pc-dmis	PART NAME : PN482497-n_650_5cell_1of3_alignment_v01		November 08, 2013	10:32
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

482497 Rev. none
PROJECT X - 650 MHZ
CAVITY - 5 CELL BETA=0.9
BARE CAVITY ASSEMBLY

'Inspected by ' : Robert Riley
'Cavity Serial Number' : B9A-AES-009
'Routing Form Number ' : 96018
' ' : 1311081015

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DATUM DISCS - CIRCLES
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⌖	MM	LOC1 - CIR_MCE_DD					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
X	0.000	0.000	0.000	0.250	0.250	0.000	
Z	0.000	0.000	0.000	0.250	0.250	0.000	
D	141.358	141.091	-0.267	0.250	0.250	0.017	
RN	0.000	0.008	0.008	0.250	0.000	0.000	

⌖	MM	LOC2 - CIR_FPE_DD					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
X	0.000	0.000	0.000	0.250	0.250	0.000	
Z	0.000	0.000	0.000	0.250	0.250	0.000	
D	141.356	141.064	-0.293	0.250	0.250	0.043	
RN	0.000	0.015	0.015	0.250	0.000	0.000	

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DATUM DISCS - PLANES
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⌖	MM	LOC3 - PLNC_MCE_DD					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
Y	534.814	531.717	-3.097	0.500	0.500	2.597	
FL	0.000	0.022	0.022	0.250	0.000	0.000	

⌖	MM	LOC4 - PLNC_FPE_DD					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
Y	-534.814	-531.717	3.097	0.500	0.500	2.597	
FL	0.000	0.036	0.036	0.250	0.000	0.000	

↔	MM	DIST1 - PLNC_FPE_DD TO PLNC_MCE_DD (YAXIS)					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	1069.627	1063.433	-6.194	1.000	1.000	5.194	

//	MM	PARL1 - PLNC_MCE_DD TO YPLUS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0	0.397	0.397	0.250	0	0.147	

//	MM	PARL2 - PLNC_FPE_DD TO YPLUS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0	0.091	0.091	0.250	0	0.000	

⌖	MM	LOC5 - PLNC_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
AX		I		J		K
V		-0.00259		1.00000		-0.00171

⌖	MM	LOC6 - PLNC_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
AX		I		J		K
V		-0.00023		-1.00000		-0.00089

//	MM	PARL3 - PLNC_MCE_DD TO PLNC_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0	0.477	0.477	0.250	0	0.227

//	MM	PARL4 - PLNC_FPE_DD TO PLNC_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0	0.470	0.470	0.250	0	0.220

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MAIN COUPLER CIRCLE
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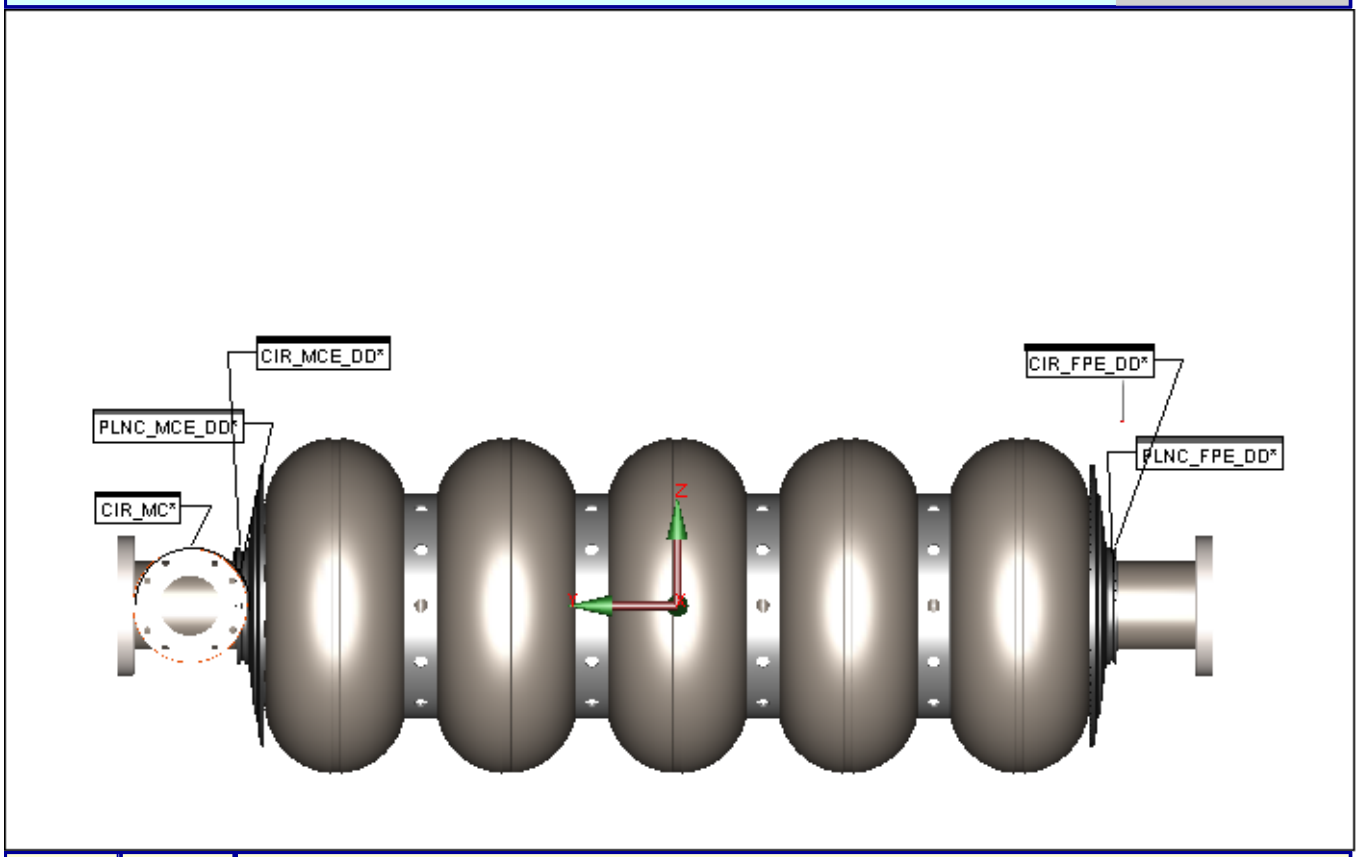
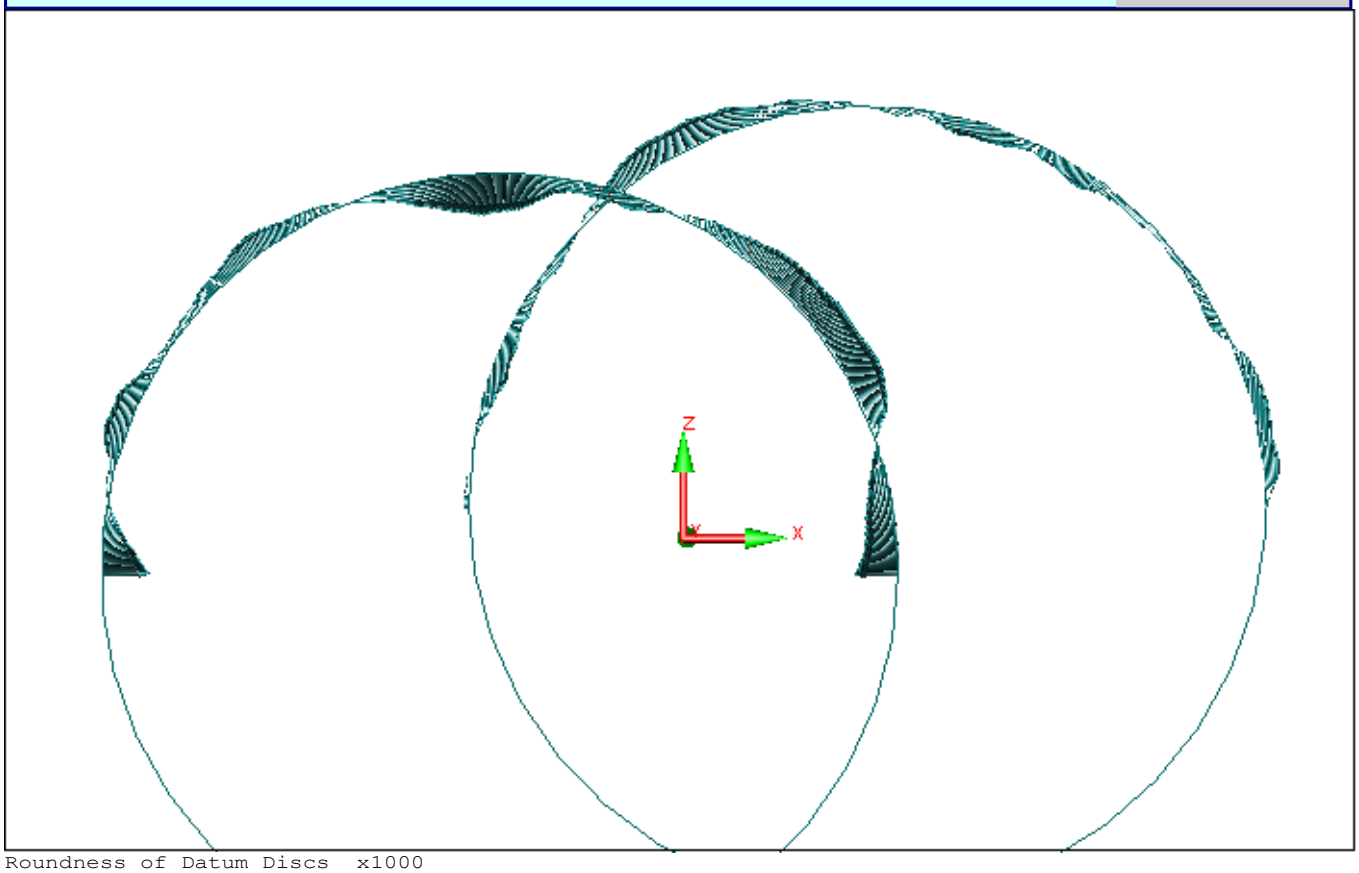
⌖	MM	LOC7 - CIR_MC				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	592.614	589.321	-3.293	0.500	0.500	2.793
Z	0.000	0.000	0.000	0.000	0.000	0.000
D	140.000	139.967	-0.033	0.200	0.200	0.000
RN	0.000	0.009	0.009	0.500	0.000	0.000



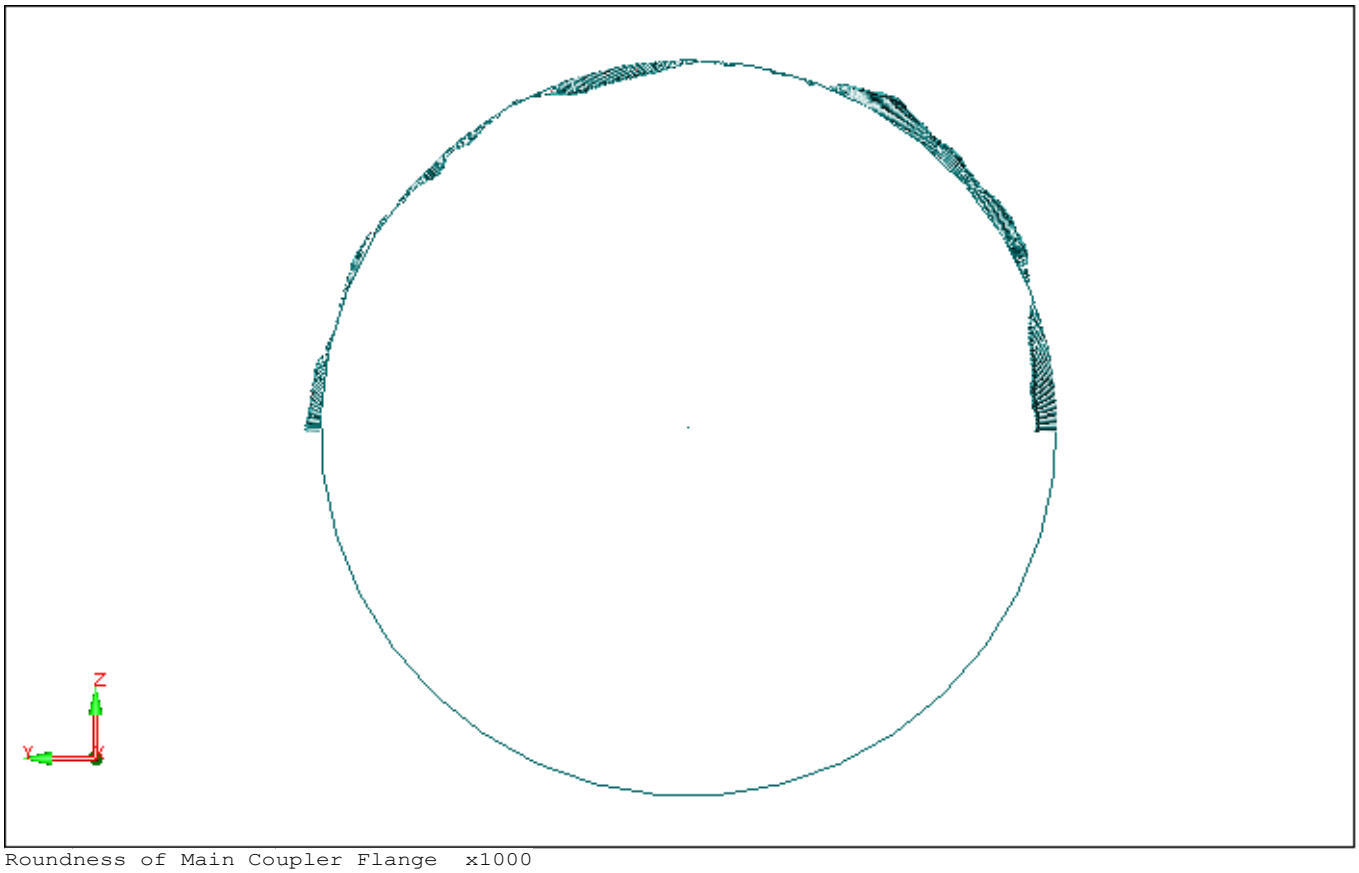
○	MM	CIRTY1 - CIR_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.008	0.008	0.250	0.000	0.000

○	MM	CIRTY2 - CIR_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.015	0.015	0.250	0.000	0.000

○	MM	CIRTY3 - CIR_MC				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.009	0.009	0.250	0.000	0.000



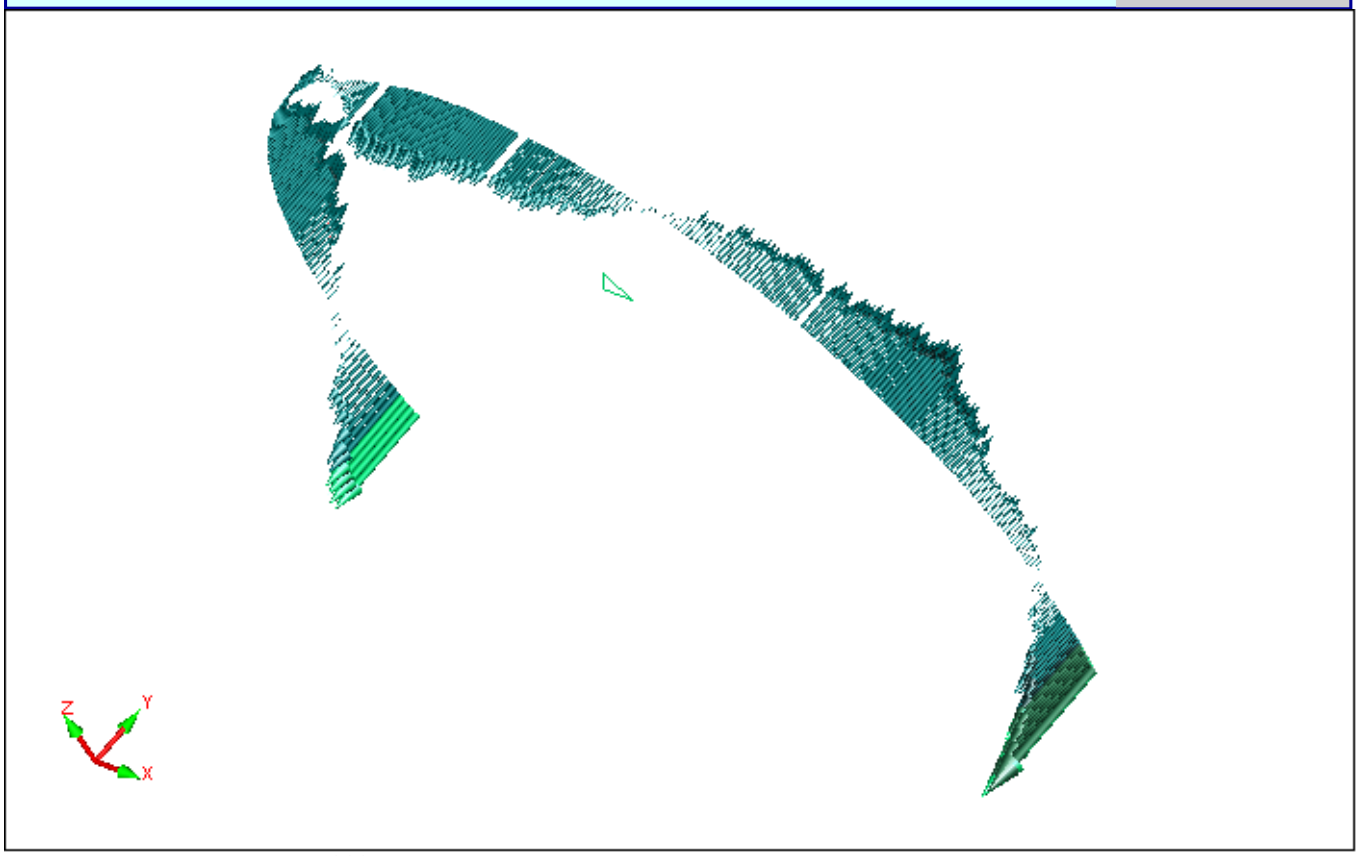
Roundness of Datum Discs x1000



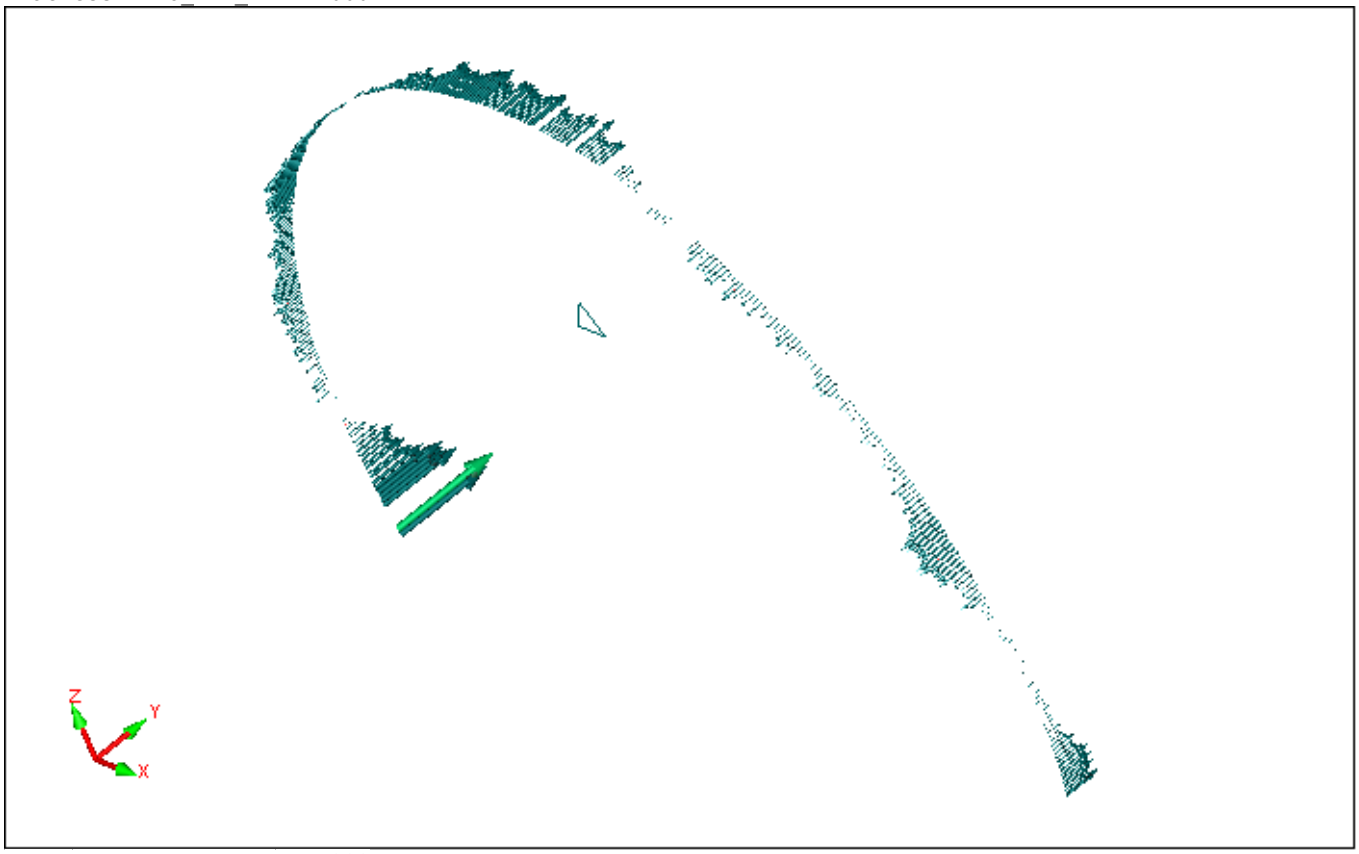
Roundness of Main Coupler Flange x1000

	MM	FLAT3 - PLNC_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.036	0.036	0.250	0.000	0.000

	MM	FLAT4 - PLNC_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.022	0.022	0.250	0.000	0.000



Flatness PLNC_FPE_DD x1000



Flatness PLNC_MCE_DD x1000