

# Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 4	Customer	L. GARCIA
Drawing Number	PF-700-913-14 R1	Serial Number	009
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, 11:41:10
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
<b>DATUM_A</b>		<b>PLA</b>					
	FLATNS	0.00024	0.00000	0.00100	0.00000	0.00024	
<b>DATUM_B</b>		<b>CYL</b>					
	DM	0.37498	0.37500	0.00050	-0.00050	-0.00002	
<b>CYL_B</b>		<b>CYL</b>					
	CYLFRM	0.00013	0.00000	0.00050	0.00000	0.00013	
<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	0.99765	0.99800	0.00000	-0.00100	-0.00035	
<b>FEATURE(2)</b>		<b>AXI</b>					
	RADRUN	0.00040	0.00000	0.00100	0.00000	0.00040	
<b>FEATURE(3)</b>		<b>PLA</b>					
	Z	0.29593	0.29600	0.00500	-0.00500	-0.00007	
<b>FEATURE(6)</b>		<b>CYL</b>					
	FORM	0.00008					
	DM	0.28085	0.28100	0.00500	-0.00500	-0.00015	
	X	-0.00535	0.00000			0.00535	
	Y	0.89891	0.90000			-0.00109	
<b>POS_FEATURE(6)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01137	0.00000	0.03475	0.00000	0.01137	
<b>FEATURE(7)</b>		<b>CYL</b>					
	FORM	0.00003					
	DM	0.28050	0.28100	0.00500	-0.00500	-0.00050	
	X	-0.64027	0.63630			0.00397	
	Y	0.63177	0.63630			-0.00453	
<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, 11:41:10			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	0.01214	0.00000	0.03448	0.00000	0.01214		

<b>FEATURE(8)</b>		<b>CYL</b>					
FORM	0.00002						
DM	0.28056	0.28100	0.00500	-0.00500	-0.00044		
X	-0.90022	0.90000			0.00022		
Y	-0.00628	0.00000			0.00628		

<b>POS_FEATURE(8)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01258	0.00000	0.03454	0.00000	0.01258		

<b>FEATURE(9)</b>		<b>CYL</b>					
FORM	0.00005						
DM	0.28060	0.28100	0.00500	-0.00500	-0.00040		
X	-0.63271	0.63630			-0.00359		
Y	-0.64083	0.63630			0.00453		

<b>POS_FEATURE(9)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01163	0.00000	0.03456	0.00000	0.01163		

<b>FEATURE(10)</b>		<b>CYL</b>					
FORM	0.00007						
DM	0.28067	0.28100	0.00500	-0.00500	-0.00033		
X	0.00556	0.00000			0.00556		
Y	-0.90119	0.90000			0.00119		

<b>POS_FEATURE(10)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01184	0.00000	0.03460	0.00000	0.01184		

<b>FEATURE(11)</b>		<b>CYL</b>					
FORM	0.00008						
DM	0.28055	0.28100	0.00500	-0.00500	-0.00045		
X	0.64013	0.63630			0.00383		
Y	-0.63355	0.63630			-0.00275		

<b>POS_FEATURE(11)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00950	0.00000	0.03449	0.00000	0.00950		

<b>FEATURE(12)</b>		<b>CYL</b>					
FORM	0.00002						
DM	0.28063	0.28100	0.00500	-0.00500	-0.00037		
X	0.89984	0.90000			-0.00016		
Y	0.00450	0.00000			0.00450		

<b>POS_FEATURE(12)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00925	0.00000	0.03461	0.00000	0.00925		

<b>FEATURE(13)</b>		<b>CYL</b>					
FORM	0.00007						
DM	0.28071	0.28100	0.00500	-0.00500	-0.00029		
X	0.63265	0.63630			-0.00365		
Y	0.63892	0.63630			0.00262		

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Date: 22-Oct-09, 11:41:10			NO\$NAME			Page 3 of 9	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>POS_FEATURE(13)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.00919	0.00000	0.03464	0.00000	0.00919	
<b>FEATURE(14)</b>		<b>CYL</b>					
	FORM	0.00083					
	DM	3.50036	3.50000	0.00500	-0.00500	0.00036	
<b>FEATURE(15)</b>		<b>AXI</b>					
	RADRUN	0.00092	0.00000	0.00100	0.00000	0.00092	
<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	-1.37082	1.37000	0.01000	-0.01000	0.00082	
<b>FEATURE(16)</b>		<b>CIR</b>					
	FORM	0.00018					
	DM	0.37673	0.37500	0.00500	-0.00500	0.00173	
<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	0.00032					
	DM	0.47022	0.46900	0.00200	0.00000	0.00122	
<b>FEATURE_18A</b>		<b>AXI</b>					
	DY	-0.06181	0.06000	0.01000	-0.01000	0.00181	
<b>FEATURE_18B</b>		<b>AXI</b>					
	DY	0.38167	0.38000	0.01000	-0.01000	0.00167	
<b>FEA_20(1)</b>		<b>AXI</b>					
	DY	-0.06177	0.06000	0.01000	-0.01000	0.00177	
<b>POS\$FEA_20(1)</b>		<b>AXI</b>					
	POSITN	0.00186	0.00000	0.01000	0.00000	0.00186	
<b>FEA_20(2)</b>		<b>AXI</b>					
	DX	0.06152	0.06000	0.01000	-0.01000	0.00152	
<b>POS\$FEA_20(2)</b>		<b>AXI</b>					
	POSITN	0.00042	0.00000	0.01000	0.00000	0.00042	
<b>FEA_20(3)</b>		<b>AXI</b>					
	DY	-0.06176	0.06000	0.01000	-0.01000	0.00176	
<b>POS\$FEA_20(3)</b>		<b>AXI</b>					
	POSITN	0.00183	0.00000	0.01000	0.00000	0.00183	
<b>FEA_20(4)</b>		<b>AXI</b>					
	DX	0.06160	0.06000	0.01000	-0.01000	0.00160	
<b>POS\$FEA_20(4)</b>		<b>AXI</b>					
	POSITN	0.00045	0.00000	0.01000	0.00000	0.00045	
<b>FEAT_21(1)</b>		<b>AXI</b>					
	DZ	0.06941	0.07000	0.01000	-0.01000	-0.00059	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>FEAT_21(2)</b>			<b>AXI</b>				
DZ		0.06936	0.07000	0.01000	-0.01000	-0.00064	
<b>FEAT_21(3)</b>			<b>AXI</b>				
DZ		0.06942	0.07000	0.01000	-0.01000	-0.00058	
<b>FEAT_21(4)</b>			<b>AXI</b>				
DZ		0.06948	0.07000	0.01000	-0.01000	-0.00052	
<b>DAT_B_OP</b>			<b>CYL</b>				
DM		0.37495					
FORM		0.00008					
<b>FEATURE(22)</b>			<b>PLA</b>				
FORM		0.00002					
Z		-2.26081					
<b>FEATURE(23)</b>			<b>PLA</b>				
PARALL		0.00018	0.00000	0.00100	0.00000	0.00018	
<b>FEA(24)</b>			<b>PLA</b>				
Z		-2.49628	2.49700	0.00200	0.00000	-0.00072	-0.00072 ◀
FORM		0.00005					
<b>FEATURE(24)</b>			<b>PLA</b>				
PARALL		0.00008	0.00000	0.00100	0.00000	0.00008	
<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		-2.49628	2.49700	0.00200	0.00000	-0.00072	-0.00072 ◀
<b>FEATURE(27)</b>			<b>AXI</b>				
DZ		-0.07937	0.08000	0.01000	-0.01000	-0.00063	
<b>FEATURE(28)</b>			<b>CIR</b>				
FORM		0.00042					
DM		3.29963	3.30000	0.01000	-0.01000	-0.00037	
<b>FEAT(28)</b>			<b>AXI</b>				
RADRUN		0.00059	0.00000	0.00500	0.00000	0.00059	
<b>FEATURE(30)</b>			<b>CYL</b>				
FORM		0.00007					
DM		0.99736	0.99800	0.00000	-0.00100	-0.00064	
<b>FEATURE(31)</b>			<b>AXI</b>				
RADRUN		0.00020	0.00000	0.00100	0.00000	0.00020	
<b>FEATURE(32)</b>			<b>AXI</b>				
RADRUN		0.00025	0.00000	0.00100	0.00000	0.00025	
<b>FEATURE(29)</b>			<b>TOR</b>				
FORM		0.00066					
Cir_RA		0.04999	0.05000	0.00050	-0.00050	-0.00001	
OUT_DM		0.57423	0.57500	0.00100	-0.00100	-0.00077	
INN_DM		0.37427	0.37500			-0.00073	
X		-0.00003					
Y		0.00000					

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


**FEA(33)**

**PLA**

FORM            0.00005  
 Z                -2.54593


**FEATURE(34)**

**AXI**

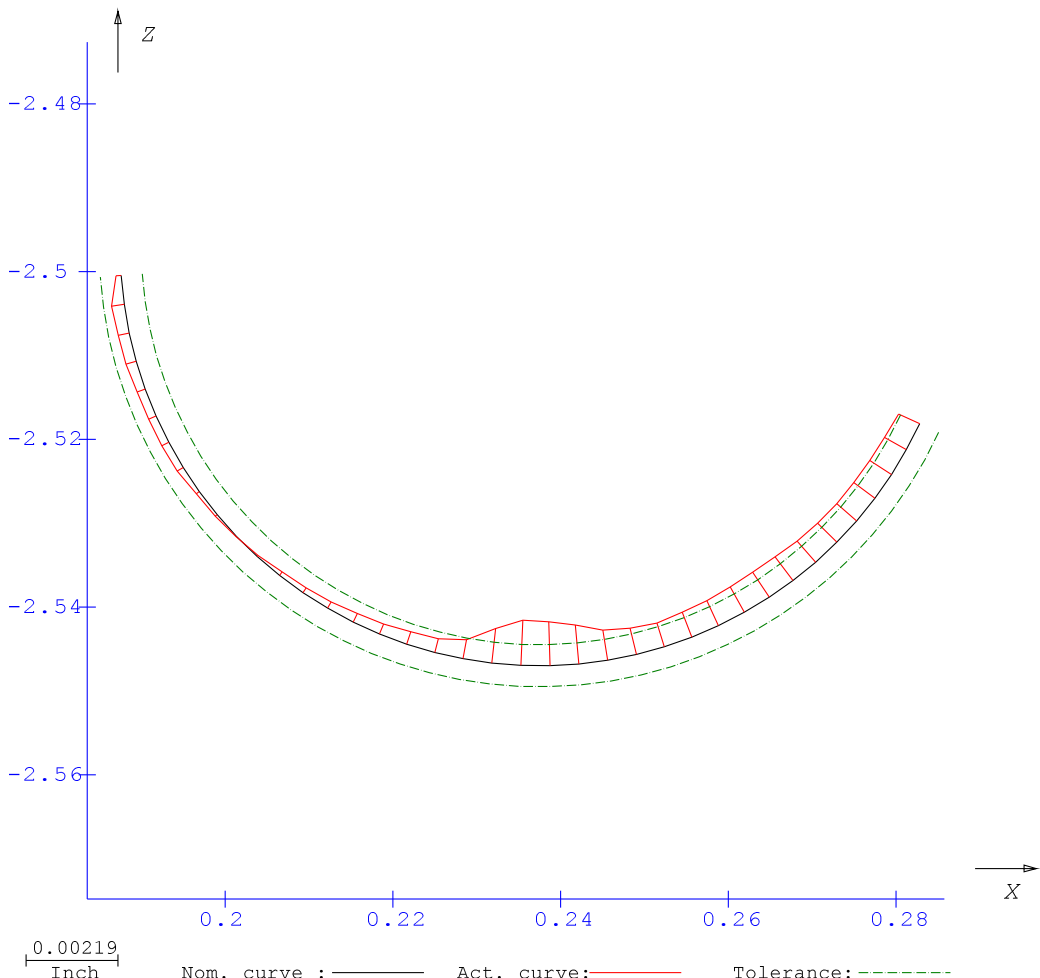
DZ                0.04966    0.05000    0.00050    -0.00050    -0.00034    

**FEATURE(41)**

**CIR**

FORM            0.00017  
 RA                0.01671    0.01600    0.00200    -0.00200    0.00071    

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

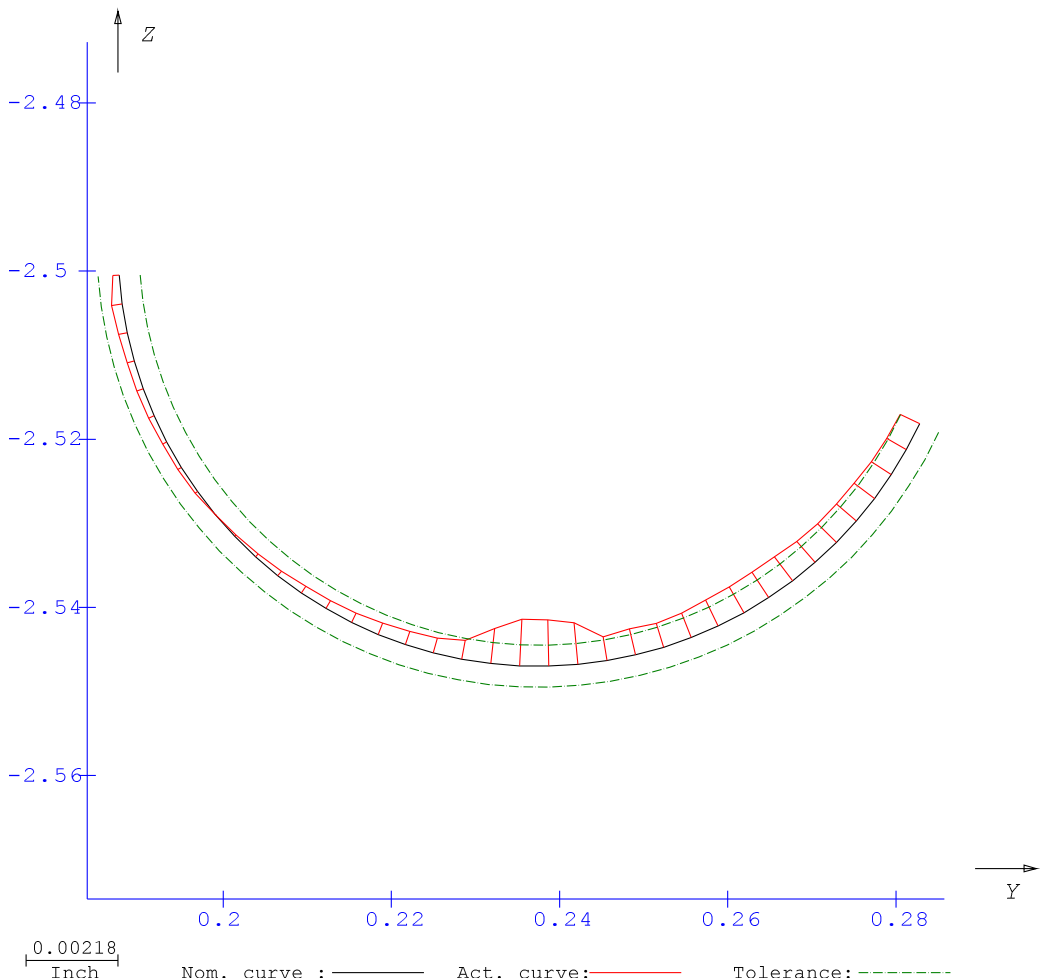
		X	Y	Z	Nr.
Form .....	0.00139	0.18798	0.00000	-2.50391	38
Lower Toler. :	-0.00050	0.23526	0.00000	-2.54695	18
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00031      Profile of Radius 0.0500  
 Max. Deviat.: 0.00108      @ 0°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:22-OCT-2009  
 Time .....:11:41:10



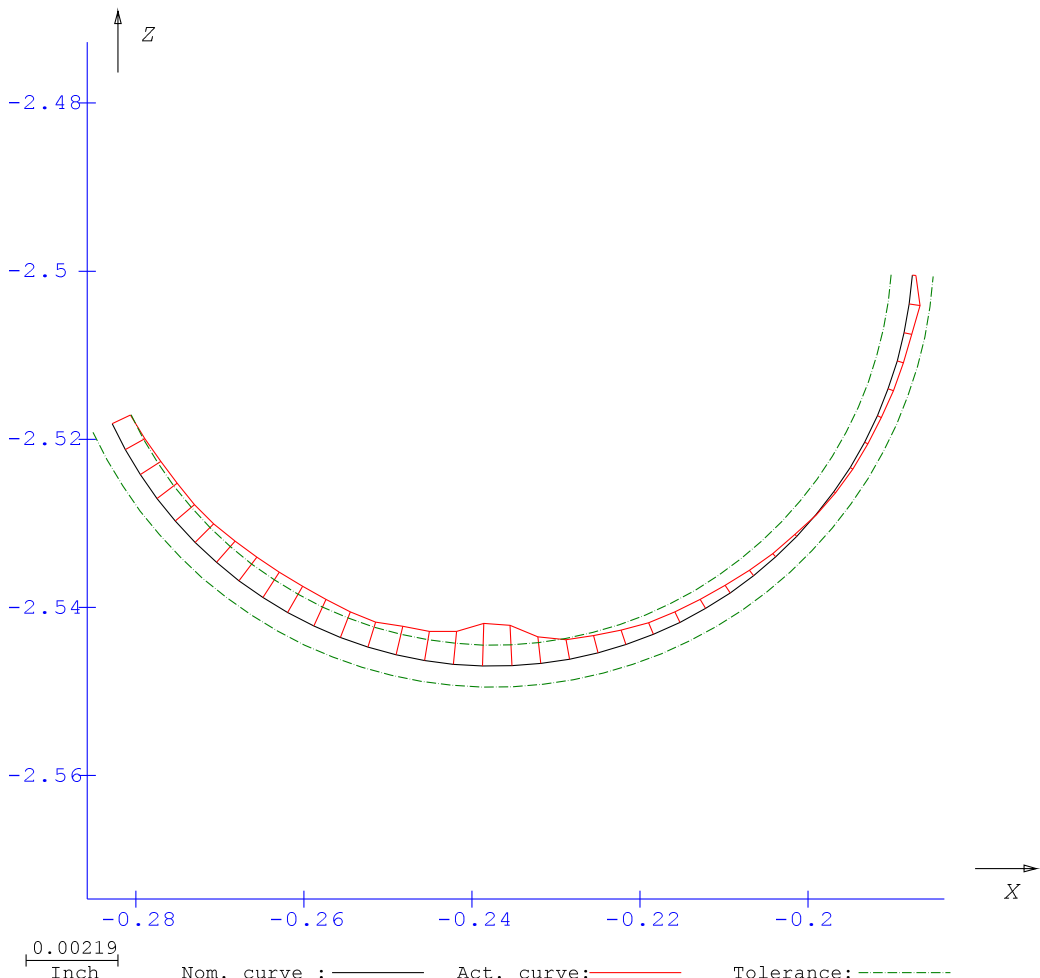
Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 009      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(2)

		X	Y	Z	Nr.		
Form .....	0.00136	Min. Deviat.:-0.00111	0.00000	0.23526	-2.54695	18	
Lower Toler. :	-0.00050	Max. Deviat.:	0.00026	0.00000	0.18798	-2.50391	38
Upper Toler. :	0.00050	Profile of Radius 0.0500					
Error Magnif.:	5	@ 90°					
No. of points:	39						



2D - CONTOUR

Inspector.:kcaban  
 Date .....:22-OCT-2009  
 Time .....:11:41:10



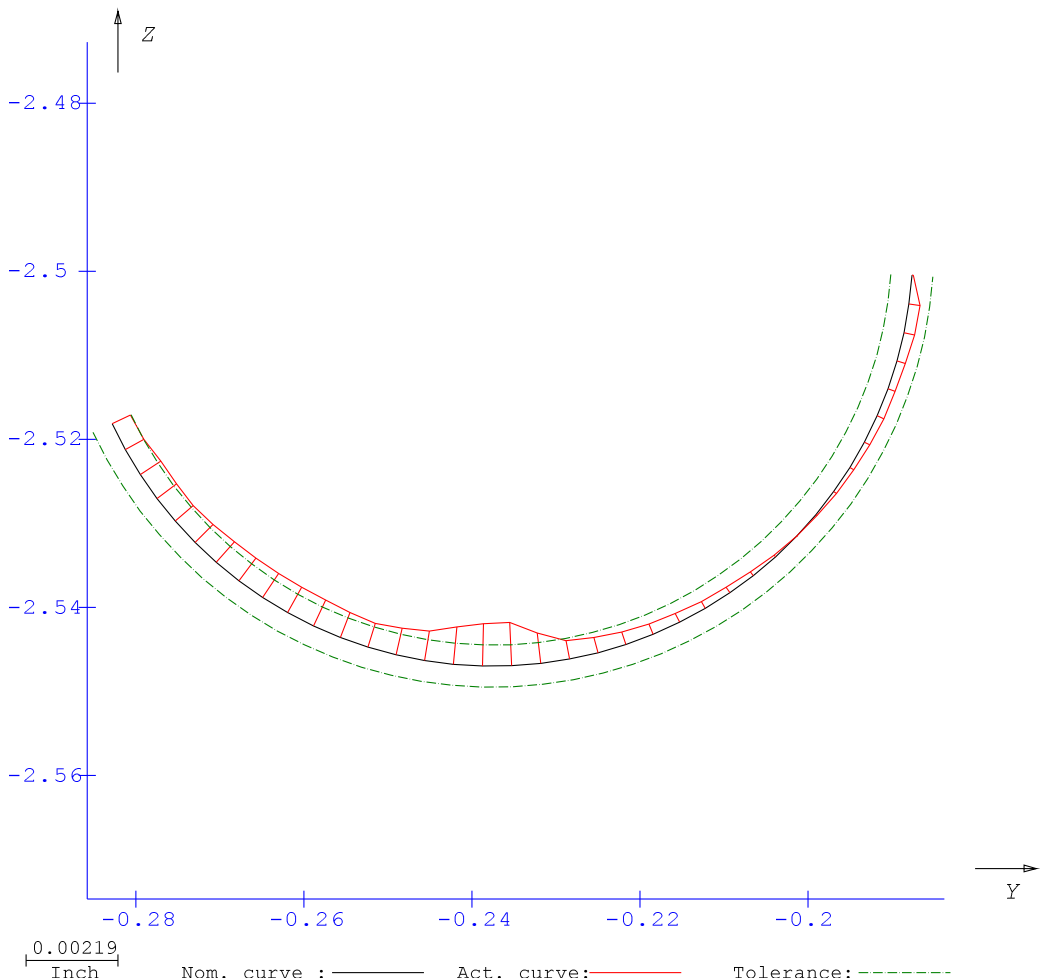
Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 009                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(3)

		X	Y	Z	Nr.		
Form .....	0.00128	Min. Deviat.:-0.00101	-0.23873	0.00000	-2.54698	17	
Lower Toler. :	-0.00050	Max. Deviat.:	0.00026	-0.18798	0.00000	-2.50391	38
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 .....:11:41:10



Notation : DRIFT TUBE 4      Producer : L. GARCIA      Draw. No. : PF-700-913-14 R  
 Ser. No. : 009                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(4)

	X	Y	Z	Nr.		
Form .....	0.00130	Min. Deviat.:-0.00103	0.00000	-0.23526	-2.54695	18
Lower Toler. :	-0.00050	Max. Deviat.: 0.00027	0.00000	-0.18798	-2.50391	38
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 270°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban  
 Date .....:22-OCT-2009  
 Time .....:11:41:10