

Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	006
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, 08:36:22
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	0.00025	0.00000	0.00100	0.00000	0.00025	
DATUM_B		CYL					
	DM	0.37500	0.37500	0.00050	-0.00050	0.00000	
CYL_B		CYL					
	CYLFRM	0.00016	0.00000	0.00050	0.00000	0.00016	
SQR_B		AXI					
	SQRNES	0.00011	0.00000	0.00100	0.00000	0.00011	
FEATURE(1)		CYL					
	DM	0.99773	0.99800	0.00000	-0.00100	-0.00027	
FEATURE(2)		AXI					
	RADRUN	0.00091	0.00000	0.00100	0.00000	0.00091	
FEATURE(3)		PLA					
	Z	0.29598	0.29600	0.00500	-0.00500	-0.00002	
FEATURE(6)		CYL					
	FORM	0.00003					
	DM	0.28096	0.28100	0.00500	-0.00500	-0.00004	
	X	-0.00589	0.00000			0.00589	
	Y	0.89872	0.90000			-0.00128	
POS_FEATURE(6)		AXI					
	POSITN			0.03000			
	POSMMC	0.01236	0.00000	0.03492	0.00000	0.01236	
FEATURE(7)		CYL					
	FORM	0.00005					
	DM	0.28082	0.28100	0.00500	-0.00500	-0.00018	
	X	-0.64047	0.63630			0.00417	
	Y	0.63158	0.63630			-0.00472	
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	0.01262	0.00000	0.03477	0.00000	0.01262		

FEATURE(8)		CYL					
FORM	0.00016						
DM	0.28082	0.28100	0.00500	-0.00500	-0.00018		
X	-0.90045	0.90000			0.00045		
Y	-0.00625	0.00000			0.00625		

POS_FEATURE(8)		AXI					
POSITN			0.03000				
POSMMC	0.01253	0.00000	0.03463	0.00000	0.01253		

FEATURE(9)		CYL					
FORM	0.00002						
DM	0.28081	0.28100	0.00500	-0.00500	-0.00019		
X	-0.63272	0.63630			-0.00358		
Y	-0.64132	0.63630			0.00502		

POS_FEATURE(9)		AXI					
POSITN			0.03000				
POSMMC	0.01239	0.00000	0.03479	0.00000	0.01239		

FEATURE(10)		CYL					
FORM	0.00002						
DM	0.28085	0.28100	0.00500	-0.00500	-0.00015		
X	0.00496	0.00000			0.00496		
Y	-0.90098	0.90000			0.00098		

POS_FEATURE(10)		AXI					
POSITN			0.03000				
POSMMC	0.01020	0.00000	0.03484	0.00000	0.01020		

FEATURE(11)		CYL					
FORM	0.00001						
DM	0.28086	0.28100	0.00500	-0.00500	-0.00014		
X	0.64000	0.63630			0.00370		
Y	-0.63386	0.63630			-0.00244		

POS_FEATURE(11)		AXI					
POSITN			0.03000				
POSMMC	0.00906	0.00000	0.03485	0.00000	0.00906		

FEATURE(12)		CYL					
FORM	0.00002						
DM	0.28094	0.28100	0.00500	-0.00500	-0.00006		
X	0.89958	0.90000			-0.00042		
Y	0.00421	0.00000			0.00421		

POS_FEATURE(12)		AXI					
POSITN			0.03000				
POSMMC	0.00858	0.00000	0.03491	0.00000	0.00858		

FEATURE(13)		CYL					
FORM	0.00004						
DM	0.28097	0.28100	0.00500	-0.00500	-0.00003		
X	0.63231	0.63630			-0.00399		
Y	0.63901	0.63630			0.00271		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 22-Oct-09, 08:36:23			NO\$NAME			Page 2 of 9	

Date: 22-Oct-09, 08:36:23			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	0.00988	0.00000	0.03493	0.00000	0.00988	
FEATURE(14)		CYL					
	FORM	0.00099					
	DM	3.50001	3.50000	0.00500	-0.00500	0.00001	
FEATURE(15)		AXI					
	RADRUN	0.00105	0.00000	0.00100	0.00000	0.00105	0.00005
FEATURE(4)		CIR					
	DM	0.37613	0.37500	0.00500	-0.00500	0.00113	
FEATURE(5)		AXI					
	DY	-1.37107	1.37000	0.01000	-0.01000	0.00107	
FEATURE(16)		CIR					
	FORM	0.00025					
	DM	0.37675	0.37500	0.00500	-0.00500	0.00175	
FEATURE(17)		AXI					
	DZ	-0.47763	0.48000	0.01000	-0.01000	-0.00237	
FEATURE(18)		CIR					
	FORM	0.00049					
	DM	0.47017	0.46900	0.00200	0.00000	0.00117	
FEATURE_18A		AXI					
	DY	-0.06123	0.06000	0.01000	-0.01000	0.00123	
FEATURE_18B		AXI					
	DY	0.38105	0.38000	0.01000	-0.01000	0.00105	
FEA_20(1)		AXI					
	DY	-0.06179	0.06000	0.01000	-0.01000	0.00179	
POS\$FEA_20(1)		AXI					
	POSITN	0.00250	0.00000	0.01000	0.00000	0.00250	
FEA_20(2)		AXI					
	DX	0.06160	0.06000	0.01000	-0.01000	0.00160	
POS\$FEA_20(2)		AXI					
	POSITN	0.00002	0.00000	0.01000	0.00000	0.00002	
FEA_20(3)		AXI					
	DY	-0.06187	0.06000	0.01000	-0.01000	0.00187	
POS\$FEA_20(3)		AXI					
	POSITN	0.00247	0.00000	0.01000	0.00000	0.00247	
FEA_20(4)		AXI					
	DX	0.06150	0.06000	0.01000	-0.01000	0.00150	
POS\$FEA_20(4)		AXI					
	POSITN	0.00006	0.00000	0.01000	0.00000	0.00006	
FEAT_21(1)		AXI					
	DZ	0.06830	0.07000	0.01000	-0.01000	-0.00170	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
FEAT_21(2)			AXI				
DZ		0.06796	0.07000	0.01000	-0.01000	-0.00204	
FEAT_21(3)			AXI				
DZ		0.06826	0.07000	0.01000	-0.01000	-0.00174	
FEAT_21(4)			AXI				
DZ		0.06820	0.07000	0.01000	-0.01000	-0.00180	
DAT_B_OP			CYL				
DM		0.37507					
FORM		0.00013					
FEATURE(22)			PLA				
FORM		0.00006					
Z		-2.26154					
FEATURE(23)			PLA				
PARALL		0.00052	0.00000	0.00100	0.00000	0.00052	
FEA(24)			PLA				
Z		-2.49698	2.49700	0.00200	0.00000	-0.00002	-0.00002 ◀
FORM		0.00003					
FEATURE(24)			PLA				
PARALL		0.00010	0.00000	0.00100	0.00000	0.00010	
FEATURE(25)			AXI				
DZ		-0.23544	0.23500	0.00100	0.00000	0.00044	
FEATURE(26)			AXI				
Z		-2.49698	2.49700	0.00200	0.00000	-0.00002	-0.00002 ◀
FEATURE(27)			AXI				
DZ		-0.07894	0.08000	0.01000	-0.01000	-0.00106	
FEATURE(28)			CIR				
FORM		0.00073					
DM		3.29779	3.30000	0.01000	-0.01000	-0.00221	
FEAT(28)			AXI				
RADRUN		0.00093	0.00000	0.00500	0.00000	0.00093	
FEATURE(30)			CYL				
FORM		0.00006					
DM		0.99752	0.99800	0.00000	-0.00100	-0.00048	
FEATURE(31)			AXI				
RADRUN		0.00026	0.00000	0.00100	0.00000	0.00026	
FEATURE(32)			AXI				
RADRUN		0.00132	0.00000	0.00100	0.00000	0.00132	0.00032 ◀
FEATURE(29)			TOR				
FORM		0.00080					
Cir_RA		0.04987	0.05000	0.00050	-0.00050	-0.00013	
OUT_DM		0.57425	0.57500	0.00100	-0.00100	-0.00075	
INN_DM		0.37477	0.37500			-0.00023	
X		-0.00007					
Y		0.00008					

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 0.00015
 Z -2.54654


FEATURE(34)

AXI

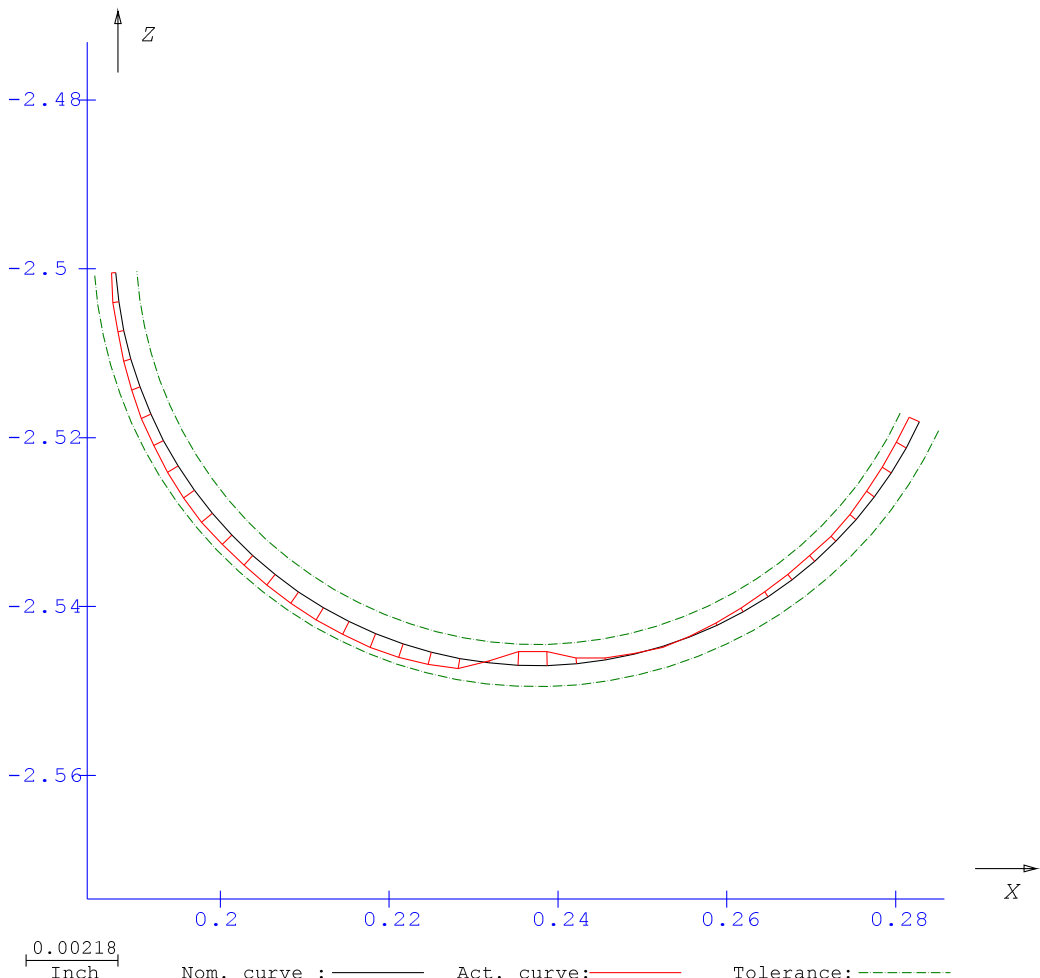
DZ 0.04956 0.05000 0.00050 -0.00050 -0.00044 

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

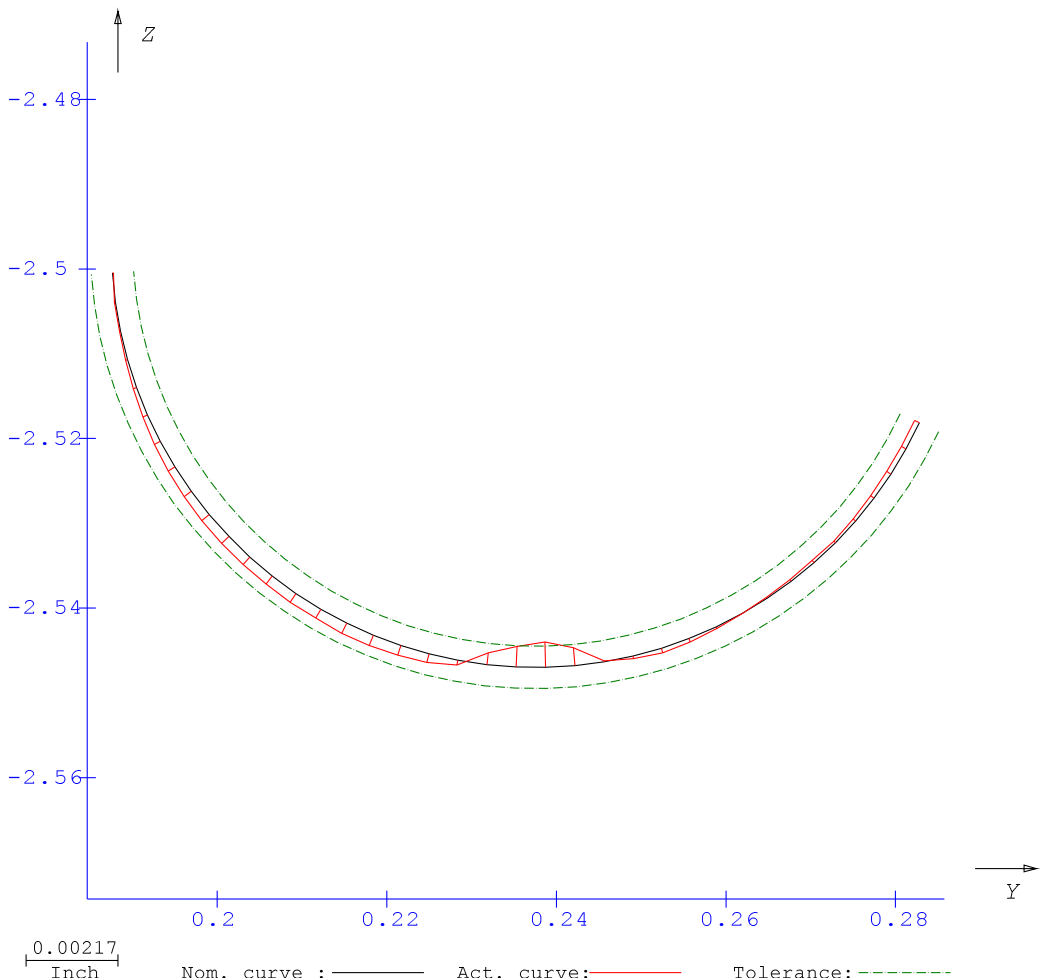
		X	Y	Z	Nr.
Form	0.00068	0.21842	0.00000	-2.54322	23
Lower Toler. :	-0.00050	0.23873	0.00000	-2.54698	17
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00035 Profile of Radius 0.0500
 Max. Deviat.: 0.00033 @ 0°



2D - CONTOUR

Inspector.:kcaban
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Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 006 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(2)

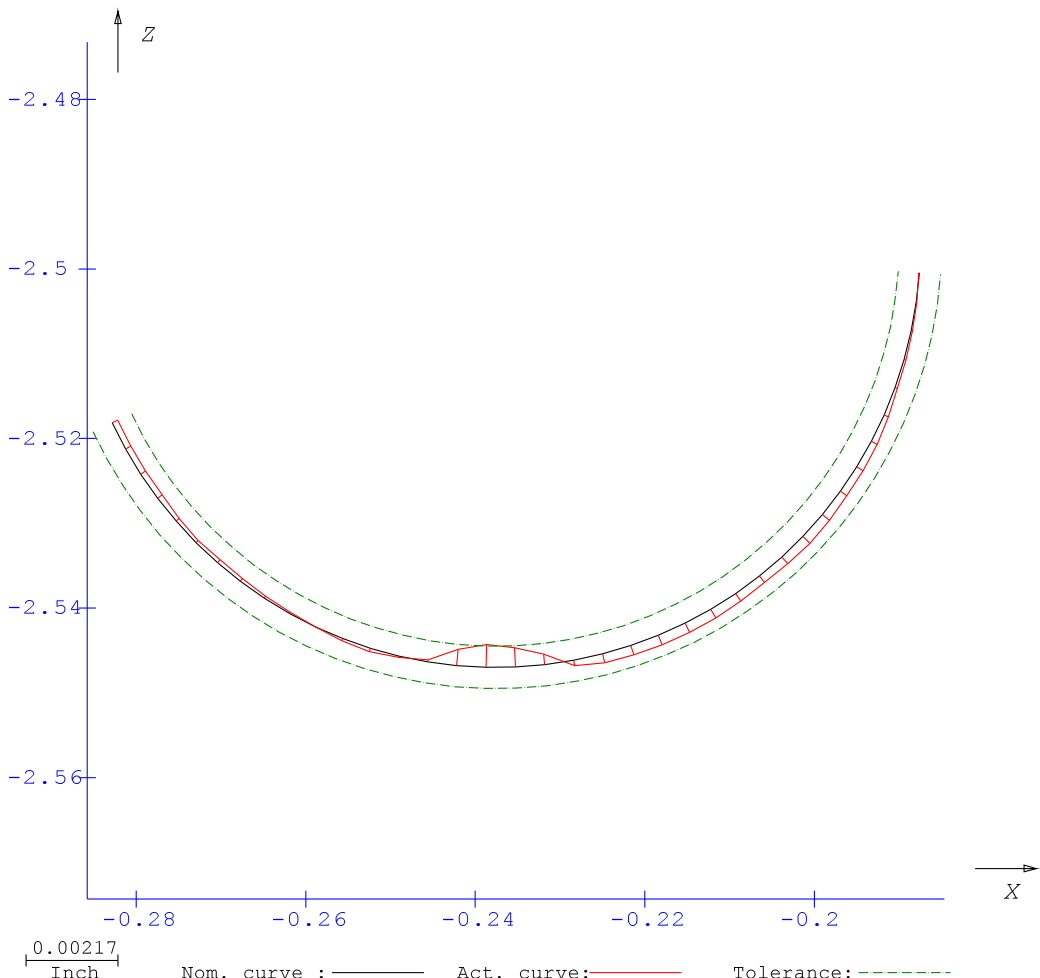
	X	Y	Z	Nr.
Form	0.00086	0.00000	-2.54698	17
Lower Toler. :	-0.00050	0.00000	-2.54178	24
Upper Toler. :	0.00050			
Error Magnif.:	5			
No. of points:	39			

Min. Deviat.: -0.00060 Max. Deviat.: 0.00026 Profile of Radius 0.0500 @ 90°



2D - CONTOUR

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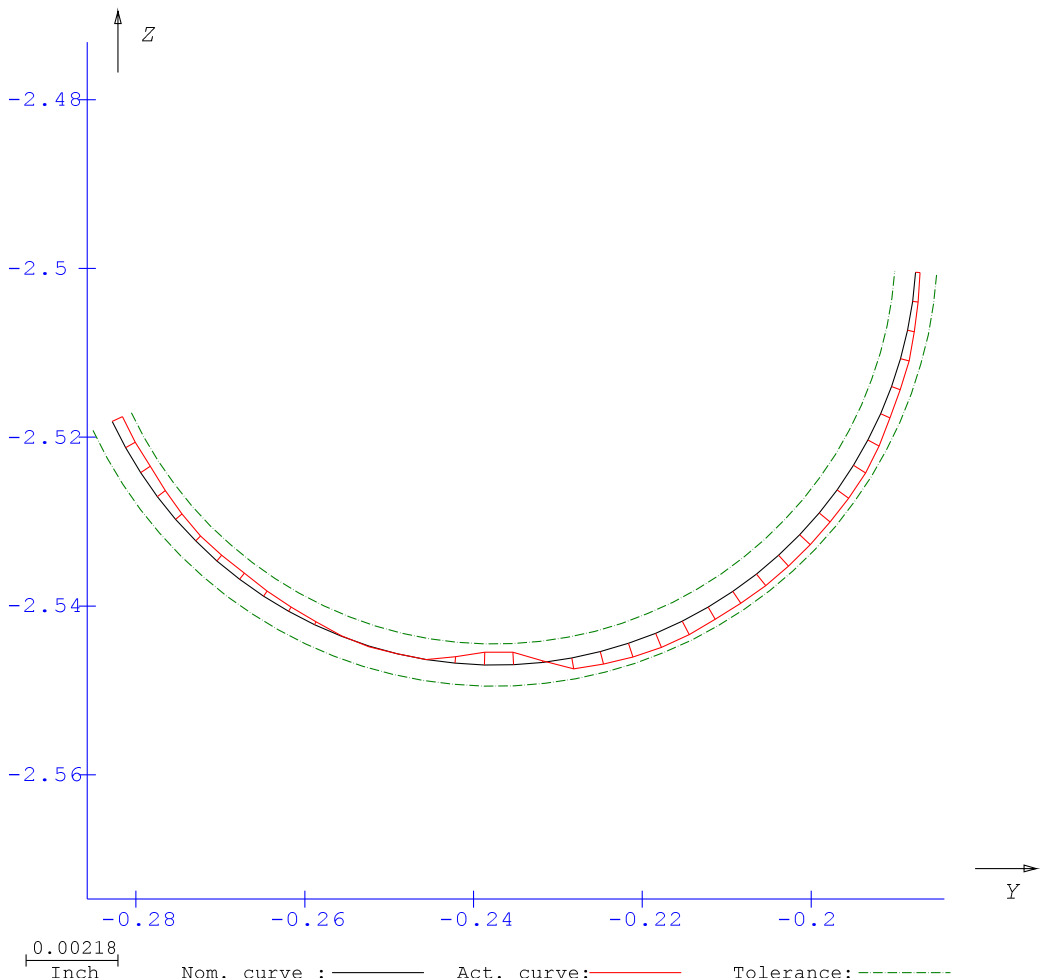
Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 006 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(3)

		X	Y	Z	Nr.	
Form	0.00078	Min. Deviat.:-0.00054	-0.23873	0.00000	-2.54698	17
Lower Toler. :	-0.00050	Max. Deviat.: 0.00024	-0.21526	0.00000	-2.54178	24
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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 Time:08:36:22



Notation : DRIFT TUBE 4 Producer : L. GARCIA Draw. No. : PF-700-913-14 R
 Ser. No. : 006 Part No. : Department: MET. QUALITY IN
 Element : FEATURE_29(4)

		X	Y	Z	Nr.
Form	0.00066	0.00000	-0.23873	-2.54698	17
Lower Toler. :	-0.00050	0.00000	-0.21526	-2.54178	24
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00030 Profile of Radius 0.0500
 Max. Deviat.: 0.00036 @ 270°



2D - CONTOUR

Inspector.:kcaban
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