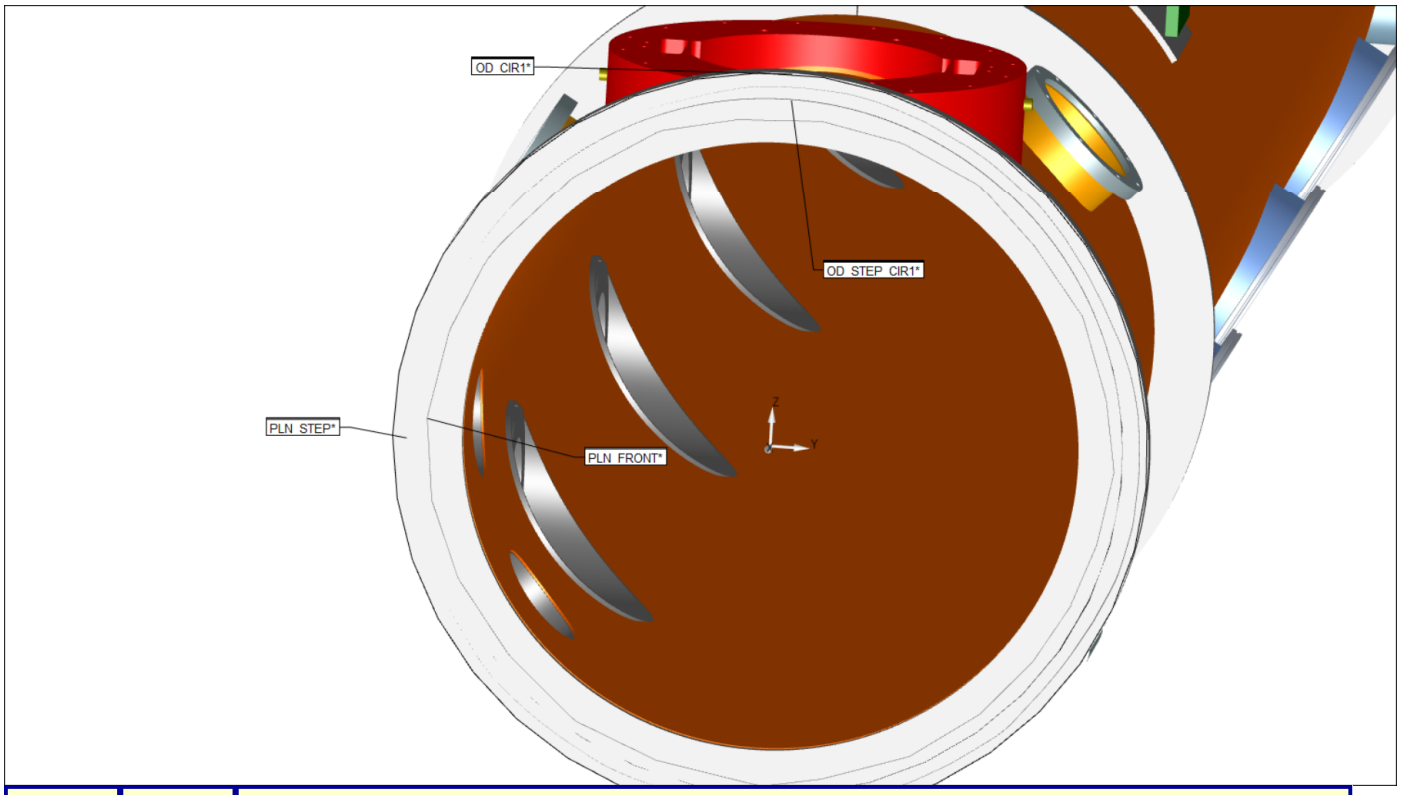
| | | | |
|---|---|---|---|
| Leica Geosystems | PART NAME : F10023636-none ITEM_11 Version 11 | August 25, 2016 | 13:53 |
| | REV NUMBER : 11 | SER NUMBER : | STATS COUNT : 1 |

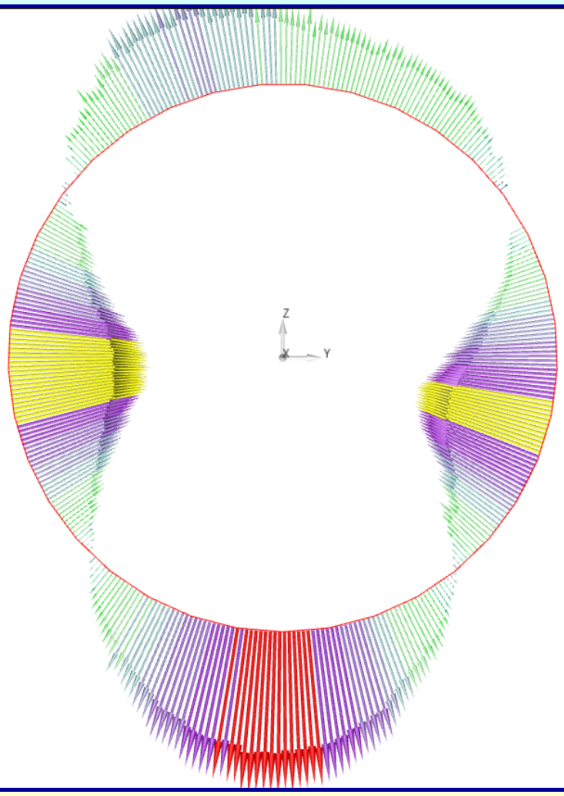
Drawing Number: F10023636-none
Name: FLANGE - FIXED DS
Description: FLANGE-FIXED DOWNSTREAM
Category: FLANGE
Project: LCLSIICryomodule
Item: I-11
Inspected by : R. Riley & O. Lira
Sample Number : RFCG-VV-003
Routing Form : 100165
Date : Aug/09/2016




| # | MM | LOC1 - PLN_FRONT | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | |
| X | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | |
| FL | 0.000 | 0.112 | 0.112 | 0.100 | 0.000 | 0.012 | |

| # | MM | LOC2 - PLN_STEP | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | |
| X | -5.000 | -5.052 | -0.052 | 0.300 | 0.300 | 0.000 | |
| FL | 0.000 | 0.141 | 0.141 | 0.100 | 0.000 | 0.041 | |

| ⊕ | MM | LOC3 - OD_CIR1 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| Y | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| Z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| D | 1160.000 | 1159.620 | -0.380 | 0.300 | 0.300 | 0.080 |
| RN | 0.000 | 0.646 | 0.646 | 0.600 | 0.000 | 0.046 |




| ⊕ | MM | LOC4 - OD_STEP_CIR1 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | -5.000 | -5.052 | -0.052 | 0.300 | 0.300 | 0.000 |
| Y | 0.000 | 1.198 | 1.198 | 0.300 | 0.300 | 0.898 |
| Z | 0.000 | -2.124 | -2.124 | 0.300 | 0.300 | 1.824 |
| D | 1080.000 | 1080.226 | 0.226 | 0.300 | 0.300 | 0.000 |
| RN | 0.000 | 0.496 | 0.496 | 0.600 | 0.000 | 0.000 |

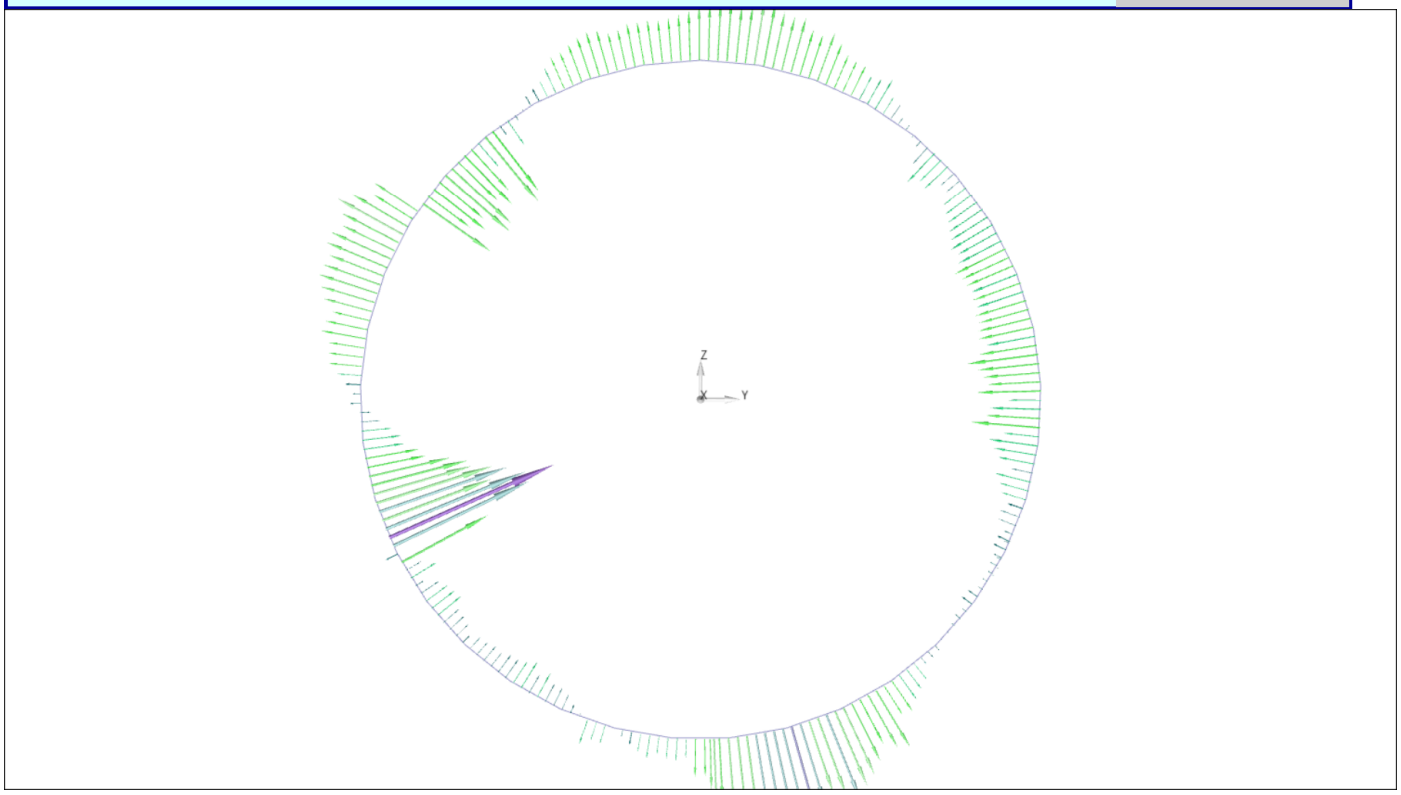
| ⊕ | MM | LOC5 - PLN_BACK | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | -40.000 | -42.812 | -2.812 | 0.300 | 0.300 | 2.512 |
| FL | 0.000 | 0.332 | 0.332 | 0.600 | 0.000 | 0.000 |

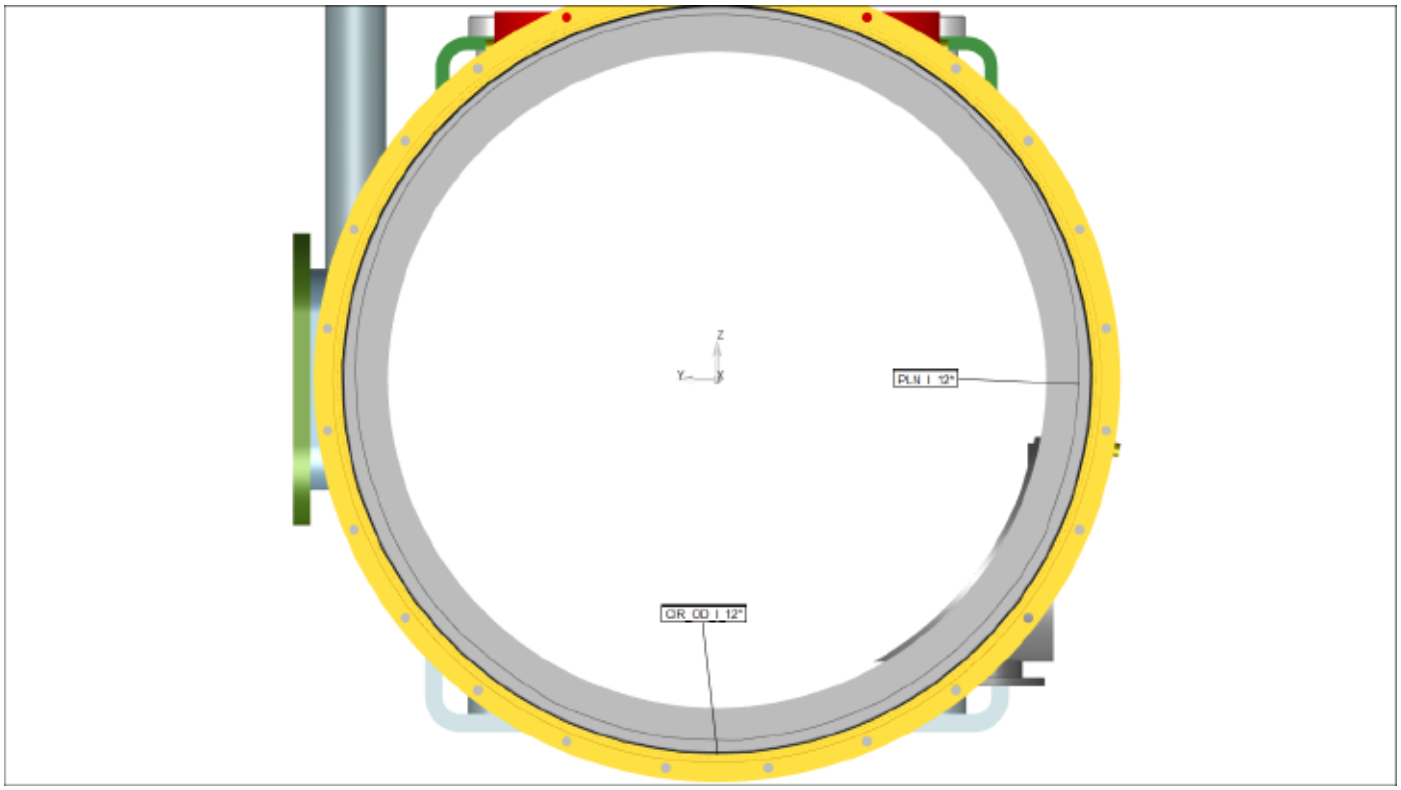
| | | | |
|---|---|---|---|
| Leica Geosystems | PART NAME : F10023641-n_I-12_VV-###_v11 | August 25, 2016 | 14:51 |
| | REV NUMBER : 11 | SER NUMBER : | STATS COUNT : 1 |

Drawing Number: F10023641-none
Name: FLANGE - FIXED US
Description: FLANGE-FIXED UPSTREAM
Category: FLANGE
Project: LCLSIICryomodule
Item: I-12
Inspected by : R. Riley & O. Lira
Sample Number : RFCG-VV-003
Routing Form : 100165
Date : Aug/09/2016

| ⌖ | MM | LOC1 - PLN_I_12 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| FL | 0.000 | 0.201 | 0.201 | 0.100 | 0.000 | 0.101 |

| ⌖ | MM | LOC2 - CIR_OD_I_12 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| Y | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| Z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| D | 1080.000 | 1079.790 | -0.210 | 0.300 | 0.300 | 0.000 |
| RN | 0.000 | 0.450 | 0.450 | 0.600 | 0.000 | 0.000 |




Z
Y
X
PLN I 12"
OR OD I 12"

| Leica Geosystems | PART NAME : F10023643-n_I-13_VV-###_v11 | | August 25, 2016 | 15:25 |
|---|---|---|---|---|
| | REV NUMBER : 11 | SER NUMBER : | STATS COUNT : 1 | |

Drawing Number: F10023643-none
Name: FLANGE - SLIDING
Description: FLANGE-SLIDING
Category: FLANGE
Project: LCLSIICryomodule
Item: I-13
Inspected by : R. Riley & O. Lira
Sample Number : RFCG-VV-003
Routing Form : 100165
Date : Aug/09/2016

Flange Flatness

| # | MM | LOC7 - ITEM_13_PLN | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | 0.019 | 0.019 | 0.050 | 0.050 | 0.000 |

Flange O.D.

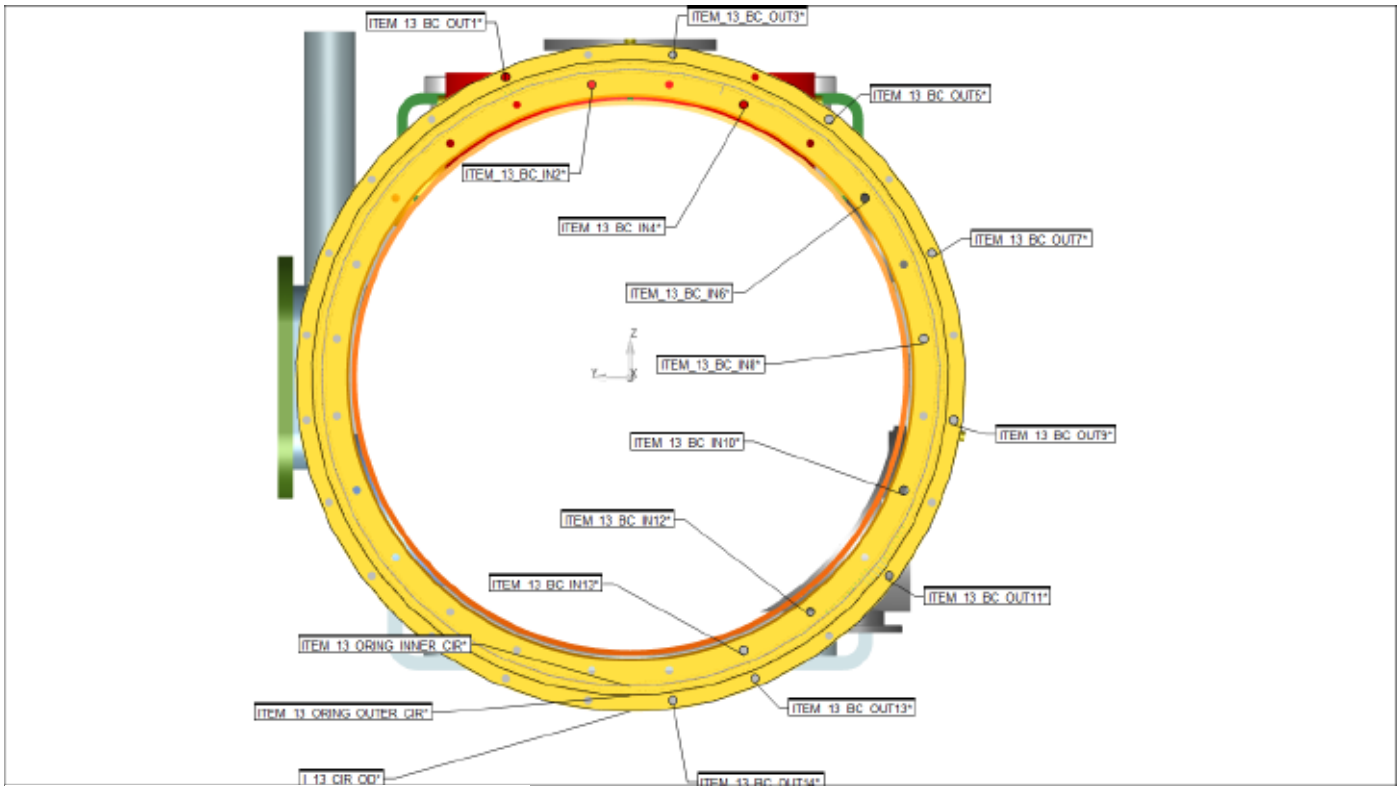
| # | MM | LOC2 - I_13_CIR_OD | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| Y | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| Z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 |
| D | 1160.000 | 1159.820 | -0.180 | 0.300 | 0.300 | 0.000 |
| RN | 0.000 | 0.170 | 0.170 | 0.600 | 0.000 | 0.000 |

O Ring Outer

| # | MM | LOC3 - ITEM_13_ORING_OUTER_CIR | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | 0.000 | 0.000 | 0.300 | 0.300 | 0.000 |
| Y | 0.000 | -0.008 | -0.008 | 0.300 | 0.300 | 0.000 |
| Z | 0.000 | 0.010 | 0.010 | 0.300 | 0.300 | 0.000 |
| D | 1104.000 | 1103.970 | -0.030 | 0.300 | 0.300 | 0.000 |
| RN | 0.000 | 0.244 | 0.244 | 0.600 | 0.000 | 0.000 |

O Ring Inner

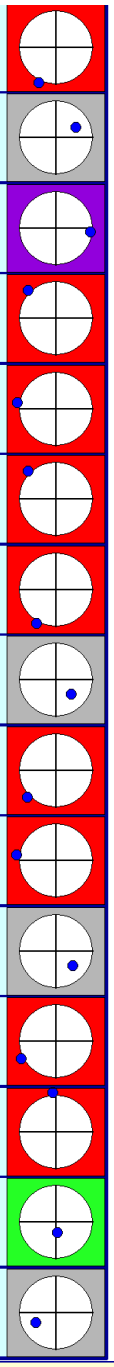
| # | MM | LOC4 - ITEM_13_ORING_INNER_CIR | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | 0.000 | 0.000 | 0.300 | 0.300 | 0.000 |
| Y | 0.000 | -0.112 | -0.112 | 0.300 | 0.300 | 0.000 |
| Z | 0.000 | 0.109 | 0.109 | 0.300 | 0.300 | 0.000 |
| D | 1071.000 | 1070.945 | -0.055 | 0.300 | 0.300 | 0.000 |
| RN | 0.000 | 0.400 | 0.400 | 0.600 | 0.000 | 0.000 |




Outer & Inner Bolt Hole Pattern

| FCFLOC1 Position | | MM | | | | ⌖ Ø.25 Ⓢ A | | |
|---|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | BONUS | |
| ITEM_13_BC_OUT1 | 0.000 | 0.415 | 0.415 | 0.250 | | 0.165 | 0.000 | |
| ITEM_13_BC_OUT2 | 0.000 | 0.318 | 0.318 | 0.250 | | 0.068 | 0.000 | |
| ITEM_13_BC_OUT3 | 0.000 | 0.386 | 0.386 | 0.250 | | 0.136 | 0.000 | |
| ITEM_13_BC_OUT4 | 0.000 | 0.432 | 0.432 | 0.250 | | 0.182 | 0.000 | |
| ITEM_13_BC_OUT5 | 0.000 | 0.669 | 0.669 | 0.250 | | 0.419 | 0.000 | |
| ITEM_13_BC_OUT6 | 0.000 | 0.296 | 0.296 | 0.250 | | 0.046 | 0.000 | |
| ITEM_13_BC_OUT7 | 0.000 | 0.353 | 0.353 | 0.250 | | 0.103 | 0.000 | |
| ITEM_13_BC_OUT8 | 0.000 | 0.287 | 0.287 | 0.250 | | 0.037 | 0.000 | |
| ITEM_13_BC_OUT9 | 0.000 | 0.566 | 0.566 | 0.250 | | 0.316 | 0.000 | |
| ITEM_13_BC_OUT10 | 0.000 | 0.162 | 0.162 | 0.250 | | 0.000 | 0.000 | |
| ITEM_13_BC_OUT11 | 0.000 | 0.257 | 0.257 | 0.250 | | 0.007 | 0.000 | |

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| ITEM_13_BC_OUT12 | 0.000 | 0.290 | 0.290 | 0.250 | | 0.040 | 0.000 |
| ITEM_13_BC_OUT13 | 0.000 | 0.149 | 0.149 | 0.250 | | 0.000 | 0.000 |
| ITEM_13_BC_OUT14 | 0.000 | 0.233 | 0.233 | 0.250 | | 0.000 | 0.000 |
| ITEM_13_BC_IN2 | 0.000 | 0.417 | 0.417 | 0.250 | | 0.167 | 0.000 |
| ITEM_13_BC_IN3 | 0.000 | 0.495 | 0.495 | 0.250 | | 0.245 | 0.000 |
| ITEM_13_BC_IN4 | 0.000 | 0.380 | 0.380 | 0.250 | | 0.130 | 0.000 |
| ITEM_13_BC_IN5 | 0.000 | 0.493 | 0.493 | 0.250 | | 0.243 | 0.000 |
| ITEM_13_BC_IN6 | 0.000 | 0.147 | 0.147 | 0.250 | | 0.000 | 0.000 |
| ITEM_13_BC_IN7 | 0.000 | 0.608 | 0.608 | 0.250 | | 0.358 | 0.000 |
| ITEM_13_BC_IN8 | 0.000 | 0.773 | 0.773 | 0.250 | | 0.523 | 0.000 |
| ITEM_13_BC_IN9 | 0.000 | 0.153 | 0.153 | 0.250 | | 0.000 | 0.000 |
| ITEM_13_BC_IN10 | 0.000 | 0.405 | 0.405 | 0.250 | | 0.155 | 0.000 |
| ITEM_13_BC_IN11 | 0.000 | 0.315 | 0.315 | 0.250 | | 0.065 | 0.000 |
| ITEM_13_BC_IN12 | 0.000 | 0.071 | 0.071 | 0.250 | | 0.000 | 0.000 |
| ITEM_13_BC_IN13 | 0.000 | 0.152 | 0.152 | 0.250 | | 0.000 | 0.000 |



FCFLOC1 Datum Shift

| Segment | Shift X | Shift Y | Shift Z | Rotation X | Rotation Y | Rotation Z |
|---|---|---|---|---|---|---|
| Segment 1 | Fixed | Fixed | Fixed | 0.010 | Fixed | Fixed |

FCFLOC1 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON

| Feature | AX | NOMINAL | MEAS | DEV |
|---|---|---|---|---|
| ITEM_13_BC_OUT1 | Y | 216.216 | 216.017 | -0.200 |
| | Z | 521.992 | 522.048 | 0.056 |
| | PR | 565.000 | 564.976 | -0.024 |
| | PA | 112.500 | 112.479 | -0.021 |
| ITEM_13_BC_OUT2 | Y | 73.747 | 73.590 | -0.157 |
| | Z | 560.166 | 560.191 | 0.024 |
| | PR | 565.000 | 565.004 | 0.004 |

| | | | | |
|---|---|---|---|---|
| | PA | 97.500 | 97.484 | -0.016 |
| ITEM_13_BC_OUT3 | Y | -73.747 | -73.939 | -0.192 |
| | Z | 560.166 | 560.186 | 0.019 |
| | PR | 565.000 | 565.044 | 0.044 |
| | PA | 82.500 | 82.481 | -0.019 |
| ITEM_13_BC_OUT4 | Y | -216.216 | -216.423 | -0.207 |
| | Z | 521.992 | 521.929 | -0.063 |
| | PR | 565.000 | 565.021 | 0.021 |
| | PA | 67.500 | 67.478 | -0.022 |
| ITEM_13_BC_OUT5 | Y | -343.950 | -344.249 | -0.299 |
| | Z | 448.245 | 448.095 | -0.150 |
| | PR | 565.000 | 565.063 | 0.063 |
| | PA | 52.500 | 52.467 | -0.033 |
| ITEM_13_BC_OUT6 | Y | -448.245 | -448.365 | -0.120 |
| | Z | 343.950 | 343.863 | -0.087 |
| | PR | 565.000 | 565.043 | 0.043 |
| | PA | 37.500 | 37.486 | -0.014 |
| ITEM_13_BC_OUT7 | Y | -521.992 | -522.124 | -0.132 |
| | Z | 216.216 | 216.099 | -0.117 |
| | PR | 565.000 | 565.077 | 0.077 |
| | PA | 22.500 | 22.484 | -0.016 |
| ITEM_13_BC_OUT8 | Y | -560.166 | -560.201 | -0.035 |
| | Z | 73.747 | 73.608 | -0.139 |
| | PR | 565.000 | 565.016 | 0.016 |
| | PA | 7.500 | 7.486 | -0.014 |
| ITEM_13_BC_OUT9 | Y | -560.166 | -560.183 | -0.017 |
| | Z | -73.747 | -74.030 | -0.283 |
| | PR | 565.000 | 565.053 | 0.053 |
| | PA | -7.500 | -7.528 | -0.028 |
| ITEM_13_BC_OUT10 | Y | -521.992 | -522.073 | -0.081 |
| | Z | -216.216 | -216.223 | -0.007 |
| | PR | 565.000 | 565.077 | 0.077 |
| | PA | -22.500 | -22.498 | 0.002 |
| ITEM_13_BC_OUT11 | Y | -448.245 | -448.136 | 0.109 |
| | Z | -343.950 | -343.881 | 0.069 |
| | PR | 565.000 | 564.872 | -0.128 |
| | PA | -37.500 | -37.501 | -0.001 |
| ITEM_13_BC_OUT12 | Y | -343.950 | -344.014 | -0.064 |
| | Z | -448.245 | -448.375 | -0.131 |
| | PR | 565.000 | 565.142 | 0.142 |
| | PA | -52.500 | -52.503 | -0.003 |
| ITEM_13_BC_OUT13 | Y | -216.216 | -216.150 | 0.066 |
| | Z | -521.992 | -521.958 | 0.034 |

| | | | | |
|---|---|---|---|---|
| | PR | 565.000 | 564.943 | -0.057 |
| | PA | -67.500 | -67.505 | -0.005 |
| ITEM_13_BC_OUT14 | Y | -73.747 | -73.631 | 0.116 |
| | Z | -560.166 | -560.179 | -0.012 |
| | PR | 565.000 | 564.997 | -0.003 |
| | PA | -82.500 | -82.512 | -0.012 |
| ITEM_13_BC_IN2 | Y | 66.895 | 66.748 | -0.146 |
| | Z | 508.115 | 508.264 | 0.149 |
| | PR | 512.500 | 512.628 | 0.128 |
| | PA | 97.500 | 97.482 | -0.018 |
| ITEM_13_BC_IN3 | Y | -66.895 | -67.139 | -0.244 |
| | Z | 508.115 | 508.154 | 0.038 |
| | PR | 512.500 | 512.570 | 0.070 |
| | PA | 82.500 | 82.473 | -0.027 |
| ITEM_13_BC_IN4 | Y | -196.125 | -196.260 | -0.134 |
| | Z | 473.488 | 473.623 | 0.135 |
| | PR | 512.500 | 512.676 | 0.176 |
| | PA | 67.500 | 67.492 | -0.008 |
| ITEM_13_BC_IN5 | Y | -311.990 | -312.112 | -0.122 |
| | Z | 406.594 | 406.379 | -0.214 |
| | PR | 512.500 | 512.404 | -0.096 |
| | PA | 52.500 | 52.475 | -0.025 |
| ITEM_13_BC_IN6 | Y | -406.594 | -406.540 | 0.053 |
| | Z | 311.990 | 311.940 | -0.050 |
| | PR | 512.500 | 512.427 | -0.073 |
| | PA | 37.500 | 37.499 | -0.001 |
| ITEM_13_BC_IN7 | Y | -473.488 | -473.711 | -0.222 |
| | Z | 196.125 | 195.918 | -0.207 |
| | PR | 512.500 | 512.626 | 0.126 |
| | PA | 22.500 | 22.469 | -0.031 |
| ITEM_13_BC_IN8 | Y | -508.115 | -508.498 | -0.383 |
| | Z | 66.895 | 66.945 | 0.050 |
| | PR | 512.500 | 512.886 | 0.386 |
| | PA | 7.500 | 7.500 | 0.000 |
| ITEM_13_BC_IN9 | Y | -508.115 | -508.057 | 0.058 |
| | Z | -66.895 | -66.944 | -0.049 |
| | PR | 512.500 | 512.449 | -0.051 |
| | PA | -7.500 | -7.506 | -0.006 |
| ITEM_13_BC_IN10 | Y | -473.488 | -473.668 | -0.180 |
| | Z | -196.125 | -196.218 | -0.093 |
| | PR | 512.500 | 512.702 | 0.202 |
| | PA | -22.500 | -22.502 | -0.002 |
| ITEM_13_BC_IN11 | Y | -406.594 | -406.605 | -0.011 |

| | | | | |
|---|---|---|---|---|
| | Z | -311.990 | -311.833 | 0.157 |
| | PR | 512.500 | 512.413 | -0.087 |
| | PA | -37.500 | -37.485 | 0.015 |
| ITEM_13_BC_IN12 | Y | -311.990 | -311.985 | 0.005 |
| | Z | -406.594 | -406.628 | -0.035 |
| | PR | 512.500 | 512.525 | 0.025 |
| | PA | -52.500 | -52.503 | -0.003 |
| ITEM_13_BC_IN13 | Y | -196.125 | -196.193 | -0.068 |
| | Z | -473.488 | -473.523 | -0.035 |
| | PR | 512.500 | 512.558 | 0.058 |
| | PA | -67.500 | -67.495 | 0.005 |

Constructed Outer and Inner Bolt Circles from holes

| ⌖ | MM | LOC5 - CIRC_OUTER_BP | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | |
| Y | 0.000 | -0.053 | -0.053 | 0.125 | 0.125 | 0.000 | |
| Z | 0.000 | 0.022 | 0.022 | 0.125 | 0.125 | 0.000 | |
| D | 1130.000 | 1129.986 | -0.014 | 0.125 | 0.125 | 0.000 | |
| RN | 0.000 | 0.284 | 0.284 | 0.250 | 0.000 | 0.034 | |

| ⌖ | MM | LOC6 - CIRC_INNER_BP | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | |
| Y | 0.000 | -0.031 | -0.031 | 0.125 | 0.125 | 0.000 | |
| Z | 0.000 | 0.025 | 0.025 | 0.125 | 0.125 | 0.000 | |
| D | 1025.000 | 1025.098 | 0.098 | 0.125 | 0.125 | 0.000 | |
| RN | 0.000 | 0.487 | 0.487 | 0.250 | 0.000 | 0.237 | |

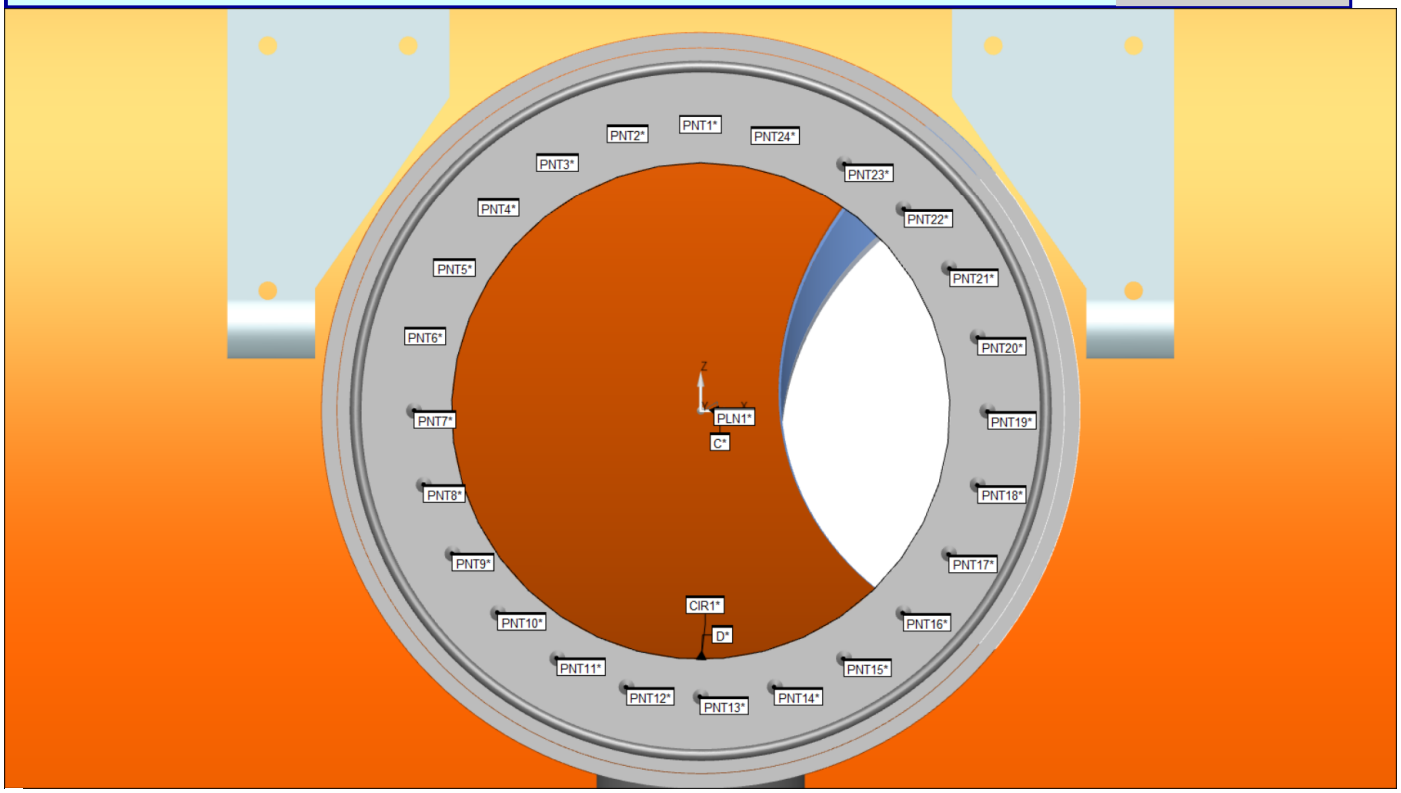
| | | | |
|---|---|---|---|
| Leica Geosystems | PART NAME : F10026609-D_I-14_MC-PORT-BHP_VV-###_V11.PRG | August 25, 2016 | 11:57 |
| | REV NUMBER : 11 | SER NUMBER : | STATS COUNT : 1 |

COUPLER PORT # 4 BOLT HOLE PATTERN

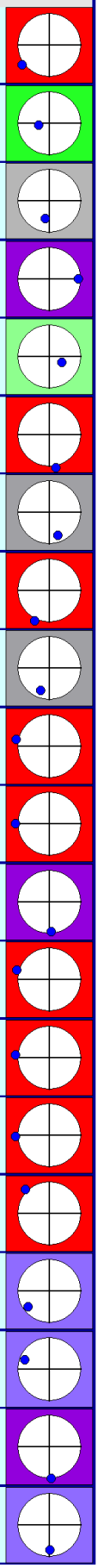
Drawing Number: F10026609-C
Name: WELDMENT,VESSEL LCLS-II, AFTER MACHINING
Description: WELDMENT,VESSEL LCLS-II, AFTER MACHINING
Category: WELDMENT
Project: LCLSIICryomodule
Item: I-14
Inspected by : R. Riley & O. Lira
Sample Number : RFCG-VV-003
Routing Form : 100165
Date : Aug/09/2016

| # | MM | LOC1 - PLN1 | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | |
| Y | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | |
| FL | 0.000 | 0.042 | 0.042 | 0.100 | 0.000 | 0.000 | |

| # | MM | LOC2 - CIR1 | | | | | |
|---|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | |
| X | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | |
| Z | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | 0.000 | |
| RN | 0.000 | 0.044 | 0.044 | 1.000 | 0.000 | 0.000 | |



| FCFLOC1 Position | MM | ⌖ Ø.25 C D | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL | BONUS |
| PNT1 | 0.000 | 0.279 | 0.279 | 0.250 | | 0.029 | 0.000 |
| PNT2 | 0.000 | 0.082 | 0.082 | 0.250 | | 0.000 | 0.000 |
| PNT3 | 0.000 | 0.147 | 0.147 | 0.250 | | 0.000 | 0.000 |
| PNT4 | 0.000 | 0.228 | 0.228 | 0.250 | | 0.000 | 0.000 |
| PNT5 | 0.000 | 0.112 | 0.112 | 0.250 | | 0.000 | 0.000 |
| PNT6 | 0.000 | 0.355 | 0.355 | 0.250 | | 0.105 | 0.000 |
| PNT7 | 0.000 | 0.193 | 0.193 | 0.250 | | 0.000 | 0.000 |
| PNT8 | 0.000 | 0.287 | 0.287 | 0.250 | | 0.037 | 0.000 |
| PNT9 | 0.000 | 0.192 | 0.192 | 0.250 | | 0.000 | 0.000 |
| PNT10 | 0.000 | 0.288 | 0.288 | 0.250 | | 0.038 | 0.000 |
| PNT11 | 0.000 | 0.331 | 0.331 | 0.250 | | 0.081 | 0.000 |
| PNT12 | 0.000 | 0.233 | 0.233 | 0.250 | | 0.000 | 0.000 |
| PNT13 | 0.000 | 0.328 | 0.328 | 0.250 | | 0.078 | 0.000 |
| PNT14 | 0.000 | 0.282 | 0.282 | 0.250 | | 0.032 | 0.000 |
| PNT15 | 0.000 | 0.303 | 0.303 | 0.250 | | 0.053 | 0.000 |
| PNT16 | 0.000 | 0.371 | 0.371 | 0.250 | | 0.121 | 0.000 |
| PNT17 | 0.000 | 0.208 | 0.208 | 0.250 | | 0.000 | 0.000 |
| PNT18 | 0.000 | 0.203 | 0.203 | 0.250 | | 0.000 | 0.000 |
| PNT19 | 0.000 | 0.248 | 0.248 | 0.250 | | 0.000 | 0.000 |
| PNT20 | 0.000 | 0.196 | 0.196 | 0.250 | | 0.000 | 0.000 |



| | | | | | | | |
|---|---|---|---|---|---|---|---|
| PNT21 | 0.000 | 0.242 | 0.242 | 0.250 | | 0.000 | 0.000 |
| PNT22 | 0.000 | 0.060 | 0.060 | 0.250 | | 0.000 | 0.000 |
| PNT23 | 0.000 | 0.216 | 0.216 | 0.250 | | 0.000 | 0.000 |
| PNT24 | 0.000 | 0.229 | 0.229 | 0.250 | | 0.000 | 0.000 |

FCFLOC1 Datum Shift

| Segment | Shift X | Shift Y | Shift Z | Rotation X | Rotation Y | Rotation Z |
|---|---|---|---|---|---|---|
| Segment 1 | Fixed | Fixed | Fixed | Fixed | 359.895 | Fixed |

FCFLOC1 Summary FIT TO DATUMS=ON

| Feature | AX | NOMINAL | MEAS | DEV |
|---|---|---|---|---|
| Set | X | 0.000 | -0.044 | -0.044 |
| | Z | 0.000 | -0.041 | -0.041 |
| PNT1 | X | 0.000 | -0.112 | -0.112 |
| | Z | 122.500 | 122.417 | -0.083 |
| | PR | 122.500 | 122.417 | -0.083 |
| | PA | 90.000 | 90.052 | 0.052 |
| PNT2 | X | -31.705 | -31.746 | -0.040 |
| | Z | 118.326 | 118.319 | -0.007 |
| | PR | 122.500 | 122.504 | 0.004 |
| | PA | 105.000 | 105.019 | 0.019 |
| PNT3 | X | -61.250 | -61.266 | -0.016 |
| | Z | 106.088 | 106.016 | -0.072 |
| | PR | 122.500 | 122.446 | -0.054 |
| | PA | 120.000 | 120.023 | 0.023 |
| PNT4 | X | -86.621 | -86.507 | 0.114 |
| | Z | 86.621 | 86.620 | -0.001 |
| | PR | 122.500 | 122.419 | -0.081 |
| | PA | 135.000 | 134.963 | -0.037 |
| PNT5 | X | -106.088 | -106.037 | 0.051 |
| | Z | 61.250 | 61.227 | -0.023 |
| | PR | 122.500 | 122.444 | -0.056 |
| | PA | 150.000 | 149.998 | -0.002 |
| PNT6 | X | -118.326 | -118.290 | 0.035 |
| | Z | 31.705 | 31.531 | -0.174 |
| | PR | 122.500 | 122.421 | -0.079 |
| | PA | 165.000 | 165.074 | 0.074 |
| PNT7 | X | -122.500 | -122.466 | 0.034 |
| | Z | 0.000 | -0.091 | -0.091 |
| | PR | 122.500 | 122.466 | -0.034 |

| | | | | |
|---|---|---|---|---|
| | PA | 180.000 | 180.042 | 0.042 |
| PNT8 | X | -118.326 | -118.388 | -0.062 |
| | Z | -31.705 | -31.835 | -0.129 |
| | PR | 122.500 | 122.594 | 0.094 |
| | PA | 195.000 | 195.051 | 0.051 |
| PNT9 | X | -106.088 | -106.123 | -0.035 |
| | Z | -61.250 | -61.340 | -0.090 |
| | PR | 122.500 | 122.575 | 0.075 |
| | PA | 210.000 | 210.028 | 0.028 |
| PNT10 | X | -86.621 | -86.762 | -0.141 |
| | Z | -86.621 | -86.592 | 0.029 |
| | PR | 122.500 | 122.579 | 0.079 |
| | PA | 225.000 | 224.944 | -0.056 |
| PNT11 | X | -61.250 | -61.416 | -0.166 |
| | Z | -106.088 | -106.089 | -0.001 |
| | PR | 122.500 | 122.583 | 0.083 |
| | PA | 240.000 | 239.933 | -0.067 |
| PNT12 | X | -31.705 | -31.698 | 0.008 |
| | Z | -118.326 | -118.442 | -0.116 |
| | PR | 122.500 | 122.610 | 0.110 |
| | PA | 255.000 | 255.017 | 0.017 |
| PNT13 | X | 0.000 | -0.157 | -0.157 |
| | Z | -122.500 | -122.455 | 0.045 |
| | PR | 122.500 | 122.455 | -0.045 |
| | PA | 270.000 | 269.926 | -0.074 |
| PNT14 | X | 31.705 | 31.565 | -0.140 |
| | Z | -118.326 | -118.314 | 0.012 |
| | PR | 122.500 | 122.452 | -0.048 |
| | PA | 285.000 | 284.938 | -0.062 |
| PNT15 | X | 61.250 | 61.099 | -0.151 |
| | Z | -106.088 | -106.094 | -0.006 |
| | PR | 122.500 | 122.430 | -0.070 |
| | PA | 300.000 | 299.937 | -0.063 |
| PNT16 | X | 86.621 | 86.489 | -0.131 |
| | Z | -86.621 | -86.489 | 0.131 |
| | PR | 122.500 | 122.315 | -0.185 |
| | PA | 315.000 | 315.000 | 0.000 |
| PNT17 | X | 106.088 | 106.005 | -0.083 |
| | Z | -61.250 | -61.312 | -0.062 |
| | PR | 122.500 | 122.459 | -0.041 |
| | PA | 330.000 | 329.955 | -0.045 |
| PNT18 | X | 118.326 | 118.231 | -0.095 |
| | Z | -31.705 | -31.670 | 0.035 |

| | | | | |
|---|---|---|---|---|
| | PR | 122.500 | 122.399 | -0.101 |
| | PA | 345.000 | 345.004 | 0.004 |
| PNT19 | X | 122.500 | 122.507 | 0.007 |
| | Z | 0.000 | -0.124 | -0.124 |
| | PR | 122.500 | 122.507 | 0.007 |
| | PA | 360.000 | 359.942 | -0.058 |
| PNT20 | X | 118.326 | 118.328 | 0.002 |
| | Z | 31.705 | 31.607 | -0.098 |
| | PR | 122.500 | 122.477 | -0.023 |
| | PA | 15.000 | 14.955 | -0.045 |
| PNT21 | X | 106.088 | 106.129 | 0.041 |
| | Z | 61.250 | 61.136 | -0.114 |
| | PR | 122.500 | 122.479 | -0.021 |
| | PA | 30.000 | 29.944 | -0.056 |
| PNT22 | X | 86.621 | 86.597 | -0.024 |
| | Z | 86.621 | 86.602 | -0.019 |
| | PR | 122.500 | 122.470 | -0.030 |
| | PA | 45.000 | 45.002 | 0.002 |
| PNT23 | X | 61.250 | 61.142 | -0.108 |
| | Z | 106.088 | 106.097 | 0.009 |
| | PR | 122.500 | 122.454 | -0.046 |
| | PA | 60.000 | 60.046 | 0.046 |
| PNT24 | X | 31.705 | 31.817 | 0.111 |
| | Z | 118.326 | 118.299 | -0.027 |
| | PR | 122.500 | 122.503 | 0.003 |
| | PA | 75.000 | 74.946 | -0.054 |

| 中 | MM | LOC3 - CIRC_BHP | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | +TOL | -TOL | OUTTOL |
| X | 0.000 | -0.036 | -0.036 | 0.125 | 0.125 | 0.000 |
| Z | 0.000 | -0.023 | -0.023 | 0.125 | 0.125 | 0.000 |
| D | 245.000 | 244.955 | -0.045 | 0.125 | 0.125 | 0.000 |
| RN | 0.000 | 0.255 | 0.255 | 0.250 | 0.000 | 0.005 |