

# Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	007
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	22-OCT-2009, 09:39:46
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	0.00022	0.00000	0.00100	0.00000	0.00022	
<b>DATUM_B</b>		<b>CYL</b>					
	DM	0.37484	0.37500	0.00050	-0.00050	-0.00016	
<b>CYL_B</b>		<b>CYL</b>					
	CYLFRM	0.00014	0.00000	0.00050	0.00000	0.00014	
<b>SQR_B</b>		<b>AXI</b>					
	SQRNES	0.00005	0.00000	0.00100	0.00000	0.00005	
<b>FEATURE(1)</b>		<b>CYL</b>					
	DM	0.99776	0.99800	0.00000	-0.00100	-0.00024	
<b>FEATURE(2)</b>		<b>AXI</b>					
	RADRUN	0.00056	0.00000	0.00100	0.00000	0.00056	
<b>FEATURE(3)</b>		<b>PLA</b>					
	Z	0.29598	0.29600	0.00500	-0.00500	-0.00002	
<b>FEATURE(6)</b>		<b>CYL</b>					
	FORM	0.00002					
	DM	0.28074	0.28100	0.00500	-0.00500	-0.00026	
	X	0.00501	0.00000			0.00501	
	Y	0.89844	0.90000			-0.00156	
<b>POS_FEATURE(6)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01058	0.00000	0.03472	0.00000	0.01058	
<b>FEATURE(7)</b>		<b>CYL</b>					
	FORM	0.00001					
	DM	0.28065	0.28100	0.00500	-0.00500	-0.00035	
	X	-0.63275	0.63630			-0.00355	
	Y	0.63859	0.63630			0.00229	
<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, 09:39:46			NO\$NAME			Page 2 of 9	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

POS_FEATURE(7)		AXI					
POSMC	0.00849	0.00000	0.03464	0.00000	0.00849		

FEATURE(8)		CYL					
FORM	0.00002						
DM	0.28067	0.28100	0.00500	-0.00500	-0.00033		
X	-0.90043	0.90000			0.00043		
Y	0.00431	0.00000			0.00431		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMC	0.00884	0.00000	0.03465	0.00000	0.00884		

FEATURE(9)		CYL					
FORM	0.00003						
DM	0.28068	0.28100	0.00500	-0.00500	-0.00032		
X	-0.64047	0.63630			0.00417		
Y	-0.63408	0.63630			-0.00222		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMC	0.00949	0.00000	0.03465	0.00000	0.00949		

FEATURE(10)		CYL					
FORM	0.00004						
DM	0.28070	0.28100	0.00500	-0.00500	-0.00030		
X	-0.00557	0.00000			0.00557		
Y	-0.90133	0.90000			0.00133		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMC	0.01149	0.00000	0.03467	0.00000	0.01149		

FEATURE(11)		CYL					
FORM	0.00003						
DM	0.28071	0.28100	0.00500	-0.00500	-0.00029		
X	0.63236	0.63630			-0.00394		
Y	-0.64150	0.63630			0.00520		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMC	0.01310	0.00000	0.03467	0.00000	0.01310		

FEATURE(12)		CYL					
FORM	0.00001						
DM	0.28071	0.28100	0.00500	-0.00500	-0.00029		
X	0.89980	0.90000			-0.00020		
Y	-0.00636	0.00000			0.00636		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMC	0.01282	0.00000	0.03470	0.00000	0.01282		

FEATURE(13)		CYL					
FORM	0.00002						
DM	0.28073	0.28100	0.00500	-0.00500	-0.00027		
X	0.63958	0.63630			0.00328		
Y	0.63109	0.63630			-0.00521		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Date: 22-Oct-09, 09:39:46			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	0.01234	0.00000	0.03471	0.00000	0.01234	
<b>FEATURE(14)</b>		<b>CYL</b>					
	FORM	0.00087					
	DM	3.50011	3.50000	0.00500	-0.00500	0.00011	
<b>FEATURE(15)</b>		<b>AXI</b>					
	RADRUN	0.00093	0.00000	0.00100	0.00000	0.00093	
<b>FEATURE(4)</b>		<b>CIR</b>					
	DM	0.37607	0.37500	0.00500	-0.00500	0.00107	
<b>FEATURE(5)</b>		<b>AXI</b>					
	DY	-1.37133	1.37000	0.01000	-0.01000	0.00133	
<b>FEATURE(16)</b>		<b>CIR</b>					
	FORM	0.00024					
	DM	0.37668	0.37500	0.00500	-0.00500	0.00168	
<b>FEATURE(17)</b>		<b>AXI</b>					
	DZ	-0.47878	0.48000	0.01000	-0.01000	-0.00122	
<b>FEATURE(18)</b>		<b>CIR</b>					
	FORM	0.00025					
	DM	0.47024	0.46900	0.00200	0.00000	0.00124	
<b>FEATURE_18A</b>		<b>AXI</b>					
	DY	-0.06135	0.06000	0.01000	-0.01000	0.00135	
<b>FEATURE_18B</b>		<b>AXI</b>					
	DY	0.38120	0.38000	0.01000	-0.01000	0.00120	
<b>FEA_20(1)</b>		<b>AXI</b>					
	DY	-0.06188	0.06000	0.01000	-0.01000	0.00188	
<b>POS\$FEA_20(1)</b>		<b>AXI</b>					
	POSITN	0.00288	0.00000	0.01000	0.00000	0.00288	
<b>FEA_20(2)</b>		<b>AXI</b>					
	DX	0.06155	0.06000	0.01000	-0.01000	0.00155	
<b>POS\$FEA_20(2)</b>		<b>AXI</b>					
	POSITN	0.00031	0.00000	0.01000	0.00000	0.00031	
<b>FEA_20(3)</b>		<b>AXI</b>					
	DY	-0.06189	0.06000	0.01000	-0.01000	0.00189	
<b>POS\$FEA_20(3)</b>		<b>AXI</b>					
	POSITN	0.00294	0.00000	0.01000	0.00000	0.00294	
<b>FEA_20(4)</b>		<b>AXI</b>					
	DX	0.06153	0.06000	0.01000	-0.01000	0.00153	
<b>POS\$FEA_20(4)</b>		<b>AXI</b>					
	POSITN	0.00029	0.00000	0.01000	0.00000	0.00029	
<b>FEAT_21(1)</b>		<b>AXI</b>					
	DZ	0.06943	0.07000	0.01000	-0.01000	-0.00057	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>FEAT_21(2)</b>			<b>AXI</b>				
DZ		0.06930	0.07000	0.01000	-0.01000	-0.00070	
<b>FEAT_21(3)</b>			<b>AXI</b>				
DZ		0.06943	0.07000	0.01000	-0.01000	-0.00057	
<b>FEAT_21(4)</b>			<b>AXI</b>				
DZ		0.06957	0.07000	0.01000	-0.01000	-0.00043	
<b>DAT_B_OP</b>			<b>CYL</b>				
DM		0.37489					
FORM		0.00009					
<b>FEATURE(22)</b>			<b>PLA</b>				
FORM		0.00006					
Z		-2.26188					
<b>FEATURE(23)</b>			<b>PLA</b>				
PARALL		0.00010	0.00000	0.00100	0.00000	0.00010	
<b>FEA(24)</b>			<b>PLA</b>				
Z		-2.49731	2.49700	0.00200	0.00000	0.00031	
FORM		0.00005					
<b>FEATURE(24)</b>			<b>PLA</b>				
PARALL		0.00007	0.00000	0.00100	0.00000	0.00007	
<b>FEATURE(25)</b>			<b>AXI</b>				
DZ		-0.23543	0.23500	0.00100	0.00000	0.00043	
<b>FEATURE(26)</b>			<b>AXI</b>				
Z		-2.49731	2.49700	0.00200	0.00000	0.00031	
<b>FEATURE(27)</b>			<b>AXI</b>				
DZ		-0.07911	0.08000	0.01000	-0.01000	-0.00089	
<b>FEATURE(28)</b>			<b>CIR</b>				
FORM		0.00064					
DM		3.29781	3.30000	0.01000	-0.01000	-0.00219	
<b>FEAT(28)</b>			<b>AXI</b>				
RADRUN		0.00067	0.00000	0.00500	0.00000	0.00067	
<b>FEATURE(30)</b>			<b>CYL</b>				
FORM		0.00006					
DM		0.99753	0.99800	0.00000	-0.00100	-0.00047	
<b>FEATURE(31)</b>			<b>AXI</b>				
RADRUN		0.00009	0.00000	0.00100	0.00000	0.00009	
<b>FEATURE(32)</b>			<b>AXI</b>				
RADRUN		0.00027	0.00000	0.00100	0.00000	0.00027	
<b>FEATURE(29)</b>			<b>TOR</b>				
FORM		0.00097					
Cir_RA		0.04985	0.05000	0.00050	-0.00050	-0.00015	
OUT_DM		0.57414	0.57500	0.00100	-0.00100	-0.00086	
INN_DM		0.37473	0.37500			-0.00027	
X		0.00002					
Y		-0.00001					

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


**FEA(33)**

**PLA**

FORM            0.00007  
 Z                -2.54684


**FEATURE(34)**

**AXI**

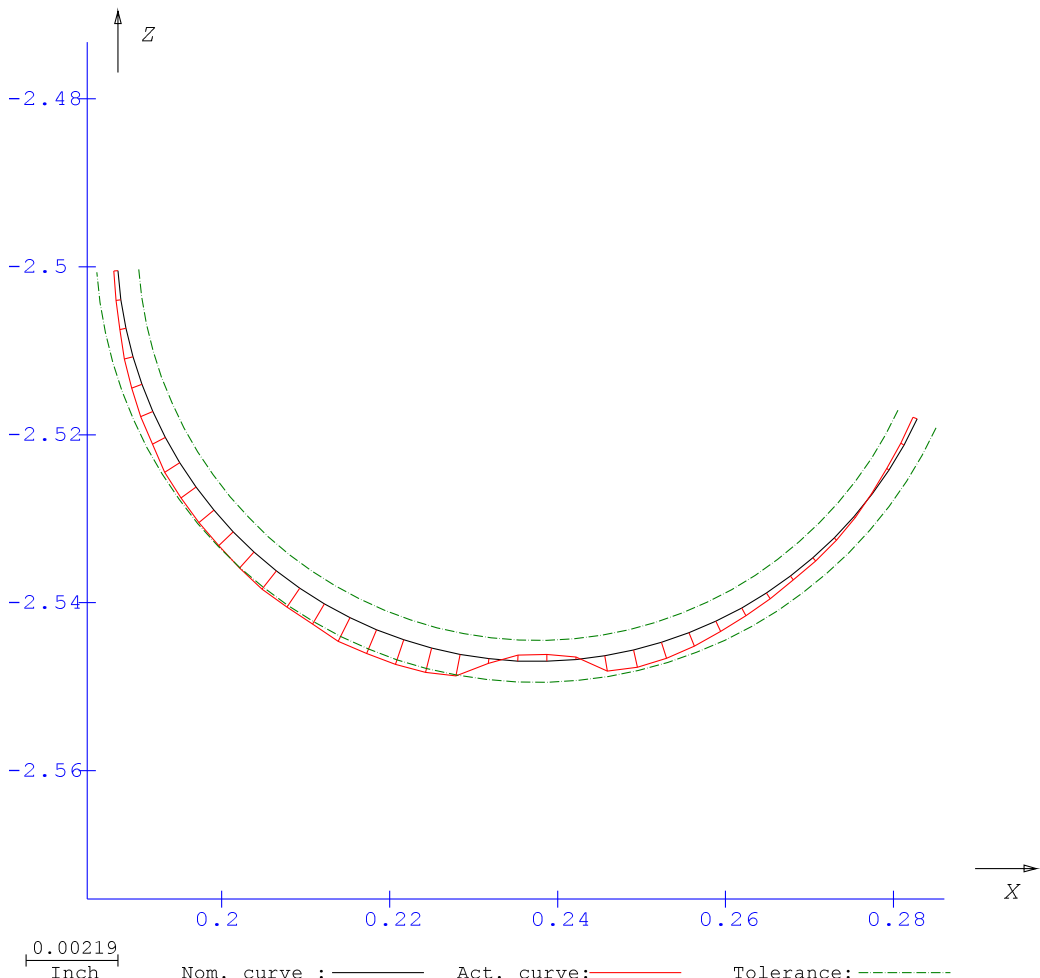
DZ                0.04953    0.05000    0.00050    -0.00050    -0.00047    

**FEATURE(41)**

**CIR**

FORM            0.00025  
 RA                0.01684    0.01600    0.00200    -0.00200    0.00084    

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

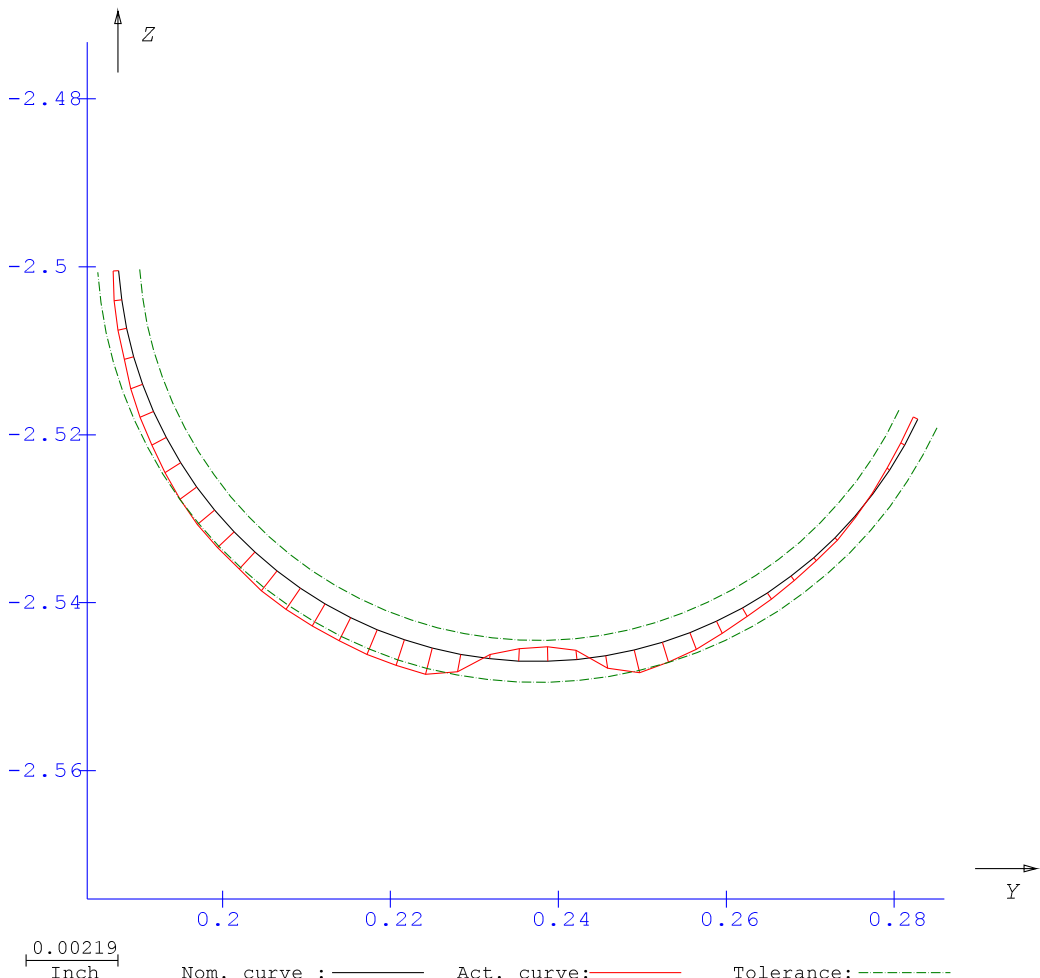
		X	Y	Z	Nr.
Form .....	0.00079	0.21526	0.00000	-2.54178	24
Lower Toler. :-	-0.00050	0.23873	0.00000	-2.54698	17
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00063      Profile of Radius 0.0500  
 Max. Deviat.: 0.00016      @ 0°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:22-OCT-2009  
 Time .....:09:39:46



Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 007      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(2)

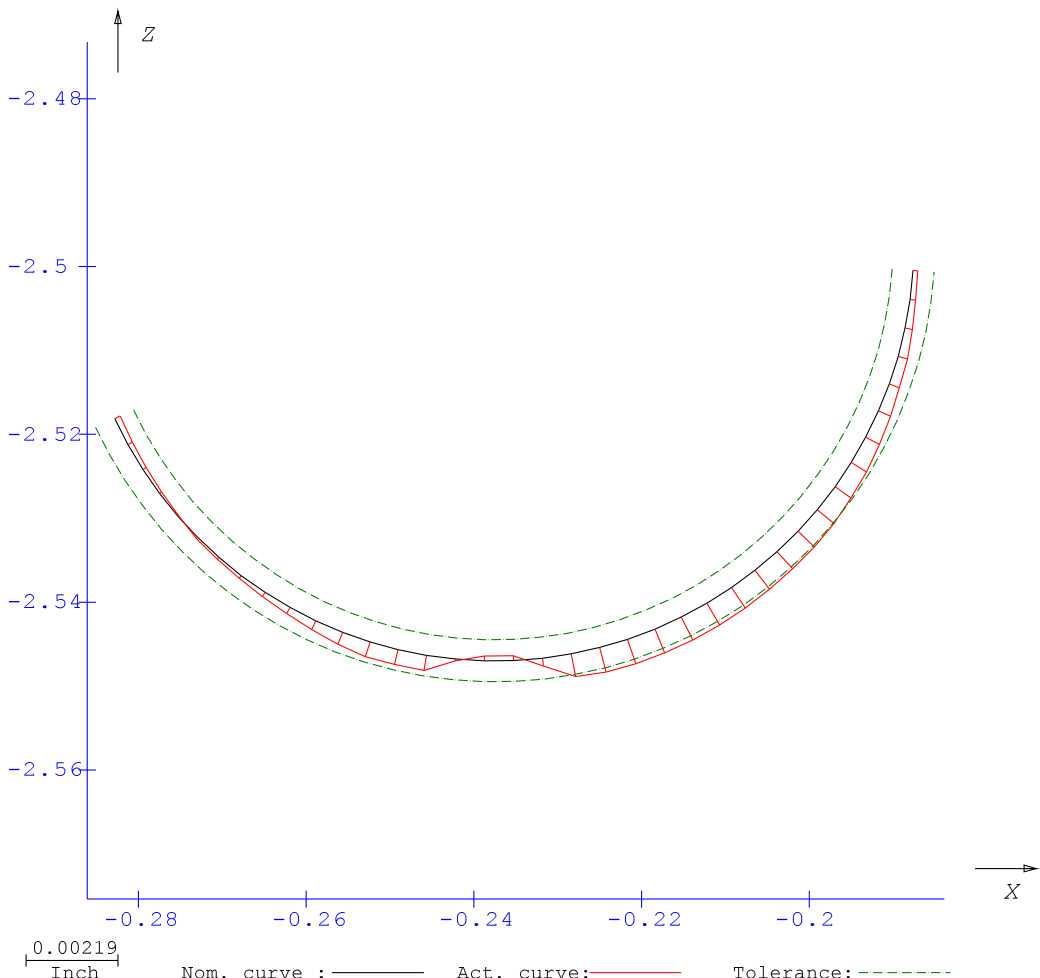
	X	Y	Z	Nr.
Form .....	0.00099	0.00000	-2.54698	17
Lower Toler. :	-0.00050	0.00000	-2.54541	21
Upper Toler. :	0.00050			
Error Magnif.:	5			
No. of points:	39			

Min. Deviat.: -0.00034      Max. Deviat.: 0.00065  
 Profile of Radius 0.0500 @ 90°



## 2D - CONTOUR

Inspector.:kcaban  
 Date .....:22-OCT-2009  
 Time .....:09:39:46



Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 007                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(3)

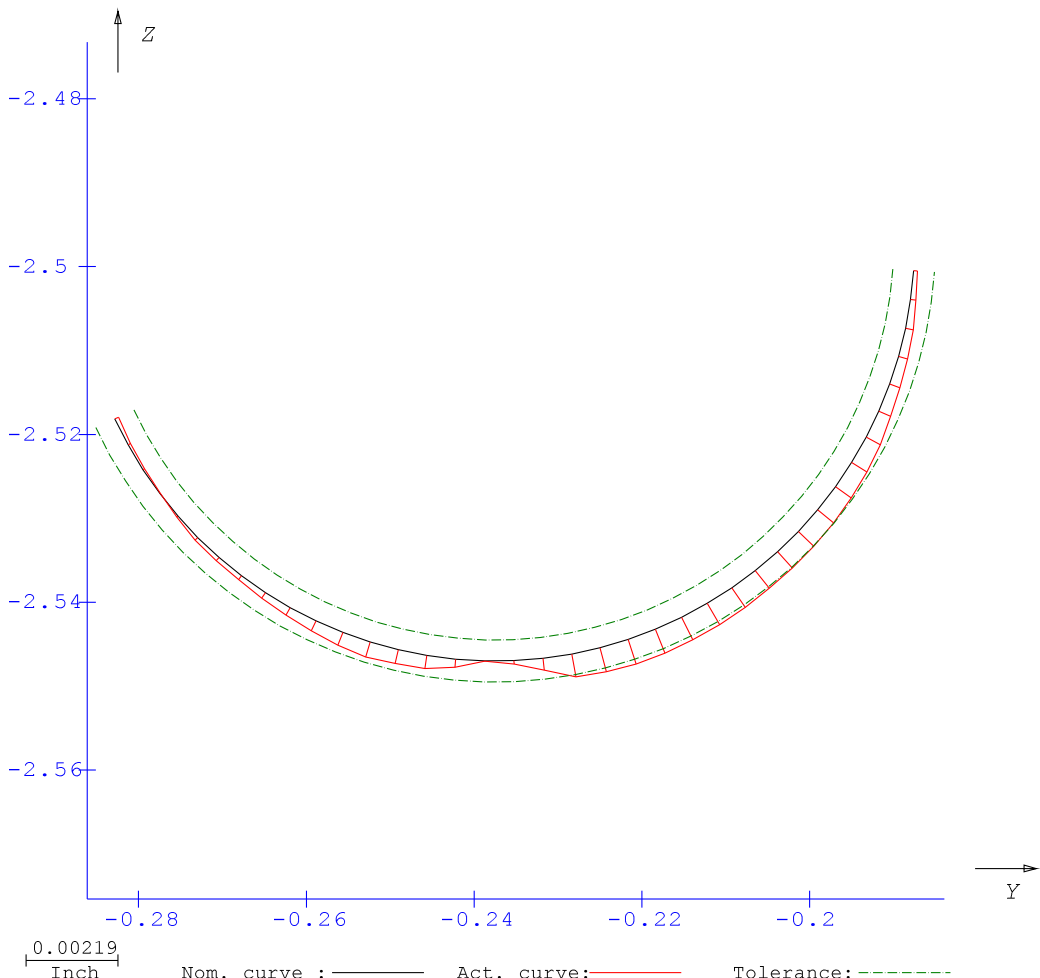
		X	Y	Z	Nr.	
Form .....	0.00076	Min. Deviat.:-0.00014	-0.28282	0.00000	-2.51813	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00062	-0.22167	0.00000	-2.54443	22
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 180°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban  
 Date .....:22-OCT-2009  
 Time .....:09:39:46





Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 007                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(4)

		X	Y	Z	Nr.
Form .....	0.00071	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.: -0.00010      Profile of Radius 0.0500  
 Max. Deviat.: 0.00062      @ 270°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:22-OCT-2009  
 Time .....:09:39:46