

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	008
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, 10:41:17
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	0.00022	0.00000	0.00100	0.00000	0.00022	
DATUM_B		CYL					
	DM	0.37504	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	0.00007	0.00000	0.00100	0.00000	0.00007	
FEATURE(1)		CYL					
	DM	0.99769	0.99800	0.00000	-0.00100	-0.00031	
FEATURE(2)		AXI					
	RADRUN	0.00048	0.00000	0.00100	0.00000	0.00048	
FEATURE(3)		PLA					
	Z	0.29595	0.29600	0.00500	-0.00500	-0.00005	
FEATURE(6)		CYL					
	FORM	0.00040					
	DM	0.28030	0.28100	0.00500	-0.00500	-0.00070	
	X	-0.00525	0.00000			0.00525	
	Y	0.89955	0.90000			-0.00045	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01062	0.00000	0.03405	0.00000	0.01062	
FEATURE(7)		CYL					
	FORM	0.00004					
	DM	0.28042	0.28100	0.00500	-0.00500	-0.00058	
	X	-0.64071	0.63630			0.00441	
	Y	0.63251	0.63630			-0.00379	
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	0.01197	0.00000	0.03437	0.00000	0.01197		

FEATURE(8)		CYL					
FORM	0.00003						
DM	0.28038	0.28100	0.00500	-0.00500	-0.00062		
X	-0.90039	0.90000			0.00039		
Y	-0.00520	0.00000			0.00520		

POS_FEATURE(8)		AXI					
POSITN				0.03000			
POSMMC	0.01063	0.00000	0.03436	0.00000	0.01063		

FEATURE(9)		CYL					
FORM	0.00003						
DM	0.28043	0.28100	0.00500	-0.00500	-0.00057		
X	-0.63353	0.63630			-0.00277		
Y	-0.64011	0.63630			0.00381		

POS_FEATURE(9)		AXI					
POSITN				0.03000			
POSMMC	0.00944	0.00000	0.03440	0.00000	0.00944		

FEATURE(10)		CYL					
FORM	0.00011						
DM	0.28046	0.28100	0.00500	-0.00500	-0.00054		
X	0.00485	0.00000			0.00485		
Y	-0.90089	0.90000			0.00089		

POS_FEATURE(10)		AXI					
POSITN				0.03000			
POSMMC	0.00987	0.00000	0.03435	0.00000	0.00987		

FEATURE(11)		CYL					
FORM	0.00003						
DM	0.28046	0.28100	0.00500	-0.00500	-0.00054		
X	0.63987	0.63630			0.00357		
Y	-0.63363	0.63630			-0.00267		

POS_FEATURE(11)		AXI					
POSITN				0.03000			
POSMMC	0.00895	0.00000	0.03443	0.00000	0.00895		

FEATURE(12)		CYL					
FORM	0.00006						
DM	0.28045	0.28100	0.00500	-0.00500	-0.00055		
X	0.89966	0.90000			-0.00034		
Y	0.00466	0.00000			0.00466		

POS_FEATURE(12)		AXI					
POSITN				0.03000			
POSMMC	0.00941	0.00000	0.03439	0.00000	0.00941		

FEATURE(13)		CYL					
FORM	0.00004						
DM	0.28047	0.28100	0.00500	-0.00500	-0.00053		
X	0.63316	0.63630			-0.00314		
Y	0.63919	0.63630			0.00289		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 22-Oct-09, 10:41:17			NO\$NAME			Page 2 of 9	

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

POS_FEATURE(13)		AXI					
	POSITN			0.03000			
	POSMMC	0.00895	0.00000	0.03442	0.00000	0.00895	
FEATURE(14)		CYL					
	FORM	0.00083					
	DM	3.50016	3.50000	0.00500	-0.00500	0.00016	
FEATURE(15)		AXI					
	RADRUN	0.00089	0.00000	0.00100	0.00000	0.00089	
FEATURE(4)		CIR					
	DM	0.37596	0.37500	0.00500	-0.00500	0.00096	
FEATURE(5)		AXI					
	DY	-1.37057	1.37000	0.01000	-0.01000	0.00057	
FEATURE(16)		CIR					
	FORM	0.00019					
	DM	0.37674	0.37500	0.00500	-0.00500	0.00174	
FEATURE(17)		AXI					
	DZ	-0.47864	0.48000	0.01000	-0.01000	-0.00136	
FEATURE(18)		CIR					
	FORM	0.00027					
	DM	0.47027	0.46900	0.00200	0.00000	0.00127	
FEATURE_18A		AXI					
	DY	-0.06154	0.06000	0.01000	-0.01000	0.00154	
FEATURE_18B		AXI					
	DY	0.38148	0.38000	0.01000	-0.01000	0.00148	
FEA_20(1)		AXI					
	DY	-0.06172	0.06000	0.01000	-0.01000	0.00172	
POS\$FEA_20(1)		AXI					
	POSITN	0.00111	0.00000	0.01000	0.00000	0.00111	
FEA_20(2)		AXI					
	DX	0.06155	0.06000	0.01000	-0.01000	0.00155	
POS\$FEA_20(2)		AXI					
	POSITN	0.00008	0.00000	0.01000	0.00000	0.00008	
FEA_20(3)		AXI					
	DY	-0.06180	0.06000	0.01000	-0.01000	0.00180	
POS\$FEA_20(3)		AXI					
	POSITN	0.00105	0.00000	0.01000	0.00000	0.00105	
FEA_20(4)		AXI					
	DX	0.06147	0.06000	0.01000	-0.01000	0.00147	
POS\$FEA_20(4)		AXI					
	POSITN	0.00018	0.00000	0.01000	0.00000	0.00018	
FEAT_21(1)		AXI					
	DZ	0.07059	0.07000	0.01000	-0.01000	0.00059	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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Date: 22-Oct-09, 10:41:17			NO\$NAME			Page 4 of 9	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
FEAT_21(2)			AXI				
DZ		0.07065	0.07000	0.01000	-0.01000	0.00065	
FEAT_21(3)			AXI				
DZ		0.07059	0.07000	0.01000	-0.01000	0.00059	
FEAT_21(4)			AXI				
DZ		0.07060	0.07000	0.01000	-0.01000	0.00060	
DAT_B_OP			CYL				
DM		0.37500					
FORM		0.00039					
FEATURE(22)			PLA				
FORM		0.00004					
Z		-2.26214					
FEATURE(23)			PLA				
PARALL		0.00010	0.00000	0.00100	0.00000	0.00010	
FEA(24)			PLA				
Z		-2.49760	2.49700	0.00200	0.00000	0.00060	
FORM		0.00004					
FEATURE(24)			PLA				
PARALL		0.00005	0.00000	0.00100	0.00000	0.00005	
FEATURE(25)			AXI				
DZ		-0.23546	0.23500	0.00100	0.00000	0.00046	
FEATURE(26)			AXI				
Z		-2.49760	2.49700	0.00200	0.00000	0.00060	
FEATURE(27)			AXI				
DZ		-0.07941	0.08000	0.01000	-0.01000	-0.00059	
FEATURE(28)			CIR				
FORM		0.00049					
DM		3.29958	3.30000	0.01000	-0.01000	-0.00042	
FEAT(28)			AXI				
RADRUN		0.00055	0.00000	0.00500	0.00000	0.00055	
FEATURE(30)			CYL				
FORM		0.00014					
DM		0.99729	0.99800	0.00000	-0.00100	-0.00071	
FEATURE(31)			AXI				
RADRUN		0.00015	0.00000	0.00100	0.00000	0.00015	
FEATURE(32)			AXI				
RADRUN		0.00035	0.00000	0.00100	0.00000	0.00035	
FEATURE(29)			TOR				
FORM		0.00072					
Cir_RA		0.04990	0.05000	0.00050	-0.00050	-0.00010	
OUT_DM		0.57398	0.57500	0.00100	-0.00100	-0.00102	
INN_DM		0.37436	0.37500			-0.00064	
X		0.00002					
Y		-0.00004					

-0.00002

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


FEA(33)

PLA

FORM 0.00009
 Z -2.54726


FEATURE(34)

AXI

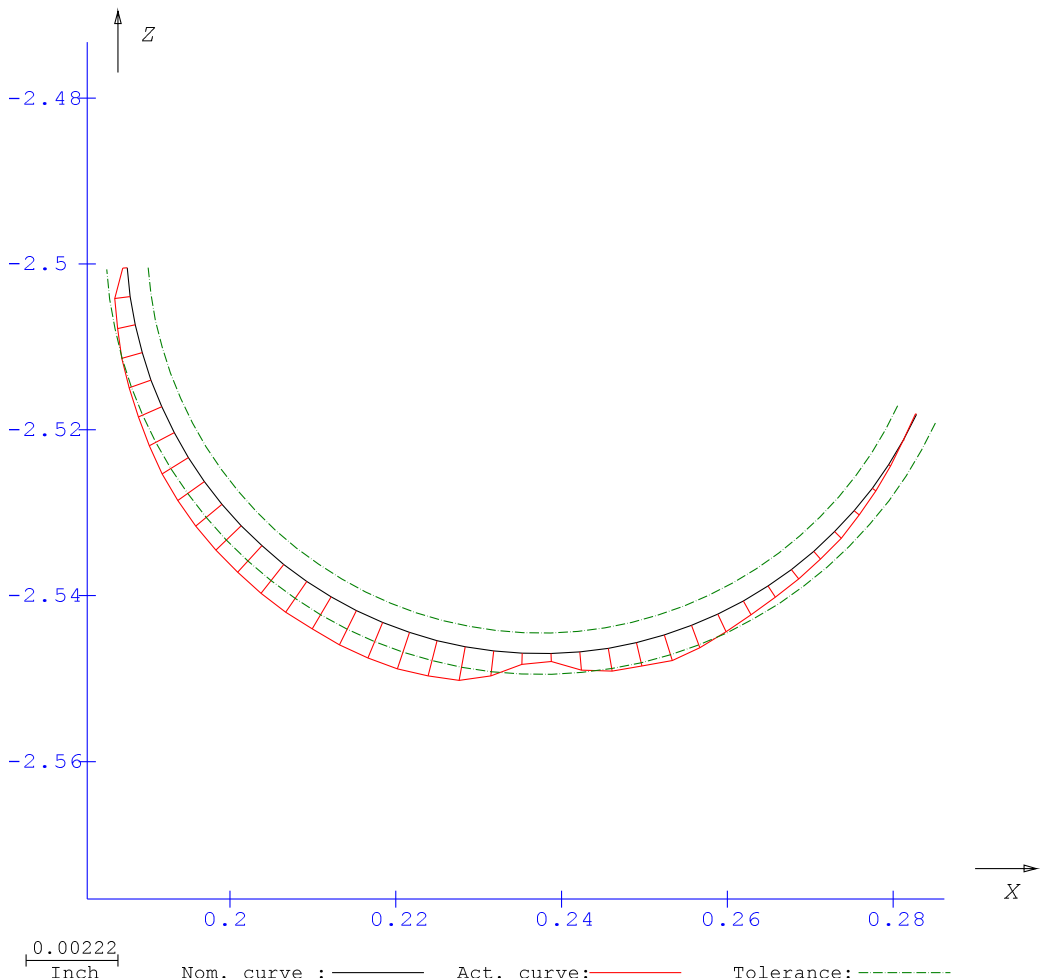
DZ 0.04966 0.05000 0.00050 -0.00050 -0.00034 

FEATURE(41)

CIR

FORM 0.00017
 RA 0.01688 0.01600 0.00200 -0.00200 0.00088 

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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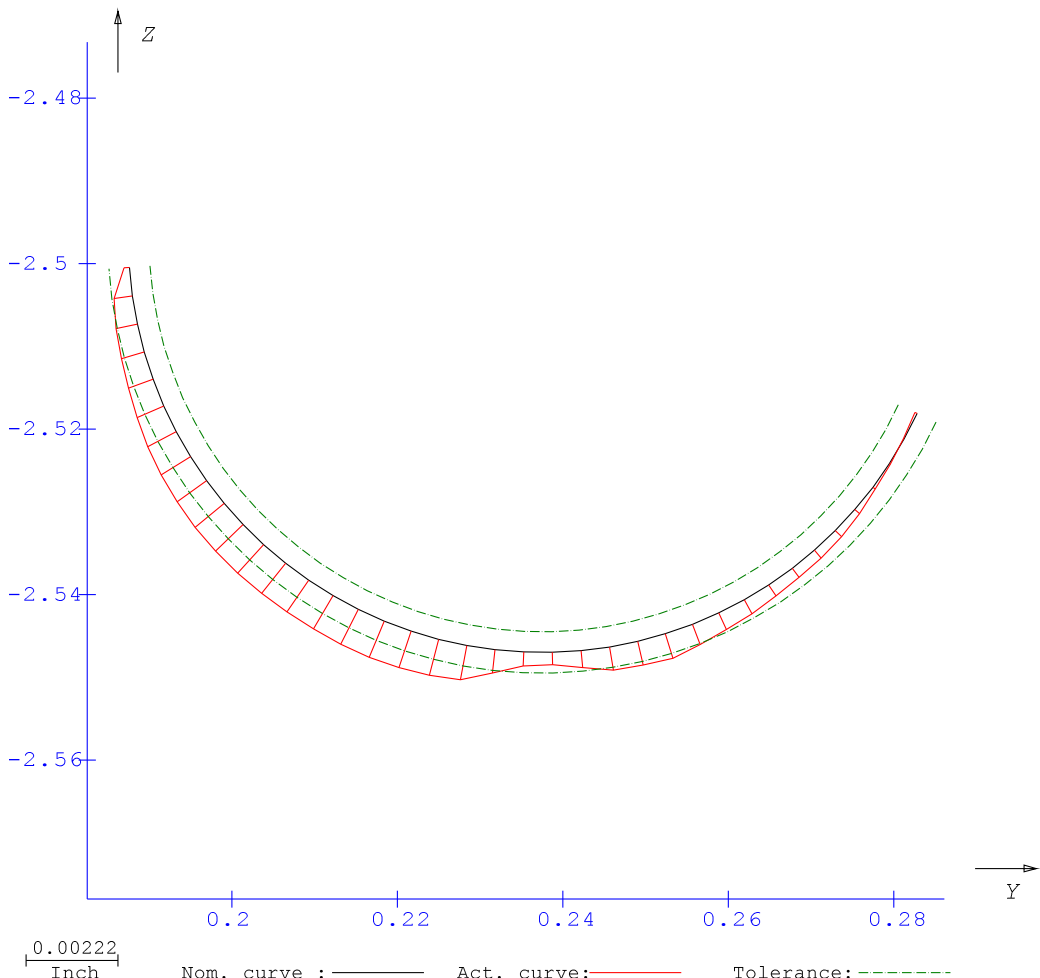
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

	X	Y	Z	Nr.			
Form	0.00096	Min. Deviat.:-0.00093	0.21842	0.00000	-2.54322	23	
Lower Toler. :-	0.00050	Max. Deviat.:	0.00003	0.28282	0.00000	-2.51813	1
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. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

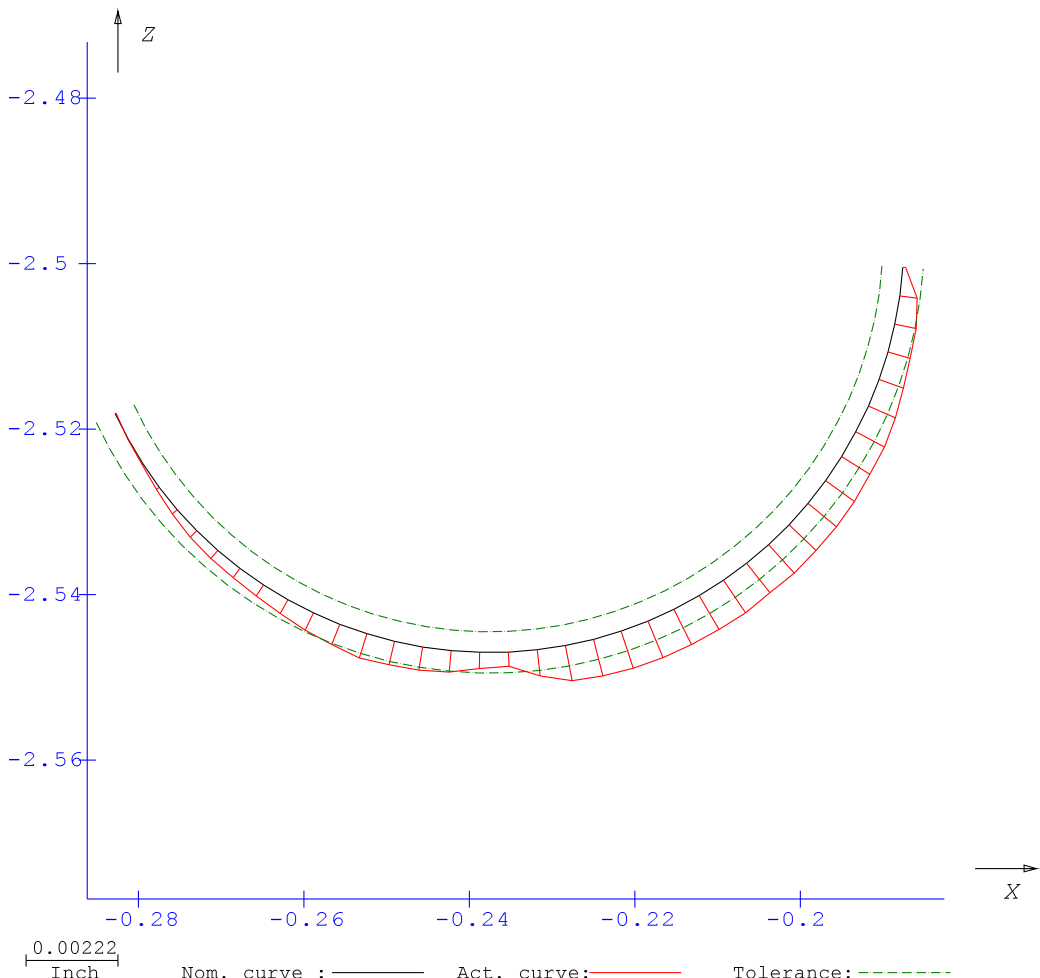
	X	Y	Z	Nr.
Form	0.00101	0.00000	-2.51813	1
Lower Toler. :-	-0.00050	0.00000	-2.54322	23
Upper Toler. :	0.00050			
Error Magnif.:	5			
No. of points:	39			

Min. Deviat.: -0.00006 Max. Deviat.: 0.00095
 Profile of Radius 0.0500 @ 90°



2D - CONTOUR

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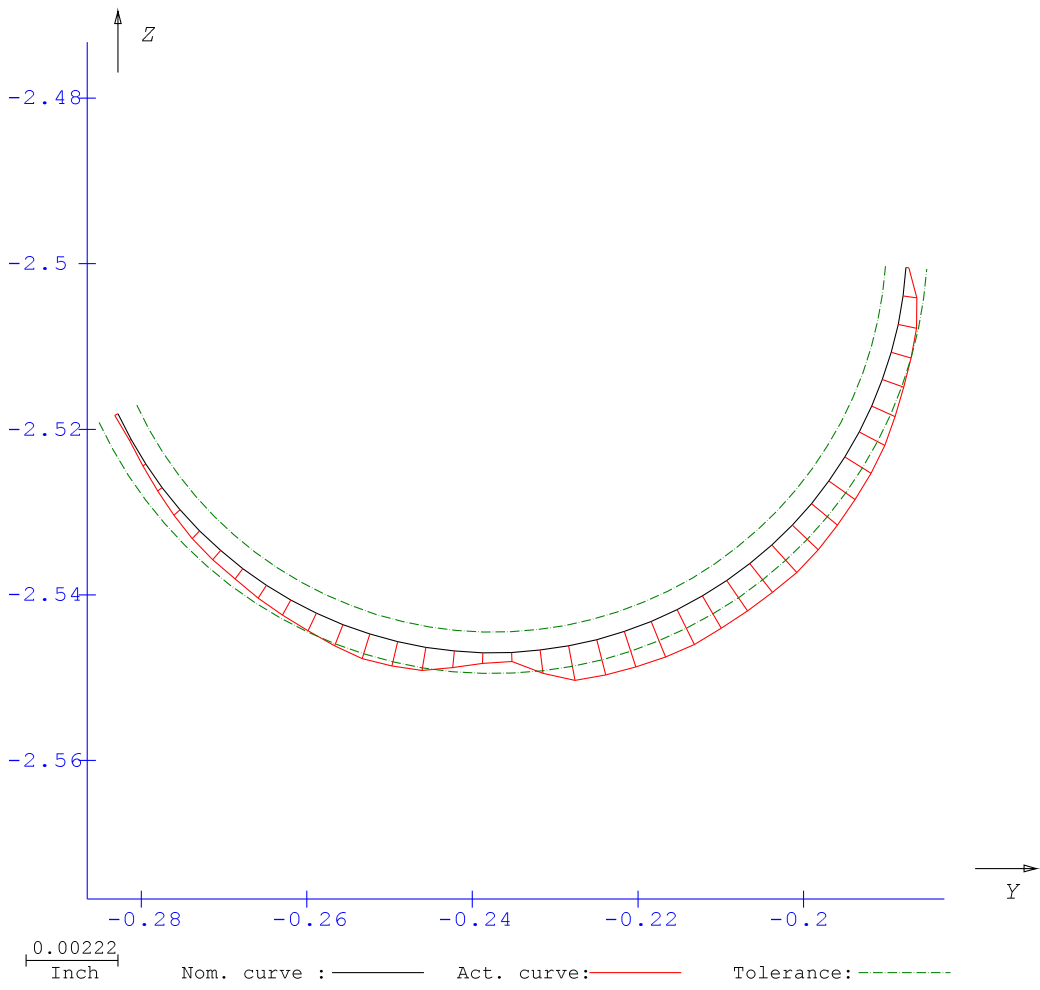
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.	
Form	0.00098	Min. Deviat.:-0.00003	-0.28282	0.00000	-2.51813	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00095	-0.21842	0.00000	-2.54322	23
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. : 008 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.
Form	0.00089	0.00000	-0.28124	-2.52122	2
Lower Toler. :	-0.00050	0.00000	-0.21526	-2.54178	24
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: 0.00004 Profile of Radius 0.0500
 Max. Deviat.: 0.00094 @ 270°



2D - CONTOUR

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