

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	002
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, 11:42:10
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	0.00023	0.00000	0.00100	0.00000	0.00023	
DATUM_B		CYL					
	DM	0.37490	0.37500	0.00050	-0.00050	-0.00010	
CYL_B		CYL					
	CYLFRM	0.00017	0.00000	0.00050	0.00000	0.00017	
SQR_B		AXI					
	SQRNES	0.00013	0.00000	0.00100	0.00000	0.00013	
FEATURE(1)		CYL					
	DM	0.99765	0.99800	0.00000	-0.00100	-0.00035	
FEATURE(2)		AXI					
	RADRUN	0.00038	0.00000	0.00100	0.00000	0.00038	
FEATURE(3)		PLA					
	Z	0.29597	0.29600	0.00500	-0.00500	-0.00003	
FEATURE(6)		CYL					
	FORM	0.00003					
	DM	0.28053	0.28100	0.00500	-0.00500	-0.00047	
	X	-0.00567	0.00000			0.00567	
	Y	0.89823	0.90000			-0.00177	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01204	0.00000	0.03450	0.00000	0.01204	
FEATURE(7)		CYL					
	FORM	0.00004					
	DM	0.28052	0.28100	0.00500	-0.00500	-0.00048	
	X	-0.64056	0.63630			0.00426	
	Y	0.63045	0.63630			-0.00585	
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	0.01478	0.00000	0.03449	0.00000	0.01478		

FEATURE(8)		CYL					
FORM	0.00007						
DM	0.28052	0.28100	0.00500	-0.00500	-0.00048		
X	-0.90002	0.90000			0.00002		
Y	-0.00674	0.00000			0.00674		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01351	0.00000	0.03445	0.00000	0.01351		

FEATURE(9)		CYL					
FORM	0.00003						
DM	0.28047	0.28100	0.00500	-0.00500	-0.00053		
X	-0.63256	0.63630			-0.00374		
Y	-0.64128	0.63630			0.00498		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01258	0.00000	0.03444	0.00000	0.01258		

FEATURE(10)		CYL					
FORM	0.00003						
DM	0.28046	0.28100	0.00500	-0.00500	-0.00054		
X	0.00516	0.00000			0.00516		
Y	-0.90158	0.90000			0.00158		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.01082	0.00000	0.03443	0.00000	0.01082		

FEATURE(11)		CYL					
FORM	0.00005						
DM	0.28050	0.28100	0.00500	-0.00500	-0.00050		
X	0.64022	0.63630			0.00392		
Y	-0.63356	0.63630			-0.00274		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.01017	0.00000	0.03445	0.00000	0.01017		

FEATURE(12)		CYL					
FORM	0.00003						
DM	0.28051	0.28100	0.00500	-0.00500	-0.00049		
X	0.89925	0.90000			-0.00075		
Y	0.00405	0.00000			0.00405		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00877	0.00000	0.03448	0.00000	0.00877		

FEATURE(13)		CYL					
FORM	0.00013						
DM	0.28052	0.28100	0.00500	-0.00500	-0.00048		
X	0.63278	0.63630			-0.00352		
Y	0.63843	0.63630			0.00213		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 21-Oct-09, 11:42:11			NO\$NAME			Page 2 of 9	

Date: 21-Oct-09, 11:42:11			NO\$NAME			Page 3 of 9	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
POS_FEATURE(13)		AXI					
	POSITN			0.03000			
	POSMMC	0.00827	0.00000	0.03444	0.00000	0.00827	
FEATURE(14)		CYL					
	FORM	0.00048					
	DM	3.50013	3.50000	0.00500	-0.00500	0.00013	
FEATURE(15)		AXI					
	RADRUN	0.00055	0.00000	0.00100	0.00000	0.00055	
FEATURE(4)		CIR					
	DM	0.37602	0.37500	0.00500	-0.00500	0.00102	
FEATURE(5)		AXI					
	DY	-1.37143	1.37000	0.01000	-0.01000	0.00143	
FEATURE(16)		CIR					
	FORM	0.00026					
	DM	0.37671	0.37500	0.00500	-0.00500	0.00171	
FEATURE(17)		AXI					
	DZ	-0.47894	0.48000	0.01000	-0.01000	-0.00106	
FEATURE(18)		CIR					
	FORM	0.00026					
	DM	0.47029	0.46900	0.00200	0.00000	0.00129	
FEATURE_18A		AXI					
	DY	-0.06197	0.06000	0.01000	-0.01000	0.00197	
FEATURE_18B		AXI					
	DY	0.38191	0.38000	0.01000	-0.01000	0.00191	
FEA_20(1)		AXI					
	DY	-0.06181	0.06000	0.01000	-0.01000	0.00181	
POS\$FEA_20(1)		AXI					
	POSITN	0.00302	0.00000	0.01000	0.00000	0.00302	
FEA_20(2)		AXI					
	DX	0.06146	0.06000	0.01000	-0.01000	0.00146	
POS\$FEA_20(2)		AXI					
	POSITN	0.00030	0.00000	0.01000	0.00000	0.00030	
FEA_20(3)		AXI					
	DY	-0.06182	0.06000	0.01000	-0.01000	0.00182	
POS\$FEA_20(3)		AXI					
	POSITN	0.00302	0.00000	0.01000	0.00000	0.00302	
FEA_20(4)		AXI					
	DX	0.06150	0.06000	0.01000	-0.01000	0.00150	
POS\$FEA_20(4)		AXI					
	POSITN	0.00014	0.00000	0.01000	0.00000	0.00014	
FEAT_21(1)		AXI					
	DZ	0.06982	0.07000	0.01000	-0.01000	-0.00018	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
FEAT_21(2)			AXI				
DZ		0.06980	0.07000	0.01000	-0.01000	-0.00020	
FEAT_21(3)			AXI				
DZ		0.06994	0.07000	0.01000	-0.01000	-0.00006	
FEAT_21(4)			AXI				
DZ		0.07000	0.07000	0.01000	-0.01000	0.00000	
DAT_B_OP			CYL				
DM		0.37495					
FORM		0.00012					
FEATURE(22)			PLA				
FORM		0.00005					
Z		-2.26131					
FEATURE(23)			PLA				
PARALL		0.00025	0.00000	0.00100	0.00000	0.00025	
FEA(24)			PLA				
Z		-2.49676	2.49700	0.00200	0.00000	-0.00024	-0.00024 ◀
FORM		0.00003					
FEATURE(24)			PLA				
PARALL		0.00007	0.00000	0.00100	0.00000	0.00007	
FEATURE(25)			AXI				
DZ		-0.23545	0.23500	0.00100	0.00000	0.00045	
FEATURE(26)			AXI				
Z		-2.49676	2.49700	0.00200	0.00000	-0.00024	-0.00024 ◀
FEATURE(27)			AXI				
DZ		-0.07910	0.08000	0.01000	-0.01000	-0.00090	
FEATURE(28)			CIR				
FORM		0.00003					
DM		3.29798	3.30000	0.01000	-0.01000	-0.00202	
FEAT(28)			AXI				
RADRUN		0.00008	0.00000	0.00500	0.00000	0.00008	
FEATURE(30)			CYL				
FORM		0.00005					
DM		0.99754	0.99800	0.00000	-0.00100	-0.00046	
FEATURE(31)			AXI				
RADRUN		0.00005	0.00000	0.00100	0.00000	0.00005	
FEATURE(32)			AXI				
RADRUN		0.00031	0.00000	0.00100	0.00000	0.00031	
FEATURE(29)			TOR				
FORM		0.00100					
Cir_RA		0.04990	0.05000	0.00050	-0.00050	-0.00010	
OUT_DM		0.57439	0.57500	0.00100	-0.00100	-0.00061	
INN_DM		0.37478	0.37500			-0.00022	
X		0.00004					
Y		-0.00004					

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


FEA(33)

PLA

FORM 0.00010
 Z -2.54628


FEATURE(34)

AXI

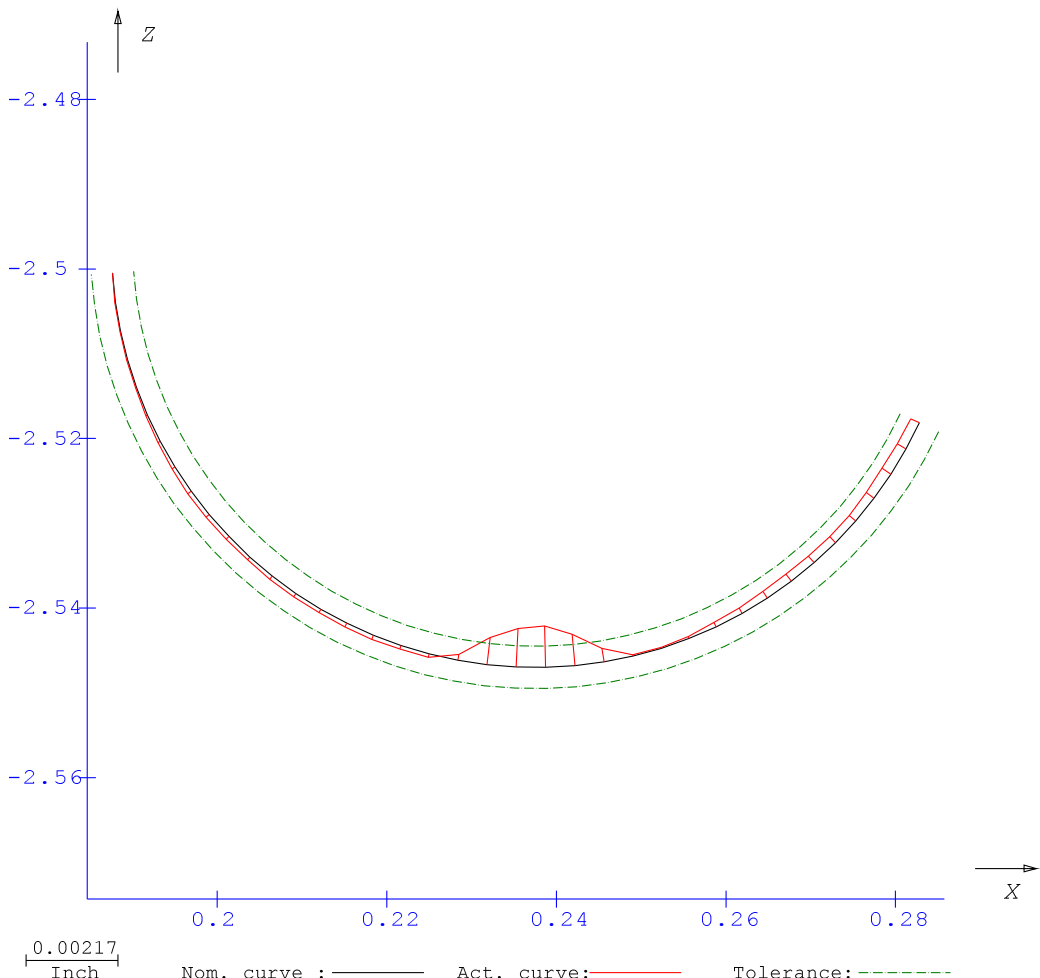
DZ 0.04952 0.05000 0.00050 -0.00050 -0.00048 

FEATURE(41)

CIR

FORM 0.00020
 RA 0.01678 0.01600 0.00200 -0.00200 0.00078 

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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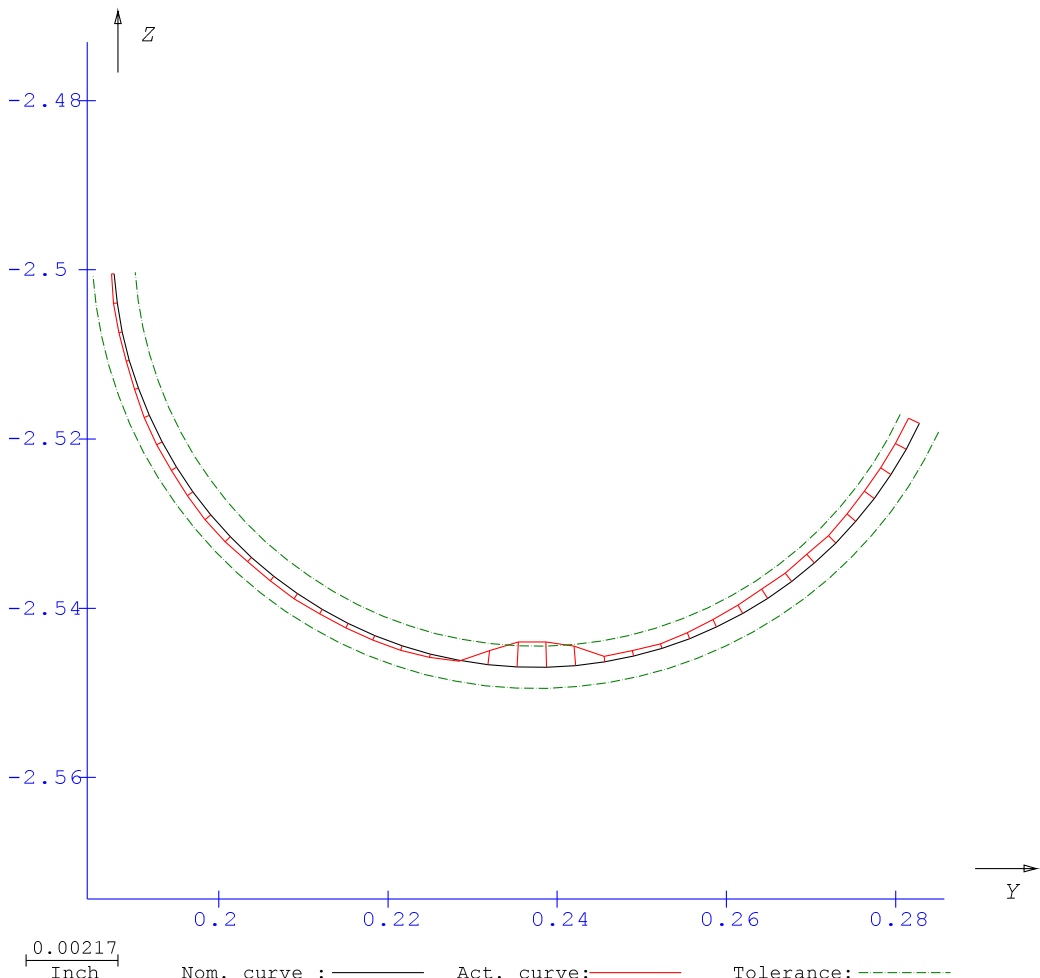
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(1)

	X	Y	Z	Nr.			
Form	0.00108	Min. Deviat.:-0.00011	0.21842	0.00000	-2.54322	23	
Lower Toler. :-	-0.00050	Max. Deviat.:	0.00097	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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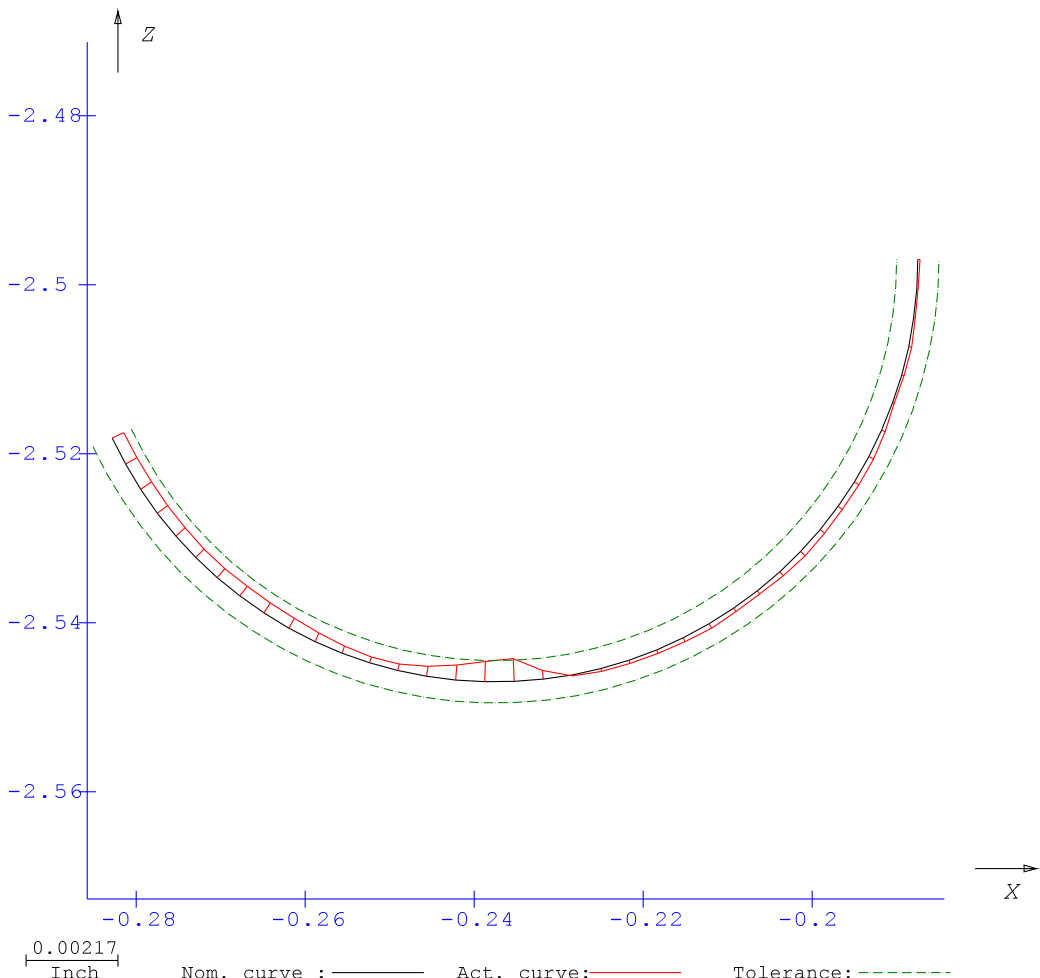
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

	X	Y	Z	Nr.
Form	0.00078	0.00000	-2.54698	17
Lower Toler. :	-0.00050	0.00000	-2.52897	30
Upper Toler. :	0.00050	0.19905		
Error Magnif.:	5	Profile of Radius 0.0500 @ 90°		
No. of points:	39			



2D - CONTOUR

Inspector.:kcaban
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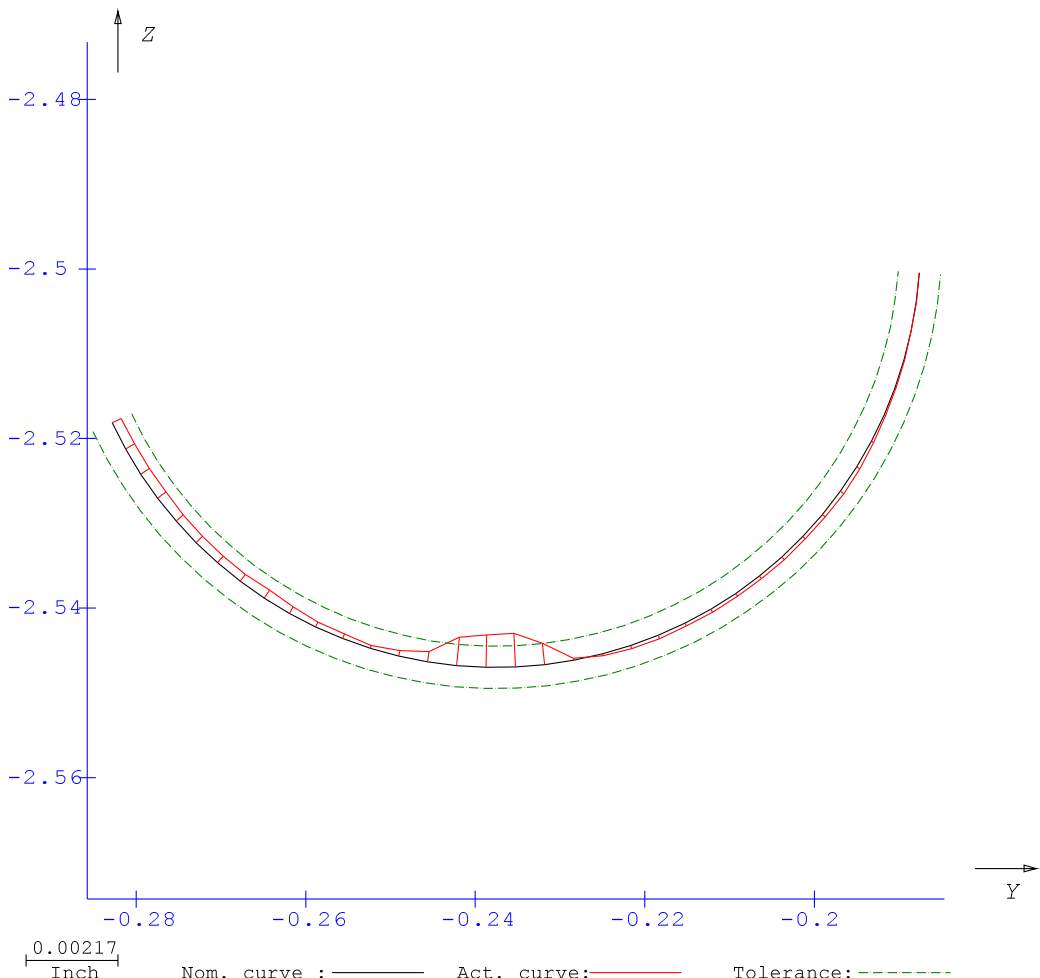
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

	X	Y	Z	Nr.		
Form	0.00069	Min. Deviat.:-0.00054	-0.23526	0.00000	-2.54695	18
Lower Toler. :	-0.00050	Max. Deviat.: 0.00015	-0.20136	0.00000	-2.53156	29
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 180°				
No. of points:	40					



2D - CONTOUR

Inspector.:kcaban
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Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 002 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.
Form	0.00089	0.00000	-0.23526	-2.54695	18
Lower Toler. :	-0.00050	0.00000	-0.19693	-2.52623	31
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Profile of Radius 0.0500
@ 270°



2D - CONTOUR

Inspector.:kcaban
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