pc-dmis	PART NAME : PN482497-n_650_5cell_1of3_alignment_v01		July 25, 2014	07:40
	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-010
'Routing Form Number ' : 96021
' ' : 1407250726

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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	141.116	-0.242	0.250	0.250	0.000	
RN	0.000	0.021	0.021	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	141.052	-0.305	0.250	0.250	0.055	
RN	0.000	0.027	0.027	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	531.458	-3.355	0.500	0.500	2.855	
FL	0.000	0.026	0.026	0.250	0.000	0.000	

⌖	MM	LOC4 - PLNC_FPE_DD					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
Y	-534.814	-531.458	3.355	0.500	0.500	2.855	
FL	0.000	0.044	0.044	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	1062.917	-6.711	1.000	1.000	5.711	

//	MM	PARL1 - PLNC_MCE_DD TO YPLUS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0	0.429	0.429	0.250	0	0.179	

//	MM	PARL2 - PLNC_FPE_DD TO YPLUS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0	0.099	0.099	0.250	0	0.000	

⌖	MM	LOC5 - PLNC_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL

AX	I	J	K
V	-0.00274	0.99999	-0.00197

⌖	MM	LOC6 - PLNC_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL

AX	I	J	K
V	0.00024	-1.00000	0.00072

//	MM	PARL3 - PLNC_MCE_DD TO PLNC_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0	0.364	0.364	0.250	0	0.114

//	MM	PARL4 - PLNC_FPE_DD TO PLNC_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0	0.367	0.367	0.250	0	0.117

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MAIN COUPLER CIRCLE
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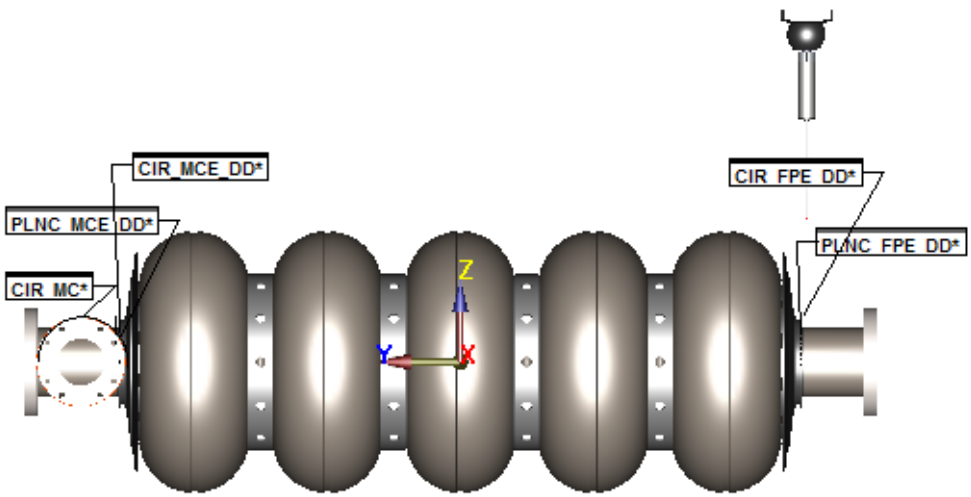
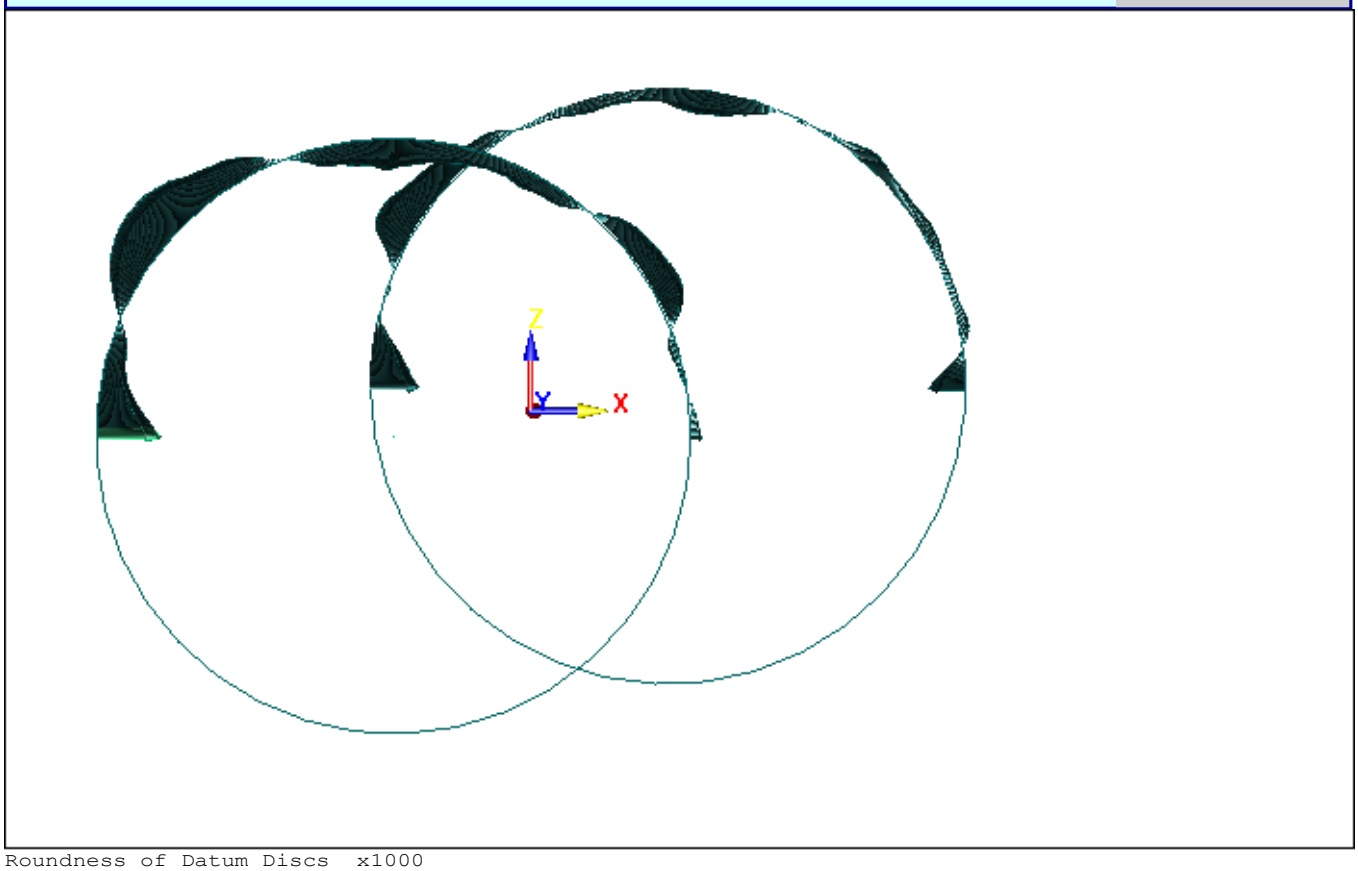
⌖	MM	LOC7 - CIR_MC				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	592.614	589.521	-3.093	0.500	0.500	2.593
Z	0.000	0.000	0.000	0.000	0.000	0.000
D	140.000	139.950	-0.050	0.200	0.200	0.000
RN	0.000	0.011	0.011	0.500	0.000	0.000



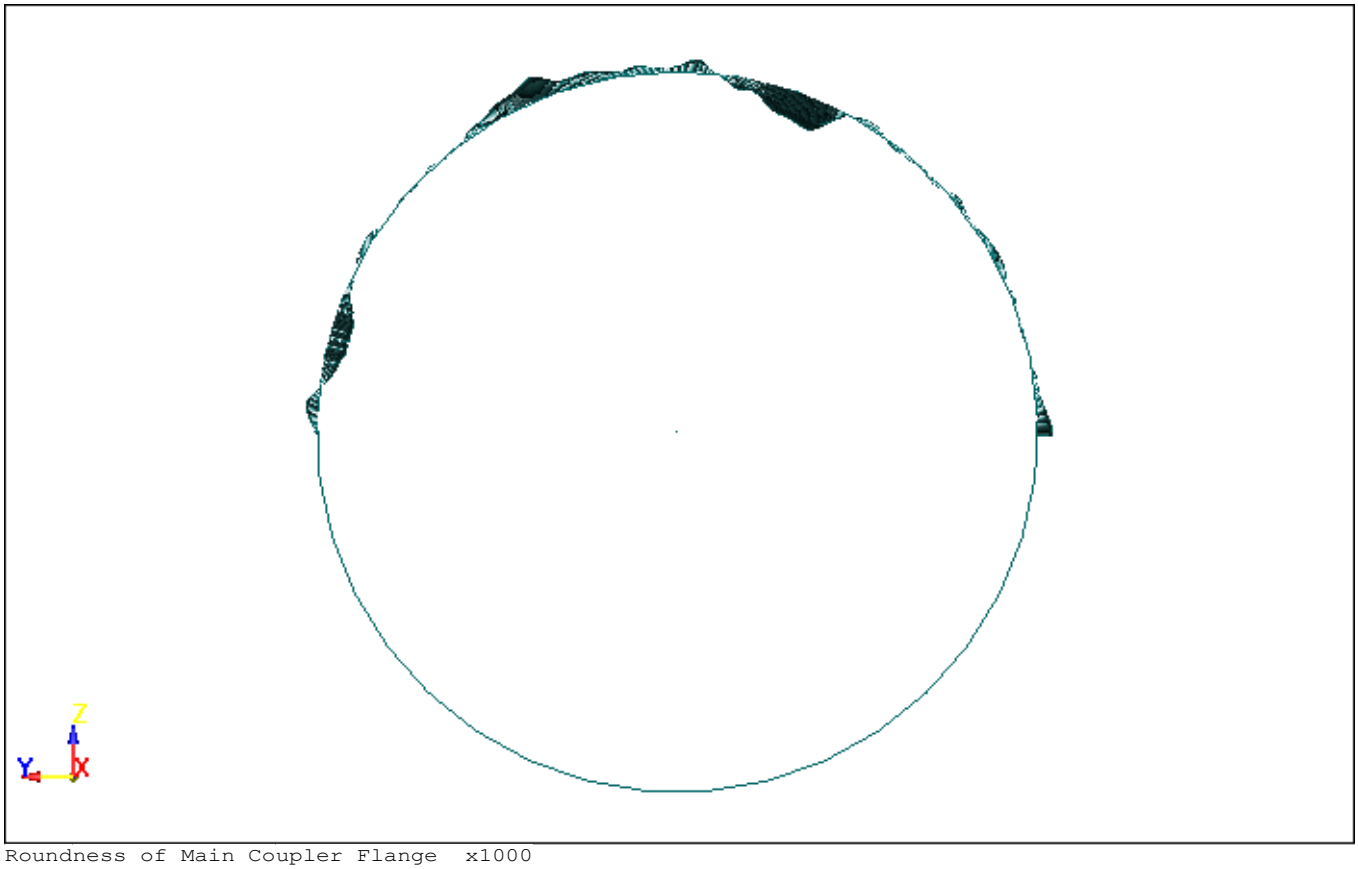
○	MM	CIRTY1 - CIR_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.021	0.021	0.250	0.000	0.000

○	MM	CIRTY2 - CIR_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.027	0.027	0.250	0.000	0.000

○	MM	CIRTY3 - CIR_MC				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.011	0.011	0.250	0.000	0.000



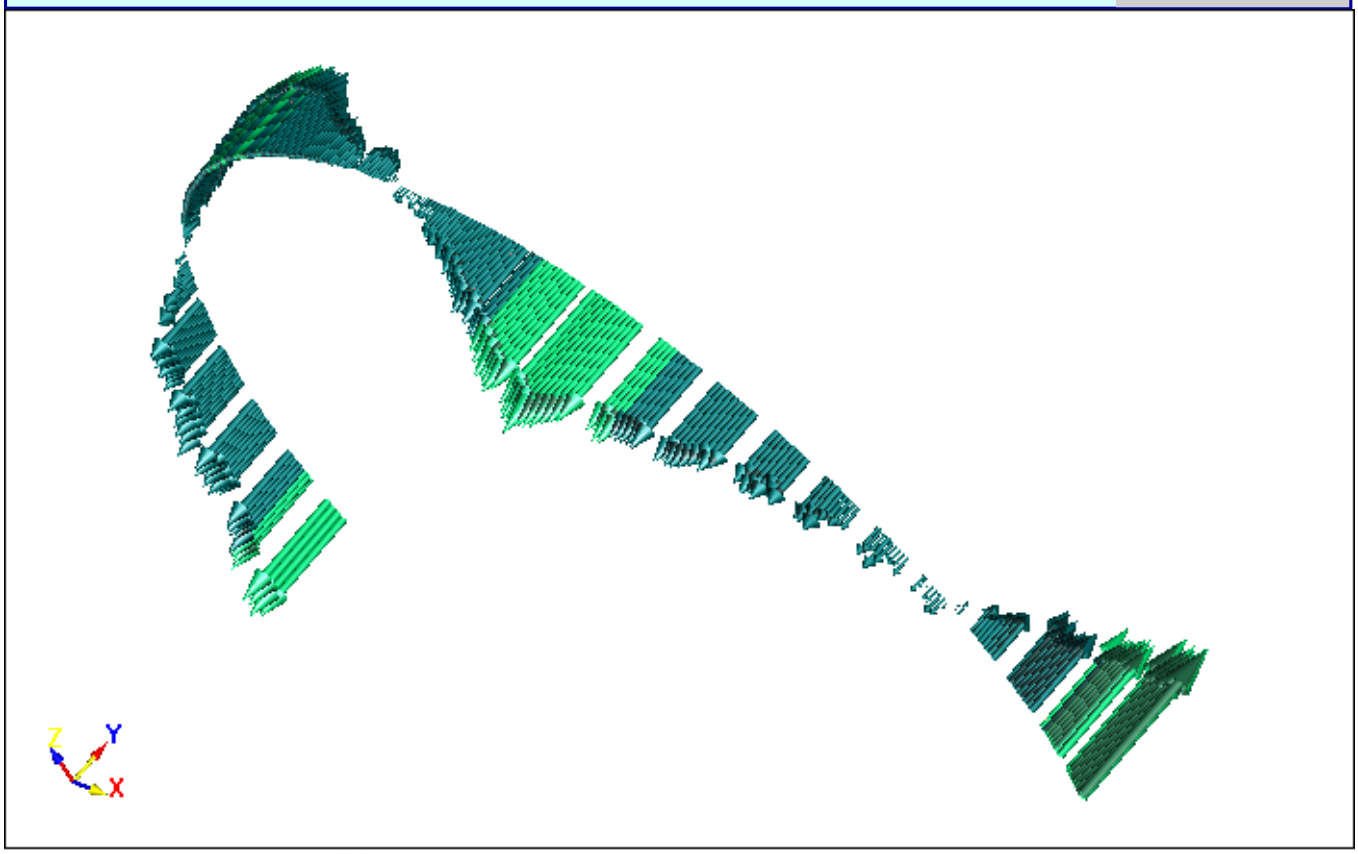
Roundness of Datum Discs x1000



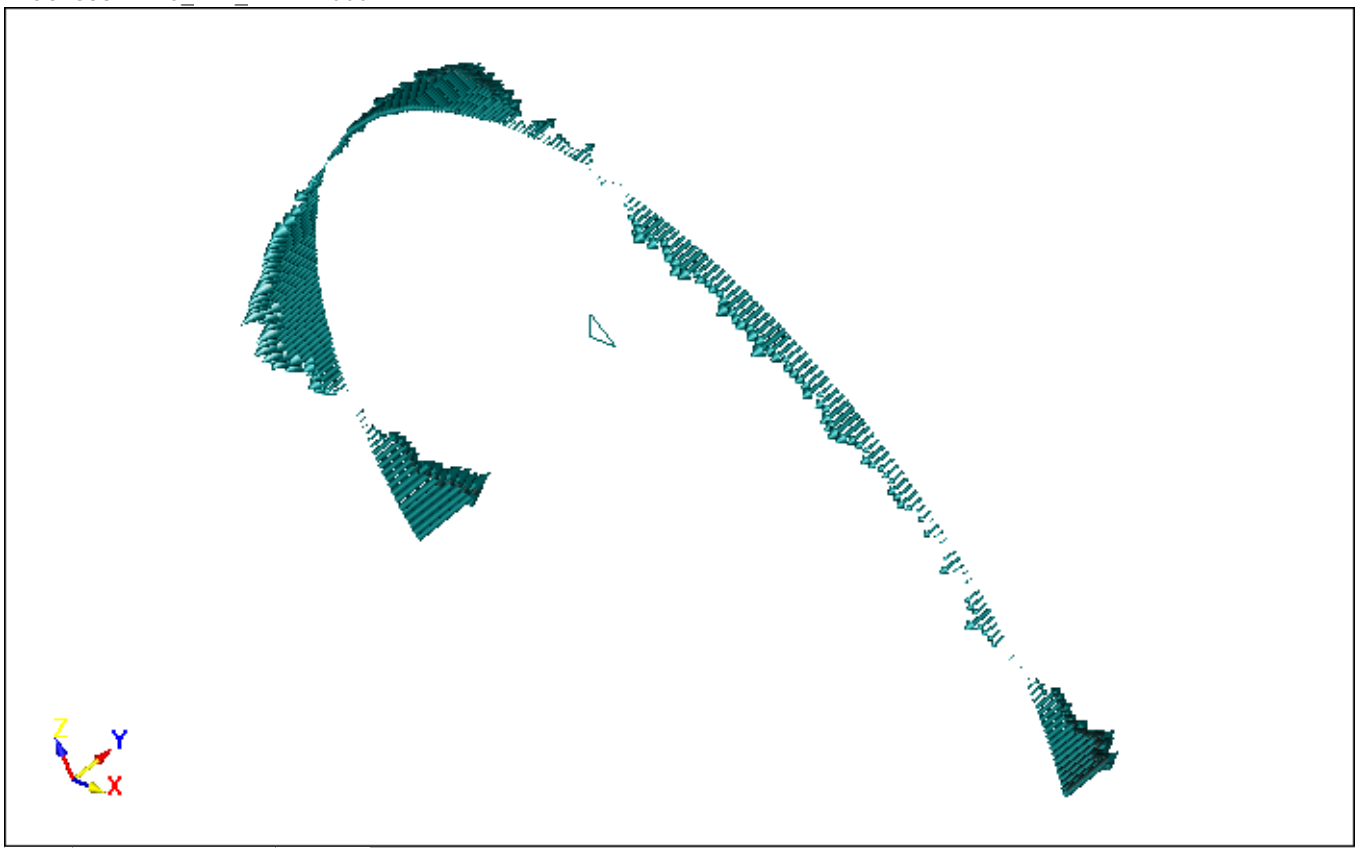
Roundness of Main Coupler Flange x1000

	MM	FLAT3 - PLNC_FPE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.044	0.044	0.250	0.000	0.000

	MM	FLAT4 - PLNC_MCE_DD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.026	0.026	0.250	0.000	0.000



Flatness PLNC_FPE_DD x1000



Flatness PLNC_MCE_DD x1000