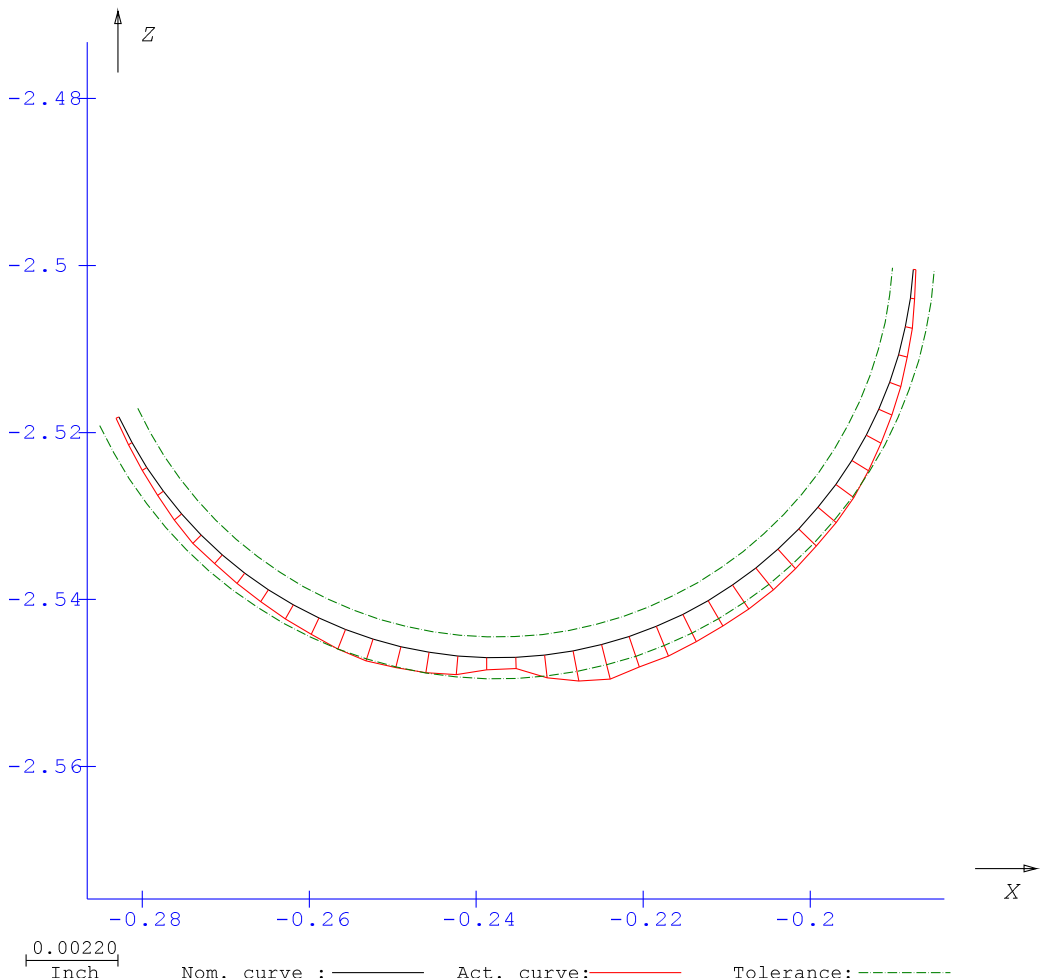
		X	Y	Z	Nr.
Form .....	0.00077	0.00000	0.28282	-2.51813	1
Lower Toler. :	-0.00050	0.00000	0.21842	-2.54322	23
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: 0.00002      Profile of Radius 0.0500  
 Max. Deviat.: 0.00078      @ 90°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:21-OCT-2009  
 Time .....:14:47:21



Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 005                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(3)

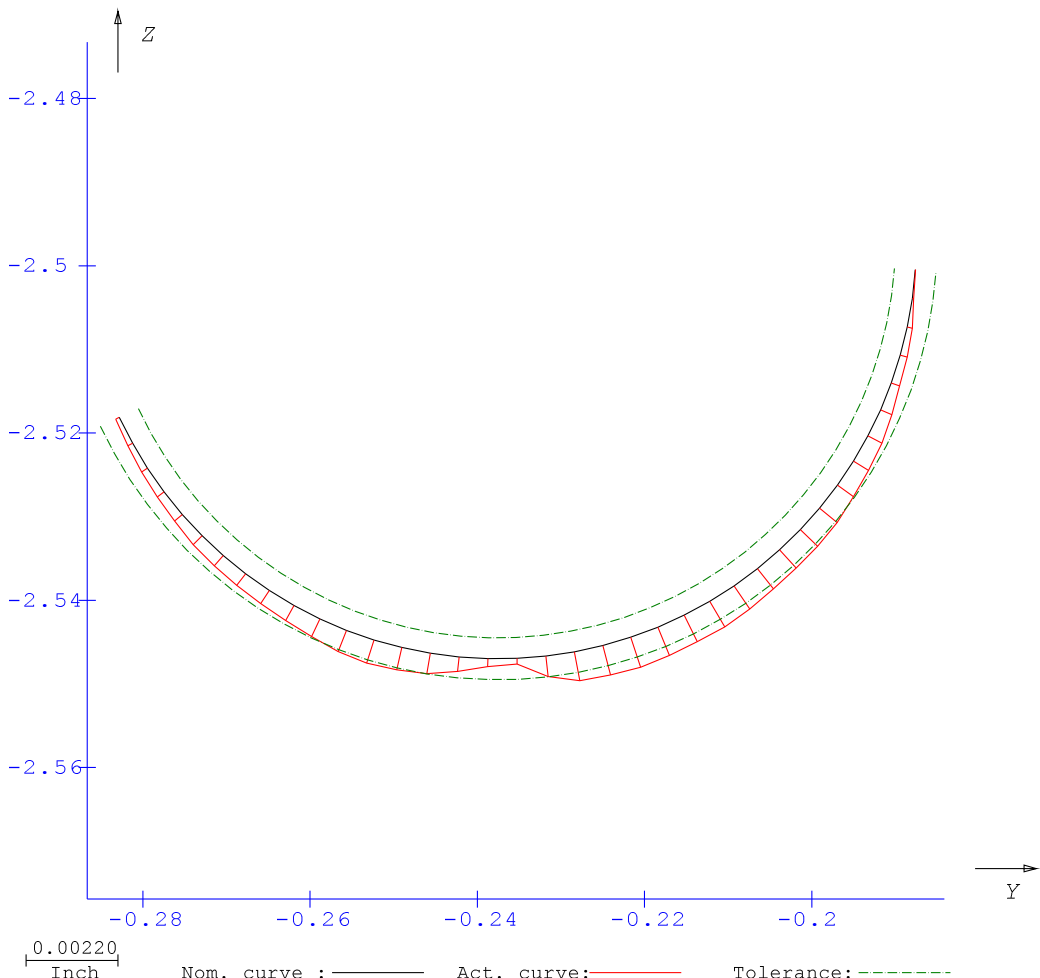
		X	Y	Z	Nr.		
Form .....	0.00079	Min. Deviat.:	0.00006	-0.18762	0.00000	-2.50047	39
Lower Toler. :	-0.00050	Max. Deviat.:	0.00085	-0.22499	0.00000	-2.54541	21
Upper Toler. :	0.00050	Profile of Radius 0.0500					
Error Magnif.:	5	@ 180°					
No. of points:	39						



2D - CONTOUR

Inspector.:kcaban  
 Date .....:21-OCT-2009  
 Time .....:14:47:21





Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 005      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(4)

		X	Y	Z	Nr.
Form .....	0.00075	0.00000	-0.18762	-2.50047	39
Lower Toler. :	-0.00050	0.00000	-0.22167	-2.54443	22
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: 0.00000      Profile of Radius 0.0500  
 Max. Deviat.: 0.00076      @ 270°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:21-OCT-2009  
 Time .....:14:47:21