pc-dmis	PART NAME : PN484128-n-V1-IR		September 21, 2012	15:38
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

484128-n
LHC - LHQ MAGNET
INSIDE LAYER ASM PLASMA COAT
L1 LE SADDLE PLASMA COAT

'Inspected by ' : Robert Riley
'Sample Number' : RF94894-Mz04
' ' : 1209201511

⌖	MM	LOC1 - CYL_DATUM_A					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
X	0.000	0.000	0.000	0.000	0.000	0.000	
Y	0.000	-189.279	-189.279	500.000	500.000	0.000	
Z	0.000	0.000	0.000	0.000	0.000	0.000	
R	60.000	59.964	-0.036	0.005	0.005	-0.031	
RN	0.000	0.003	0.003	0.050	0.000	0.000	

⌖	MM	LOC2 - CIR_DAT_B					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
X	0.000	0.000	0.000	0.000	0.000	0.000	
Y	86.750	-102.600	-189.350	500.000	500.000	0.000	
Z	83.000	83.002	0.002	1.000	1.000	0.000	
RN	0.000	0.004	0.004	0.050	0.000	0.000	

▱	MM	FLAT4 - PLN_BACK					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0.000	0.008	0.008	0.010	0.000	0.000	

▱	MM	FLAT1 - PLNC_SIDE_N					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0.000	0.031	0.031	0.100	0.000	0.000	

▱	MM	FLAT2 - PLNC_SIDE_P					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0.000	0.012	0.012	0.100	0.000	0.000	

//	MM	PARL1 - PLN_BACK TO YPLUS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	0	0.018	0.018	0.010	0	0.008	

↔	MM	DIST1 - CIR_DAT_B TO PLN_BACK (YAXIS)					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
M	25.400	25.369	-0.031	0.010	0.010	-0.021	

⌖	MM	LOC3 - PNT_ARBOR_F_1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
Z	60.254	60.220	-0.034	0.000	0.050	0.000	

⌖	MM	LOC4 - PNT_ARBOR_F_2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
Z	60.254	60.221	-0.033	0.000	0.050	0.000	

⌖	MM	LOC6 - PNT_ARBOR_B_1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
Z	60.254	60.219	-0.035	0.000	0.050	0.000	

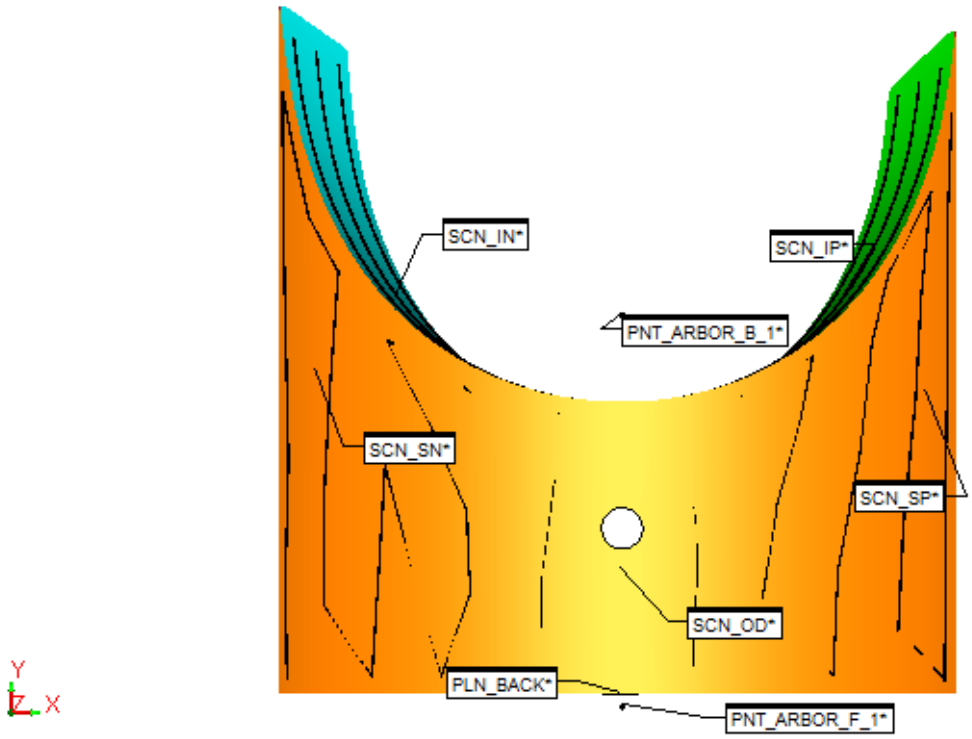
	MM	LOC7 - PNT_ARBOR_B_2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	60.254	60.216	-0.038	0.000	0.050	0.000

	MM	LOC5 - CIR_PH_P					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS
X	25.400	25.418	0.018				
Z	62.727	62.661	-0.066				
DF	6.401	6.403	0.002	0.130	0.130	0.000	0.000
RN	0.000	0.009	0.009	0.130	0.000	0.000	
TP	RFS		0.137	0.250		0.000	0.000

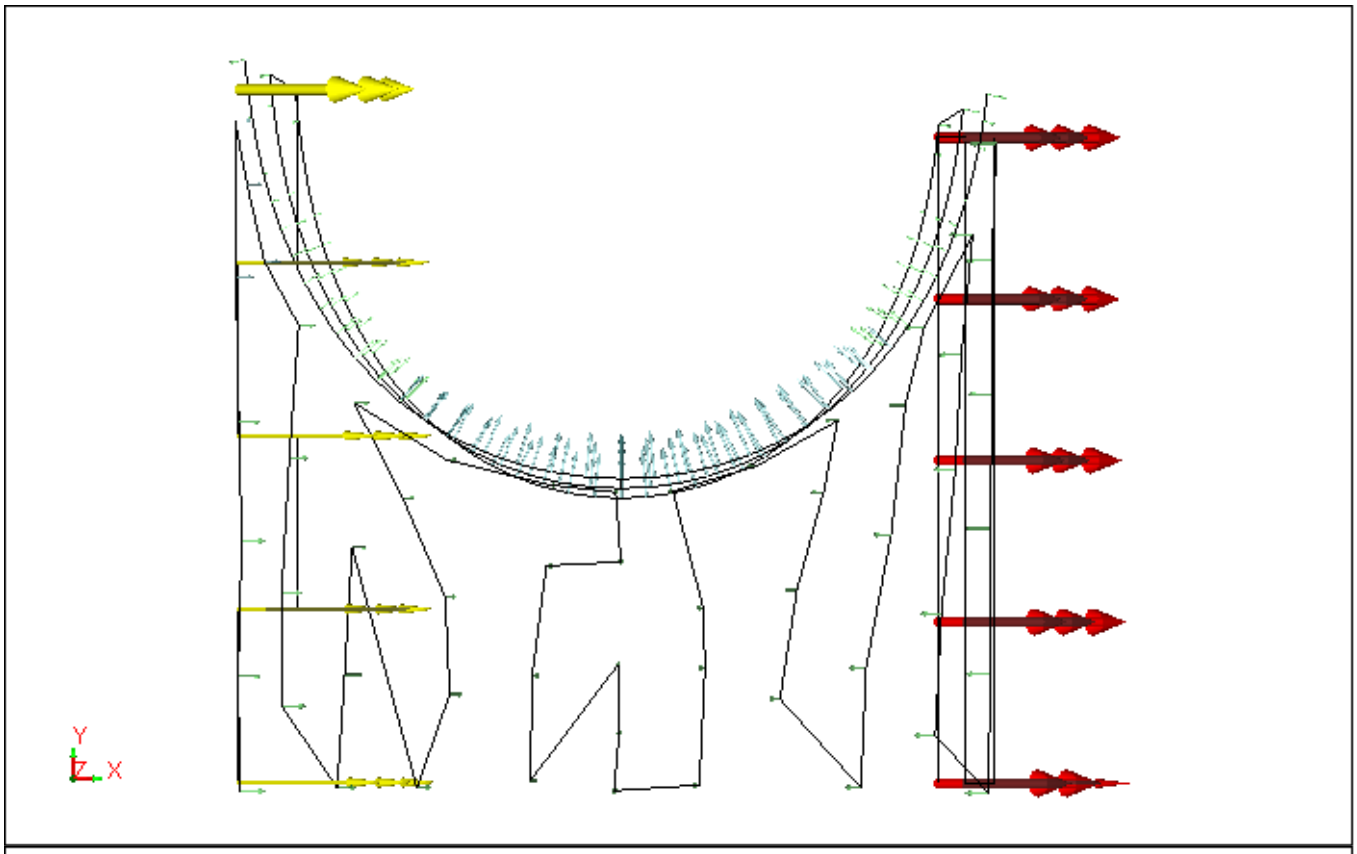
	MM	LOC12 - CIR_PH_N					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS
X	-25.400	-25.340	0.060				
Z	62.727	62.721	-0.006				
DF	6.401	6.403	0.002	0.130	0.130	0.000	0.000
RN	0.000	0.004	0.004	0.130	0.000	0.000	
TP	RFS		0.121	0.250		0.000	0.000

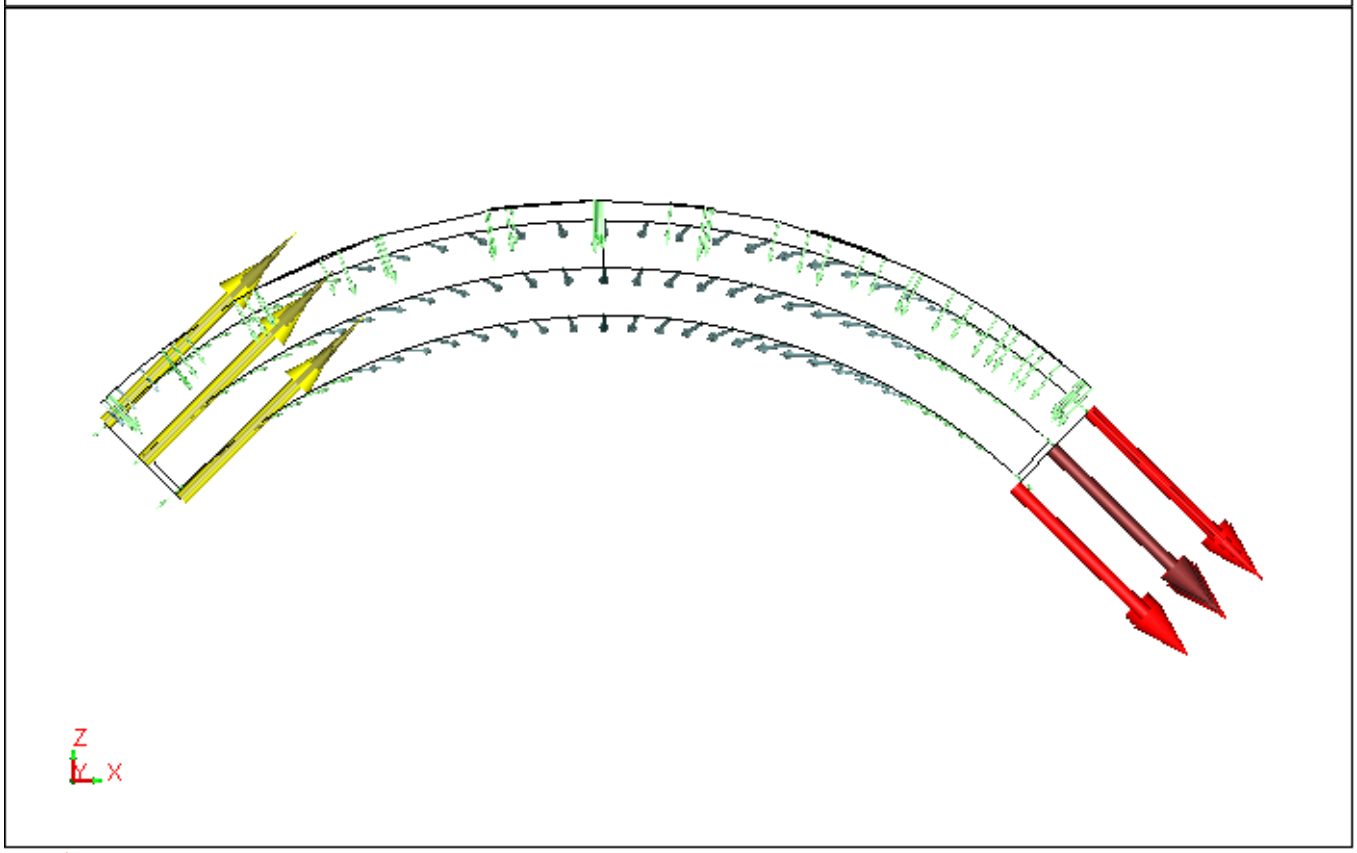
	MM	LOC13 - CIR_TH_P					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS
X	36.476	36.519	0.043				
Z	57.004	56.893	-0.111				
RN	0.000	0.002	0.002	0.010	0.000	0.000	
TP	RFS		0.238	0.250		0.000	0.000

	MM	LOC14 - CIR_TH_N					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS
X	-40.544	-40.511	0.034				
Z	54.185	54.185	0.000				
RN	0.000	0.003	0.003	0.010	0.000	0.000	
TP	RFS		0.068	0.250		0.000	0.000



	MM	PROF_NF_1 - SCNC_INNER FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.105	0.072	-0.033	0.200	0.200	0.000	
	MM	PROF_NF_2 - SCN_SN FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	-0.281	-0.225	-0.281	0.000	0.100	-0.181	
	MM	PROF_NF_3 - SCN_SP FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.256	0.256	0.230	0.000	0.100	0.256	
	MM	PROF_NF_4 - SCN_OD FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	-0.057	-0.033	-0.057	0.000	0.100	0.000	



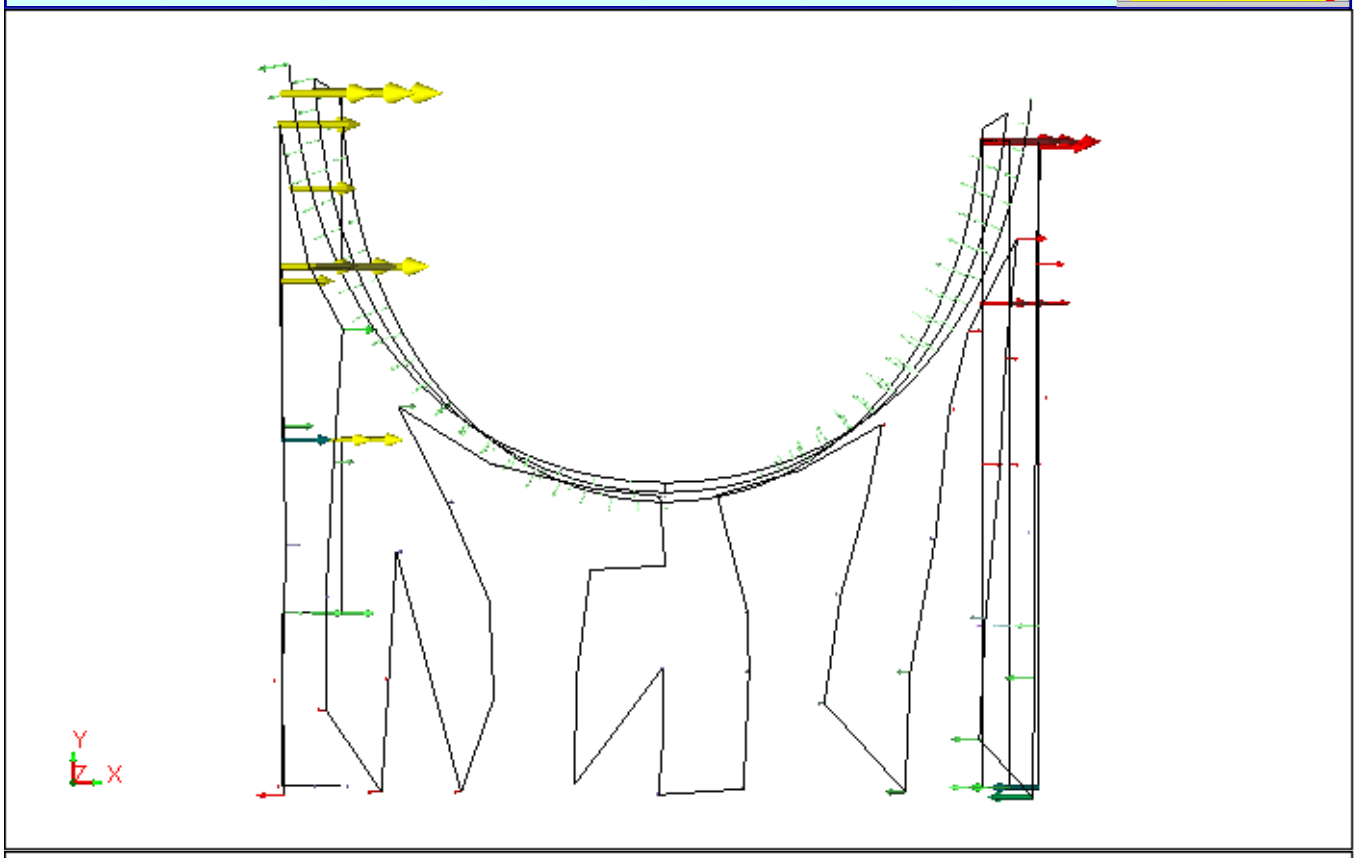


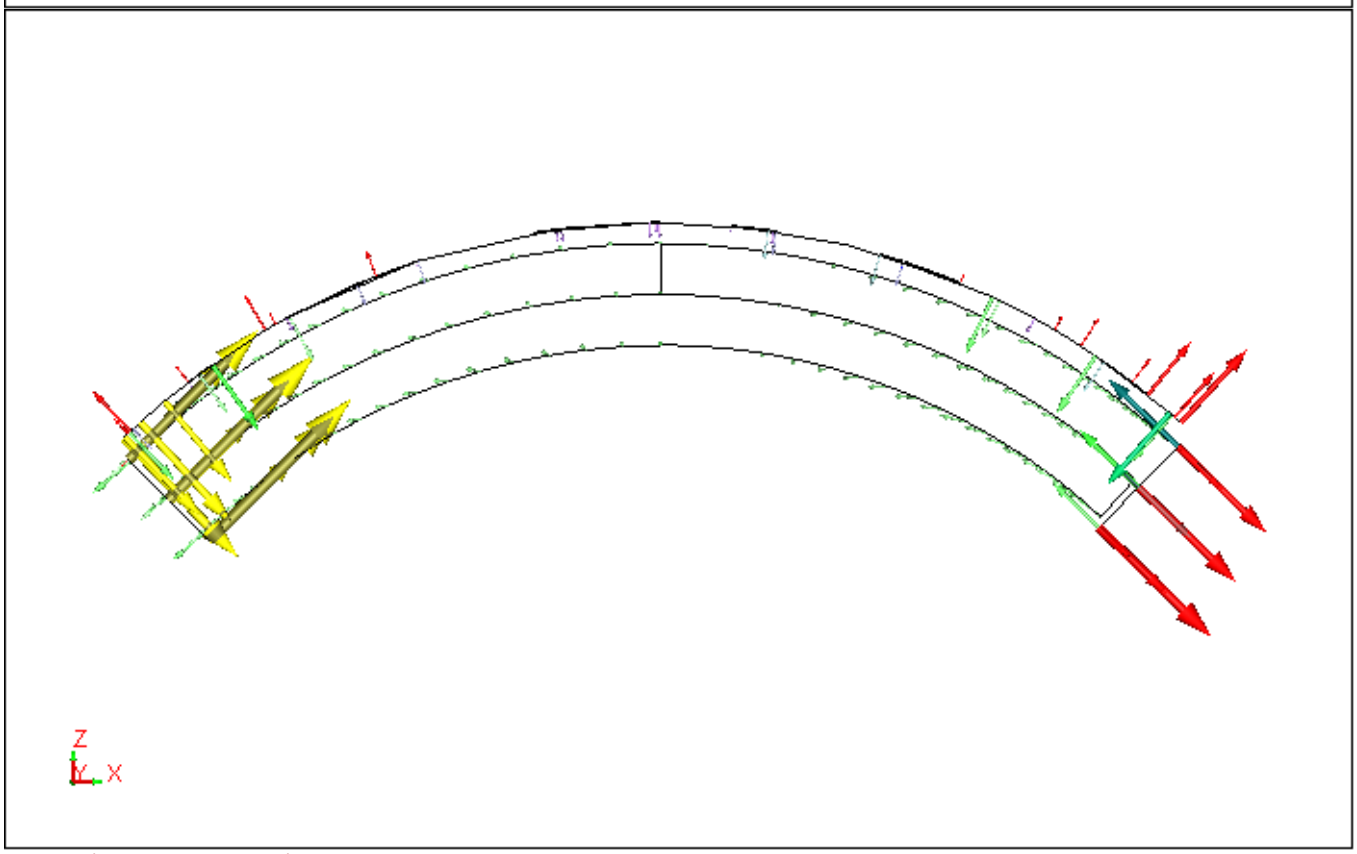
No fit
x100
See PROF_NF_1-PROF_NF_4

	MM	PROF_BF_1 - SCNC_INNER FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.094	0.037	-0.057	0.200	0.200	0.000	
	MM	PROF_BF_2 - SCN_SN FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.210	0.010	-0.200	0.000	0.100	0.110	

	MM	PROF_BF_3 - SCN_SP FORMANDLOCATION				
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL
M	0.247	0.153	-0.095	0.000	0.100	0.153

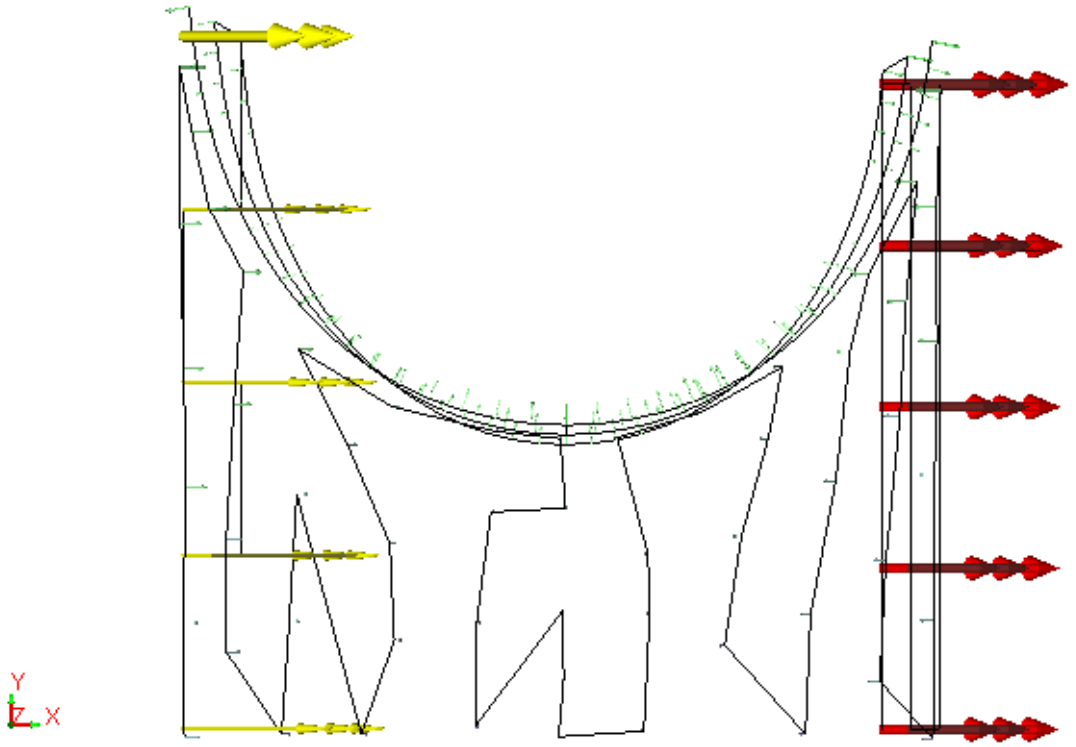
	MM	PROF_BF_4 - SCN_OD FORMANDLOCATION				
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL
M	0.257	0.096	-0.161	0.000	0.100	0.157

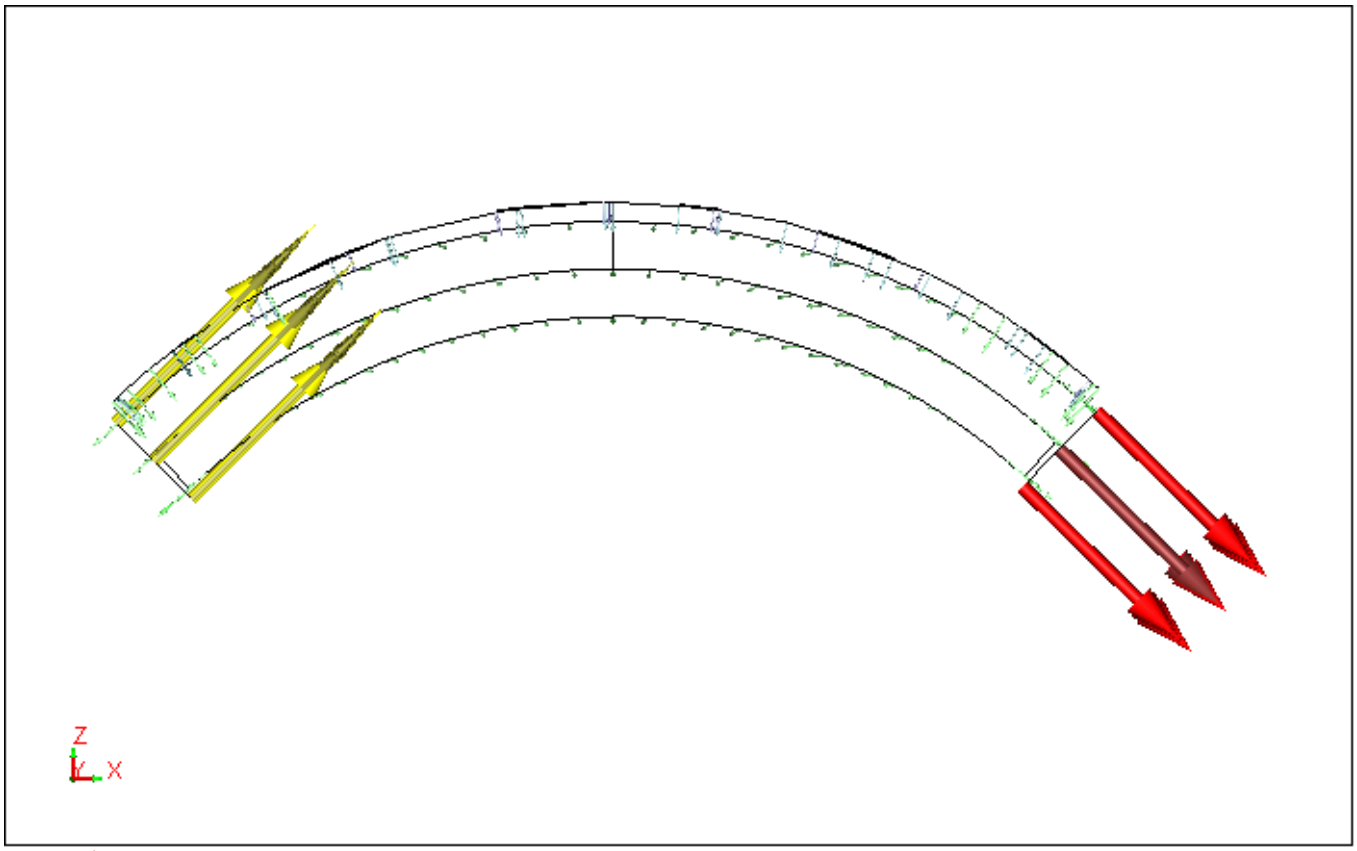




Best fit to Inner, Sides, & O.D. surfaces
x100
See PROF_BF_1-PROF_BF_4

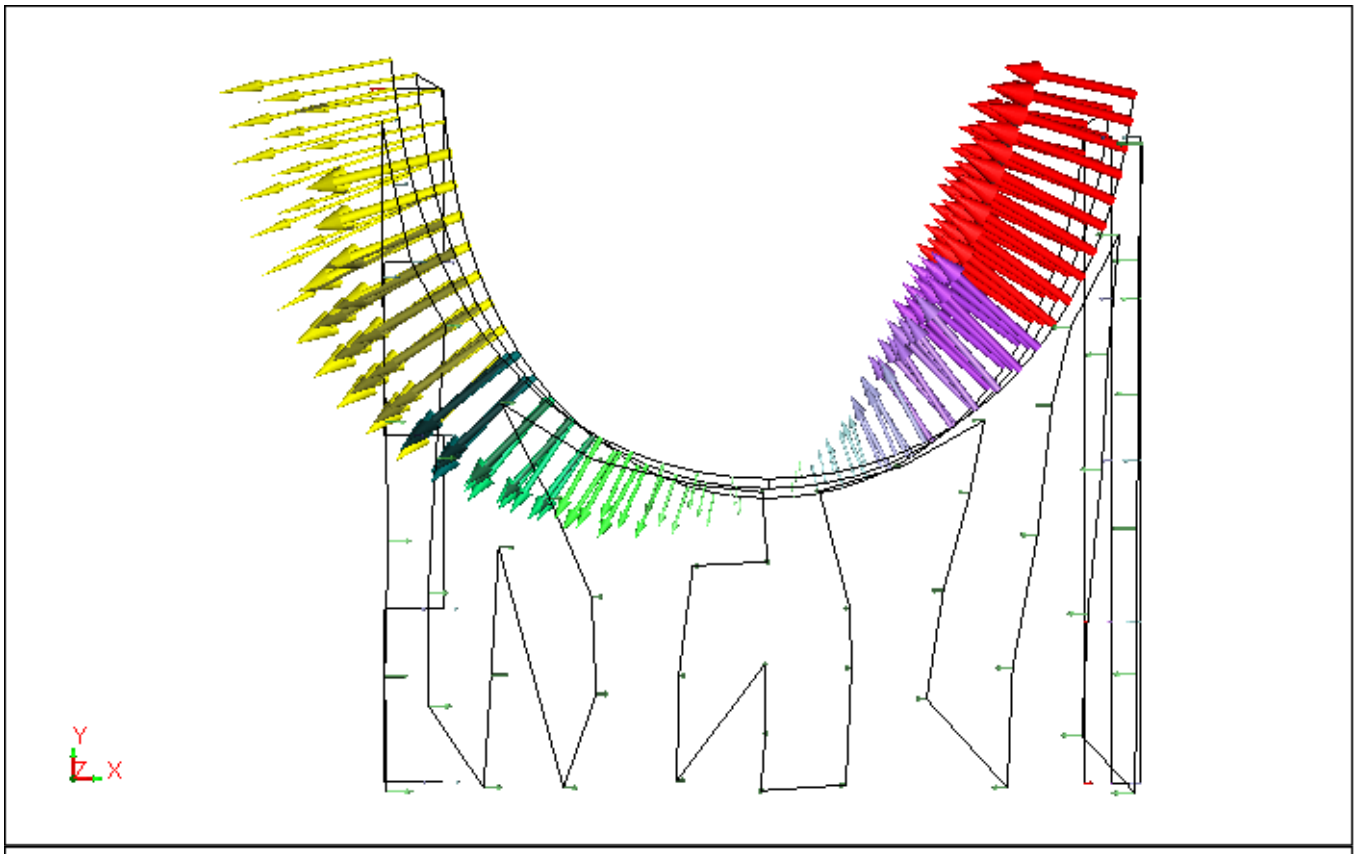
	MM	PROF_IF_1 - SCNC_INNER FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.090	0.039	-0.051	0.200	0.200	0.000	
	MM	PROF_IF_2 - SCN_SN FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	-0.295	-0.216	-0.295	0.000	0.100	-0.195	
	MM	PROF__IF_3 - SCN_SP FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.246	0.246	0.222	0.000	0.100	0.246	
	MM	PROF_IF_4 - SCN_OD FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	-0.055	-0.021	-0.055	0.000	0.100	0.000	

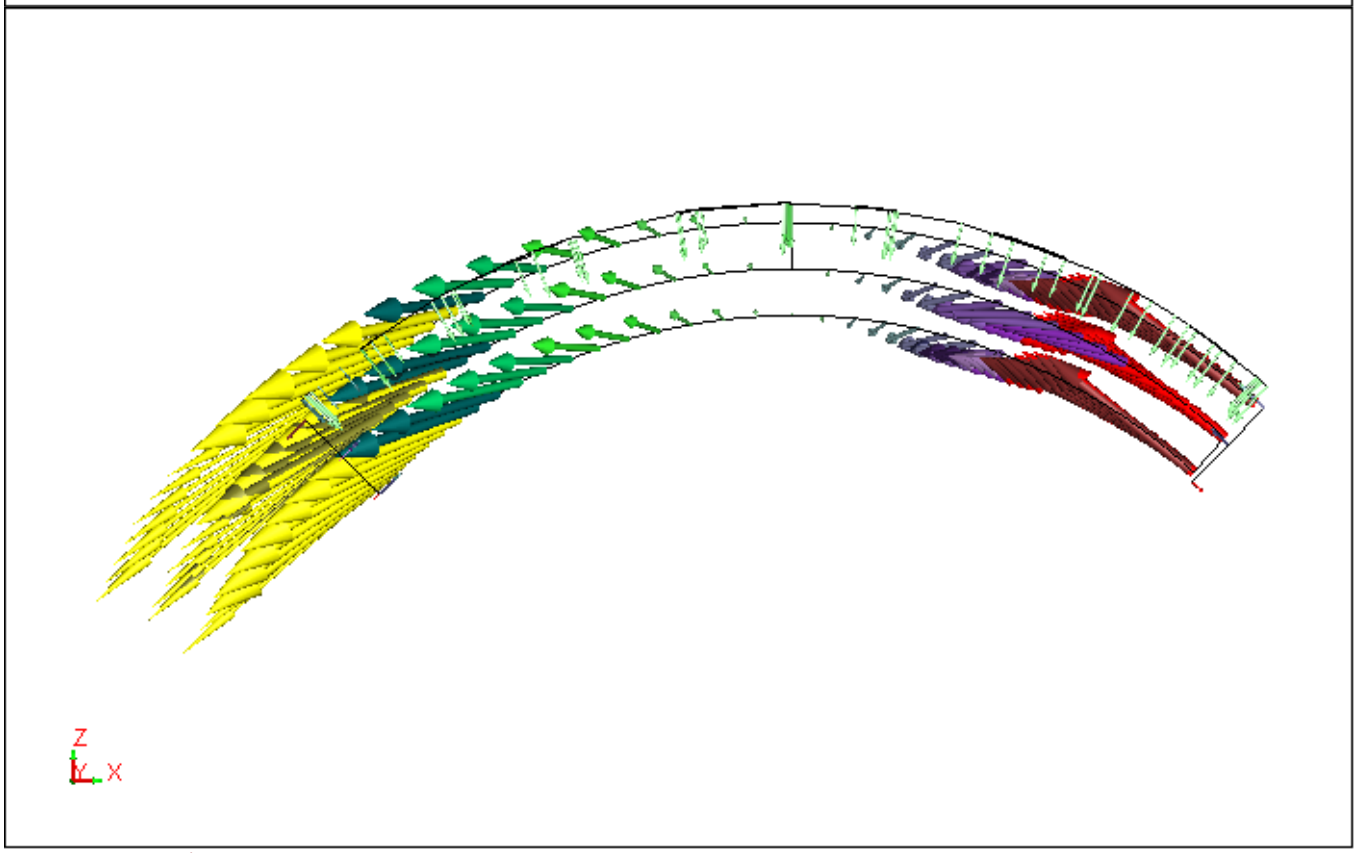




Best fit to Inner surface
x100
See PROF_IF_1-PROF_IF_4

	MM	PROF_MF_1 - SCNC_INNER FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.550	0.238	-0.311	0.200	0.200	0.150	
	MM	PROF_MF_2 - SCN_SN FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.065	0.031	-0.034	0.000	0.100	0.031	
	MM	PROF_MF_3 - SCN_SP FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	0.056	0.016	-0.040	0.000	0.100	0.016	
	MM	PROF_MF_4 - SCN_OD FORMANDLOCATION					
AX	MEAS	MAX	MIN	+TOL	-TOL	OUTTOL	
M	-0.058	-0.033	-0.058	0.000	0.100	0.000	
	MM	LOC15 - PLNC_SIDE_N					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
S	0.000	-0.010	-0.010	0.050	0.050	0.000	
	MM	LOC16 - PLNC_SIDE_P					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
S	0.000	-0.015	-0.015	0.050	0.050	0.000	





Manual Best Fit
x100
See PROF_MF_1-PROF_MF_4
Rotation: +0.217
Y Translation: +0.070

#	MM	LOC8 - F1		
AX	NOMINAL	MEAS	DEV	
X	0.000	-0.227	-0.227	
Y	0.000	-0.070	-0.070	
Z	60.000	60.000	0.000	

⊞	MM	LOC9 - F2

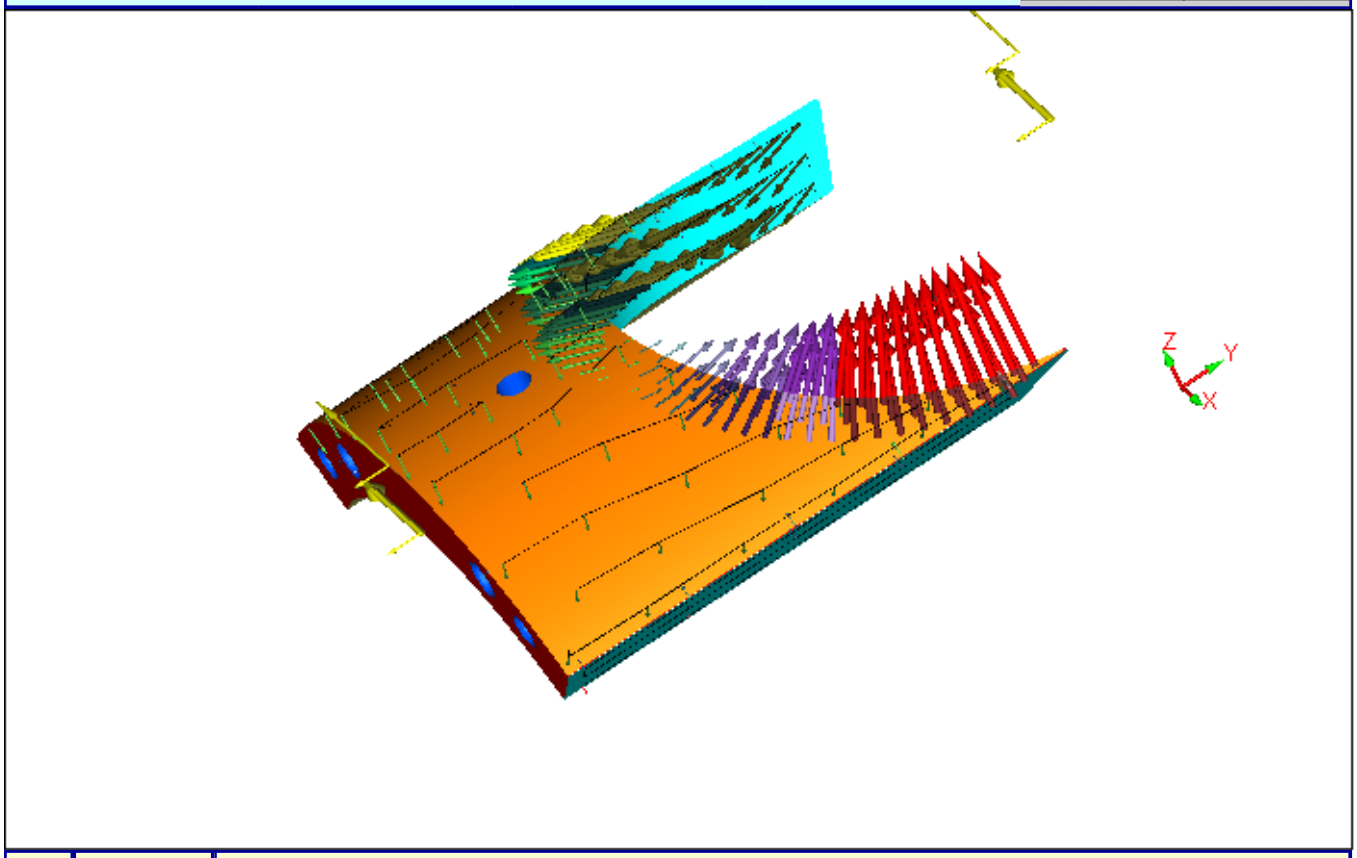
AX	NOMINAL	MEAS	DEV
X	0.000	-0.284	-0.284
Y	0.000	-0.070	-0.070
Z	75.000	74.999	-0.001

⊞	MM	LOC10 - F3

AX	NOMINAL	MEAS	DEV
X	0.000	-0.227	-0.227
Y	-128.000	-128.070	-0.070
Z	60.000	60.000	0.000

⊞	MM	LOC11 - F4

AX	NOMINAL	MEAS	DEV
X	0.000	-0.284	-0.284
Y	-128.000	-128.070	-0.070
Z	75.000	74.999	-0.001



⌖	MM	LOC17 - CIR_PH_P

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS
X	25.400	25.180	-0.220				
Z	62.727	62.756	0.029				
DF	6.401	6.403	0.002	0.130	0.130	0.000	0.000
RN	0.000	0.009	0.009	0.130	0.000	0.000	
TP	RFS		0.444	0.250		0.194	0.000

⌖	MM	LOC18 - CIR_PH_N						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS	
X	-25.400	-25.577	-0.177					
Z	62.727	62.624	-0.103					
DF	6.401	6.403	0.002	0.130	0.130	0.000	0.000	
RN	0.000	0.004	0.004	0.130	0.000	0.000		
TP	RFS		0.410	0.250		0.160	0.000	

⌖	MM	LOC19 - CIR_TH_P						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS	
X	36.476	36.304	-0.172					
Z	57.004	57.030	0.027					
RN	0.000	0.002	0.002	0.010	0.000	0.000		
TP	RFS		0.349	0.250		0.099	0.000	

⌖	MM	LOC20 - CIR_TH_N						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	BONUS	
X	-40.544	-40.715	-0.171					
Z	54.185	54.031	-0.154					
RN	0.000	0.003	0.003	0.010	0.000	0.000		
TP	RFS		0.461	0.250		0.211	0.000	