FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=6/25/2008 TIME=8:35:09 AM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC010 v3 IR
REV NUMBER :
SER NUMBER :
STATS COUNT : 1

440004-n
FNAL 1.3GHZ TESLA
RF CAVITY
ASSEMBLY
@ 000 rotation

'Inspected by ' : Robert Riley
'Cavity Number' : ACCEL-TB9ACC010
' ' : 0806241525

BEAM PIPE FLANGE NEAR

MM	DIM LOC1= LOCATION OF PLANE PL-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	0.000	0.000	0.000	0.200	0.200	0.000
V	-0.000	-1.000	0.003			
FL	0.000	0.013	0.013	0.200	0.000	0.000

// MM	DIM PARL1= PARALLEL OF PLANE PL-NEAR-END-FLANGE,RFS TO WORKPLANE YMINUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.404	0.404	0.200	0.000	0.204

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.193	0.193	0.100	0.100	0.093

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.012	-0.012	0.200	0.200	0.000
Z	0.000	0.409	0.409	0.200	0.200	0.209
D	140.000	140.068	0.068	0.300	0.300	0.000
RN	0.000	0.013	0.013	0.200	0.000	0.000

MM	DIM DIST03= 2D DISTANCE FROM PLANE PL-NEAR-END-FLANGE TO PLANE PL-NEAR-END-FLANGE-ORING PAR TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	1.000	1.084	0.084	0.100	0.100	0.000

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True Position of 6 Bolt Holes on the
NEAR BEAM PIPE FLANGE
to flange

⊕ MM	DIM TP NBPF BH1= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 015						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.969	-0.031				
PA	15.000	14.806	-0.194				
DF	8.800	8.824	0.024	0.300	0.300		0.000
TP	RFS		0.410	0.300		0.000	0.110
RN	0.000	0.018	0.018	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH2= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 045						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.942	-0.058				
PA	45.000	44.797	-0.203				
DF	8.800	8.843	0.043	0.300	0.300		0.000
TP	RFS		0.440	0.300		0.000	0.140
RN	0.000	0.015	0.015	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH3= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 075						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.961	-0.039				
PA	75.000	74.794	-0.206				
DF	8.800	8.820	0.020	0.300	0.300		0.000
TP	RFS		0.438	0.300		0.000	0.138
RN	0.000	0.011	0.011	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH4= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 105						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.958	-0.042				
PA	105.000	104.784	-0.216				
DF	8.800	8.818	0.018	0.300	0.300		0.000
TP	RFS		0.459	0.300		0.000	0.159
RN	0.000	0.012	0.012	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH5= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 135						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.982	-0.018				
PA	135.000	134.793	-0.207				
DF	8.800	8.825	0.025	0.300	0.300		0.000
TP	RFS		0.435	0.300		0.000	0.135
RN	0.000	0.017	0.017	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH6= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 165						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.933	-0.067				
PA	165.000	164.801	-0.199				
DF	8.800	8.820	0.020	0.300	0.300		0.000
TP	RFS		0.437	0.300		0.000	0.137
RN	0.000	0.019	0.019	0.300	0.000		0.000

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BEAM PIPE FLANGE FAR

MM DIM LOC3= LOCATION OF PLANE PL-FAR-END

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1247.400	1243.974	-3.426	3.000	3.000	0.426
V	0.002	1.000	0.002			
FL	0.000	0.042	0.042	0.200	0.000	0.000

// MM DIM PARL2= PARALLEL OF PLANE PL-FAR-END,RFS TO WORKPLANE YPLUS EXTEND=0.000

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.362	0.362	0.200	0.000	0.162

DEG DIM ANGL2= 3D ANGLE (COMPLEMENT) FROM PLANE PL-FAR-END TO YAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.168	0.168	0.100	0.100	0.068

MM DIM LOC4= LOCATION OF CIRCLE CR-FAR-END

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.082	0.082	0.200	0.200	0.000
Z	0.000	0.127	0.126	0.200	0.200	0.000
D	140.000	140.082	0.082	0.300	0.300	0.000
RN	0.000	0.005	0.005	0.200	0.000	0.000

MM DIM DIST04= 2D DISTANCE FROM PLANE PL-FAR-END TO PLANE PL-FAR-END-FLANGE-ORING PAR TO YAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	1.000	1.094	0.094	0.100	0.100	0.000

True Position of 6 Bolt Holes on the
FAR BEAM PIPE FLANGE
to flange

MM DIM TP FBPF BH1= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 015

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.990	-0.010				
PA	15.000	15.143	0.143				
DF	8.800	8.825	0.025	0.300	0.300		0.000
TP	RFS		0.301	0.300		0.000	0.001
RN	0.000	0.017	0.017	0.300	0.000		0.000

MM DIM TP FBPF BH2= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 045

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.991	-0.009				
PA	45.000	45.120	0.120				
DF	8.800	8.830	0.030	0.300	0.300		0.000
TP	RFS		0.252	0.300		0.000	0.000
RN	0.000	0.015	0.015	0.300	0.000		0.000

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⊕ MM	DIM TP FBPF BH3= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 075						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.979	-0.021				
PA	75.000	75.145	0.146				
DF	8.800	8.837	0.037	0.300	0.300		0.000
TP	RFS		0.308	0.300		0.000	0.008
RN	0.000	0.020	0.020	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH4= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 105						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.993	-0.007				
PA	105.000	105.146	0.146				
DF	8.800	8.826	0.026	0.300	0.300		0.000
TP	RFS		0.306	0.300		0.000	0.006
RN	0.000	0.018	0.018	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH5= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 135						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	60.013	0.013				
PA	135.000	135.133	0.133				
DF	8.800	8.833	0.033	0.300	0.300		0.000
TP	RFS		0.280	0.300		0.000	0.000
RN	0.000	0.013	0.013	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH6= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 165						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.980	-0.020				
PA	165.000	165.142	0.142				
DF	8.800	8.837	0.037	0.300	0.300		0.000
TP	RFS		0.301	0.300		0.000	0.001
RN	0.000	0.012	0.012	0.300	0.000		0.000

DATUM-1-PLANE

MM	DIM LOC-DATUM-1-PLANE= LOCATION OF PLANE PLC-DAT-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	92.840	92.628	-0.212	0.200	0.200	0.012
V	-0.002	-1.000	0.001			
FL	0.000	0.095	0.095	0.200	0.000	0.000

// MM	DIM PARL5= PARALLEL OF PLANE PLC-DAT-1,RFS TO WORKPLANE YMINUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.276	0.276	0.200	0.000	0.076

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.138	0.138	0.100	0.100	0.038

DATUM-2-PLANE

MM	DIM LOC-DATUM-2-PLANE= LOCATION OF PLANE PLC-DAT-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1154.560	1150.379	-4.181	0.200	0.200	3.981
V	-0.003	1.000	0.002			
FL	0.000	0.029	0.029	0.200	0.000	0.000

// MM	DIM PARL6= PARALLEL OF PLANE PLC-DAT-2,RFS TO WORKPLANE YPLUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.343	0.343	0.200	0.000	0.143

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.201	0.201	0.100	0.100	0.101

MM	DIM DIST3= 2D DISTANCE FROM PLANE PLC-DAT-1 TO PLANE PLC-DAT-2 PAR TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	1061.060	1057.751	-3.309	0.200	0.200	3.109

MM	DIM DIST4= 2D DISTANCE FROM PLANE PLC-DAT-2 TO PLANE PL-FAR-END PAR TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	93.500	93.595	0.095	0.200	0.200	0.000

PICKUP ANTENNA FLANGE NW8

MM	DIM LOC5= LOCATION OF PLANE PL NW8 ANTENNA FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-53.800	-53.900	-0.100	0.200	0.200	0.000
V	-1.000	-0.005	-0.003			
FL	0.000	0.004	0.004	0.200	0.000	0.000

// MM	DIM PARL3= PARALLEL OF PLANE PL NW8 ANTENNA FLANGE,RFS TO WORKPLANE XMINUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.172	0.172	0.200	0.000	0.000

DEG	DIM ANGL3= 3D ANGLE (TRUE) FROM PLANE PL NW8 ANTENNA FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.330	0.330	0.100	0.100	0.230

MM	DIM LOC6= LOCATION OF CIRCLE CR_NW8_ANTENNA_FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.477	-0.123	0.200	0.200	0.000
Z	0.000	0.199	0.199	0.200	0.200	0.000
D	33.800	33.835	0.035	0.150	0.000	0.000
RN	0.000	0.018	0.018	0.150	0.000	0.000

MM	DIM DIST01= 2D DISTANCE FROM PLANE PL NW8 ANTENNA FLANGE ORING TO PLANE PL NW8 ANTENNA FLANGE PAR TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.536	0.036	0.050	0.000	0.000

MAIN COUPLER FLANGE NW40

MM	DIM LOC7= LOCATION OF PLANE PL NW 40 FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	88.000	87.793	-0.207	0.200	0.200	0.007
V	1.000	-0.005	0.002			
FL	0.000	0.028	0.028	0.200	0.000	0.000

// MM	DIM PARL4= PARALLEL OF PLANE PL NW 40 FLANGE,RFS TO WORKPLANE XMINUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.339	0.339	0.200	0.000	0.139

DEG	DIM ANGL4= 3D ANGLE (COMPLEMENT) FROM PLANE PL NW 40 FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.280	0.280	0.100	0.100	0.180

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MM DIM LOC8= LOCATION OF CIRCLE CR_NW_40_FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1183.242	-3.558	0.200	0.200	3.358
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	75.980	-0.020	0.200	0.000	0.020
RN	0.000	0.014	0.014	0.200	0.000	0.000

MM DIM DIST1= 2D DISTANCE FROM CIRCLE CR_NW_40_FLANGE TO PLANE PL-FAR-END PAR TO YAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	60.600	60.733	0.133	0.200	0.200	0.000

MM DIM DIST NW40 MC DEPTH OF ORING GROOVE= 2D DISTANCE FROM PLANE PL NW 40 FLANGE ORING TO PLANE PL NW 40 FLANGE PAR TO XAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.618	0.118	0.050	0.000	0.068

MM DIM TP NW40 MC BH= TRUE POSITION OF CIRCLE CR NW 40 FLANGE BH

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	31.750	31.500	-0.250				
PA	112.500	112.286	-0.214				
DF	6.700	6.818	0.118	0.200	0.200		0.000
TP	RFS		0.552	0.300		0.000	0.252
RN	0.000	0.036	0.036	0.200	0.000		0.000

HOM-2 FLANGE NW12

MM DIM FLAT4= FLATNESS OF PLANE PL-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.004	0.004	0.200	0.000	0.000

MM DIM VECTOR1= LOCATION OF PLANE PL-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.552	0.264	0.791			

DEG DIM ANGL6= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM2 TO ZAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.903	-0.097	0.500	0.500	0.000

MM DIM LOC9= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-71.999	-71.999	100.000	100.000	0.000
Y	0.000	1187.163	1187.163	2000.000	2000.000	0.000
Z	0.000	-8.808	-8.808	100.000	100.000	0.000
D	33.800	33.929	0.129	0.150	0.000	0.000
RN	0.000	0.186	0.186	0.150	0.000	0.036

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MM DIM DIST FORMTEIL2 POINT= 2D DISTANCE FROM POINT PT-FORMTEIL2 TO PLANE PL-NW12-FLANGE-HOM2 PERP TO PLANE PL-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.529	0.109	0.100	0.100	0.009

MM DIM DIST FORMTEIL2 TAIL= 2D DISTANCE FROM PLANE PL-FORMTEIL2 TO PLANE PL-NW12-FLANGE-HOM2 PERP TO PLANE PL-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.529	0.109	0.100	0.100	0.009

MM DIM DIST NW12 FLANGE ORING DEPTH= 2D DISTANCE FROM PLANE PL-NW12-FLANGE-HOM2 O-RING TO PLANE PL-NW12-FLANGE-HOM2 PERP TO XAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.520	0.020	0.050	0.000	0.000

DEG DIM ANGL5= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM2 TO LINE LINC ZAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	15.159	0.159	0.500	0.500	0.000

HOM 1 LOCATION

MM DIM LOC-HOM1= LOCATION OF CYLINDER CY-HOM-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	69.050	69.050	100.000	100.000	0.000
Y	60.600	60.281	-0.319	0.200	0.200	0.119
Z	0.000	-40.055	-40.055	100.000	100.000	0.000
D	44.000	43.780	-0.220	0.000	0.100	0.120
RN	0.000	0.158	0.158	0.100	0.000	0.058
V	-0.865	0.003	0.501			

DEG DIM ANGL9= 2D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-1 TO XAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.068	0.068	0.500	0.500	0.000

DEG DIM ANGL10= 3D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO YAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	89.842	-0.158	0.500	0.500	0.000

DEG DIM ANGL11= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO ZAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	60.000	59.932	-0.068	0.500	0.500	0.000

MM DIM HOM1 POINT= LOCATION OF POINT PT-RT-HOM-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	115.916	-0.084	0.200	0.200	0.000

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MM	DIM HOM1 PLANE= LOCATION OF PLANE PL HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	111.096	0.096	0.200	0.200	0.000
FL	0.000	0.009	0.009	0.200	0.000	0.000

INTERSECTION OF HOM1 & YZ PLANE

MM	DIM LOC-HOM1 X PLANE= LOCATION OF POINT PTC-HOM1 X YZ PLANE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	60.600	60.502	-0.098	0.200	0.200	0.000
Z	0.000	-0.080	-0.080	0.200	0.200	0.000

HOM 2 LOCATION

MM	DIM LOC-HOM2= LOCATION OF CYLINDER CY-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-64.844	-64.844	100.000	100.000	0.000
Y	1186.800	1183.785	-3.015	3.000	3.000	0.015
Z	0.000	-45.033	-45.033	100.000	100.000	0.000
D	44.000	43.888	-0.112	0.000	0.100	0.012
RN	0.000	0.094	0.094	0.100	0.000	0.000
V	-0.825	0.004	-0.566			

MM	DIM DIST2= 2D DISTANCE FROM CYLINDER CY-HOM-2 TO PLANE PL-FAR-END PAR TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	60.600	60.190	-0.410	0.200	0.200	0.210

DEG	DIM ANGL12= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.460	-0.540	0.500	0.500	0.040

DEG	DIM ANGL13= 3D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	90.218	0.218	0.500	0.500	0.000

DEG	DIM ANGL14= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	55.000	55.540	0.540	0.500	0.500	0.040

MM	DIM HOM2 POINT= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.117	0.117	0.200	0.200	0.000

MM	DIM HOM2 PLANE= LOCATION OF PLANE PL HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	111.010	0.010	0.200	0.200	0.000
FL	0.000	0.001	0.001	0.200	0.000	0.000

INTERSECTION OF HOM2 & YZ PLANE

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MM	DIM LOC-HOM2 X PLANE= LOCATION OF POINT PTC-HOM2 X YZ PLANE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	1186.800	1183.485	-3.315	3.000	3.000	0.315
Z	0.000	-0.534	-0.534	0.200	0.200	0.334

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LOCATIONS OF CONSTRUCTED CIRCLES
ON 18 HALF CELLS & 2 DATUM SURFACES & 2 VACUUM SURFACES

MM DIM LOC-CC1= LOCATION OF CIRCLE CRC-DAT-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	0.000	94.634	94.634	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.895	-0.105	0.050	0.050	0.055
RN	0.000	0.021	0.021	0.050	0.000	0.000

MM DIM LOC-CC2= LOCATION OF CIRCLE CRC-VAC-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.069	0.069	0.200	0.200	0.000
Y	0.000	123.057	123.057	2000.000	2000.000	0.000
Z	0.000	-0.020	-0.020	0.200	0.200	0.000
D	191.200	191.249	0.049	0.200	0.200	0.000
RN	0.000	0.088	0.088	0.200	0.000	0.000

MM DIM LOC-CC3= LOCATION OF CIRCLE CRC-CAV-1-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.170	0.170	0.200	0.200	0.000
Y	0.000	156.483	156.483	2000.000	2000.000	0.000
Z	0.000	0.101	0.101	0.200	0.200	0.000
D	210.300	210.762	0.461	0.200	0.200	0.261
RN	0.000	0.267	0.267	0.200	0.000	0.067

MM DIM LOC-CC4= LOCATION OF CIRCLE CRC-CAV-1-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.126	0.125	0.200	0.200	0.000
Y	0.000	167.559	167.559	2000.000	2000.000	0.000
Z	0.000	0.068	0.068	0.200	0.200	0.000
D	210.300	210.595	0.295	0.200	0.200	0.095
RN	0.000	0.205	0.205	0.200	0.000	0.005

MM DIM LOC-CC5= LOCATION OF CIRCLE CRC-CAV-2-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.031	0.031	0.200	0.200	0.000
Y	0.000	270.710	270.710	2000.000	2000.000	0.000
Z	0.000	-0.187	-0.187	0.200	0.200	0.000
D	210.300	210.670	0.370	0.200	0.200	0.170
RN	0.000	0.087	0.087	0.200	0.000	0.000

MM DIM LOC-CC6= LOCATION OF CIRCLE CRC-CAV-2-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.030	0.030	0.200	0.200	0.000
Y	0.000	282.205	282.205	2000.000	2000.000	0.000
Z	0.000	-0.204	-0.204	0.200	0.200	0.004
D	210.300	210.590	0.289	0.200	0.200	0.089
RN	0.000	0.063	0.063	0.200	0.000	0.000

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MM DIM LOC-CC7= LOCATION OF CIRCLE CRC-CAV-3-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.045	-0.045	0.200	0.200	0.000
Y	0.000	385.923	385.923	2000.000	2000.000	0.000
Z	0.000	-0.402	-0.402	0.200	0.200	0.202
D	210.300	210.682	0.382	0.200	0.200	0.182
RN	0.000	0.195	0.195	0.200	0.000	0.000

MM DIM LOC-CC8= LOCATION OF CIRCLE CRC-CAV-3-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.045	-0.045	0.200	0.200	0.000
Y	0.000	397.561	397.561	2000.000	2000.000	0.000
Z	0.000	-0.439	-0.440	0.200	0.200	0.240
D	210.300	210.564	0.264	0.200	0.200	0.064
RN	0.000	0.263	0.263	0.200	0.000	0.063

MM DIM LOC-CC9= LOCATION OF CIRCLE CRC-CAV-4-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.097	-0.097	0.200	0.200	0.000
Y	0.000	500.797	500.797	2000.000	2000.000	0.000
Z	0.000	-0.604	-0.604	0.200	0.200	0.404
D	210.300	210.624	0.324	0.200	0.200	0.124
RN	0.000	0.084	0.084	0.200	0.000	0.000

MM DIM LOC-CC10= LOCATION OF CIRCLE CRC-CAV-4-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.096	-0.097	0.200	0.200	0.000
Y	0.000	512.325	512.325	2000.000	2000.000	0.000
Z	0.000	-0.602	-0.602	0.200	0.200	0.402
D	210.300	210.562	0.262	0.200	0.200	0.062
RN	0.000	0.050	0.050	0.200	0.000	0.000

MM DIM LOC-CC11= LOCATION OF CIRCLE CRC-CAV-5-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.090	-0.090	0.200	0.200	0.000
Y	0.000	615.812	615.812	2000.000	2000.000	0.000
Z	0.000	-0.644	-0.644	0.200	0.200	0.444
D	210.300	210.626	0.326	0.200	0.200	0.126
RN	0.000	0.165	0.165	0.200	0.000	0.000

MM DIM LOC-CC12= LOCATION OF CIRCLE CRC-CAV-5-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.100	-0.100	0.200	0.200	0.000
Y	0.000	627.475	627.475	2000.000	2000.000	0.000
Z	0.000	-0.657	-0.658	0.200	0.200	0.458
D	210.300	210.485	0.185	0.200	0.200	0.000
RN	0.000	0.243	0.243	0.200	0.000	0.043

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MM DIM LOC-CC13= LOCATION OF CIRCLE CRC-CAV-6-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.119	-0.119	0.200	0.200	0.000
Y	0.000	730.831	730.831	2000.000	2000.000	0.000
Z	0.000	-0.630	-0.630	0.200	0.200	0.430
D	210.300	210.702	0.402	0.200	0.200	0.202
RN	0.000	0.171	0.171	0.200	0.000	0.000

MM DIM LOC-CC14= LOCATION OF CIRCLE CRC-CAV-6-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.073	-0.073	0.200	0.200	0.000
Y	0.000	742.186	742.186	2000.000	2000.000	0.000
Z	0.000	-0.624	-0.625	0.200	0.200	0.425
D	210.300	210.516	0.215	0.200	0.200	0.015
RN	0.000	0.145	0.145	0.200	0.000	0.000

MM DIM LOC-CC15= LOCATION OF CIRCLE CRC-CAV-7-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.010	-0.010	0.200	0.200	0.000
Y	0.000	846.377	846.377	2000.000	2000.000	0.000
Z	0.000	-0.564	-0.564	0.200	0.200	0.364
D	210.300	210.649	0.349	0.200	0.200	0.149
RN	0.000	0.147	0.147	0.200	0.000	0.000

MM DIM LOC-CC16= LOCATION OF CIRCLE CRC-CAV-7-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.019	-0.019	0.200	0.200	0.000
Y	0.000	857.767	857.767	2000.000	2000.000	0.000
Z	0.000	-0.552	-0.552	0.200	0.200	0.352
D	210.300	210.599	0.299	0.200	0.200	0.099
RN	0.000	0.158	0.158	0.200	0.000	0.000

MM DIM LOC-CC17= LOCATION OF CIRCLE CRC-CAV-8-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.025	0.025	0.200	0.200	0.000
Y	0.000	961.379	961.379	2000.000	2000.000	0.000
Z	0.000	-0.389	-0.389	0.200	0.200	0.189
D	210.300	210.633	0.333	0.200	0.200	0.133
RN	0.000	0.148	0.148	0.200	0.000	0.000

MM DIM LOC-CC18= LOCATION OF CIRCLE CRC-CAV-8-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.031	0.031	0.200	0.200	0.000
Y	0.000	972.594	972.594	2000.000	2000.000	0.000
Z	0.000	-0.381	-0.381	0.200	0.200	0.181
D	210.300	210.573	0.273	0.200	0.200	0.073
RN	0.000	0.166	0.166	0.200	0.000	0.000

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MM DIM LOC-CC19= LOCATION OF CIRCLE CRC-CAV-9-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.136	0.136	0.200	0.200	0.000
Y	0.000	1076.241	1076.241	2000.000	2000.000	0.000
Z	0.000	-0.197	-0.197	0.200	0.200	0.000
D	210.300	210.652	0.352	0.200	0.200	0.152
RN	0.000	0.170	0.170	0.200	0.000	0.000

MM DIM LOC-CC20= LOCATION OF CIRCLE CRC-CAV-9-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.137	0.137	0.200	0.200	0.000
Y	0.000	1087.792	1087.792	2000.000	2000.000	0.000
Z	0.000	-0.133	-0.133	0.200	0.200	0.000
D	210.300	210.605	0.305	0.200	0.200	0.105
RN	0.000	0.130	0.130	0.200	0.000	0.000

MM DIM LOC-CC21= LOCATION OF CIRCLE CRC-VAC-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.089	0.089	0.200	0.200	0.000
Y	0.000	1117.763	1117.763	2000.000	2000.000	0.000
Z	0.000	-0.076	-0.076	0.200	0.200	0.000
D	200.000	200.116	0.116	0.200	0.200	0.000
RN	0.000	0.041	0.041	0.200	0.000	0.000

MM DIM LOC-CC22= LOCATION OF CIRCLE CRC-DAT-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	0.000	1148.512	1148.512	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.893	-0.107	0.050	0.050	0.057
RN	0.000	0.025	0.025	0.050	0.000	0.000

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TRUE POSITIONS OF CONSTRUCTED CIRCLES
ON 18 HALF CELLS & 2 DATUM SURFACES & 2 VACUUM SURFACES

⊕ MM	DIM LOC-TP-CC1= TRUE POSITION OF CIRCLE CRC-DAT-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.000	0.000				
Z	0.000	0.000	0.000				
TP	RFS		0.000	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC2= TRUE POSITION OF CIRCLE CRC-VAC-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.069	0.069				
Z	0.000	-0.020	-0.020				
TP	RFS		0.144	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC3= TRUE POSITION OF CIRCLE CRC-CAV-1-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.170	0.170				
Z	0.000	0.101	0.101				
TP	RFS		0.395	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC4= TRUE POSITION OF CIRCLE CRC-CAV-1-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.126	0.125				
Z	0.000	0.068	0.068				
TP	RFS		0.286	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC5= TRUE POSITION OF CIRCLE CRC-CAV-2-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.031	0.031				
Z	0.000	-0.187	-0.187				
TP	RFS		0.379	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.030	0.030				
Z	0.000	-0.204	-0.204				
TP	RFS		0.413	0.400		0.000	0.013

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.045	-0.045				
Z	0.000	-0.402	-0.402				
TP	RFS		0.810	0.400		0.000	0.410

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⊕ MM	DIM LOC-TP-CC8= TRUE POSITION OF CIRCLE CRC-CAV-3-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.045	-0.045				
Z	0.000	-0.439	-0.440				
TP	RFS		0.884	0.400		0.000	0.484

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.097	-0.097				
Z	0.000	-0.604	-0.604				
TP	RFS		1.223	0.400		0.000	0.823

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.096	-0.097				
Z	0.000	-0.602	-0.602				
TP	RFS		1.219	0.400		0.000	0.819

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.090	-0.090				
Z	0.000	-0.644	-0.644				
TP	RFS		1.301	0.400		0.000	0.901

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.100	-0.100				
Z	0.000	-0.657	-0.658				
TP	RFS		1.330	0.400		0.000	0.930

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.119	-0.119				
Z	0.000	-0.630	-0.630				
TP	RFS		1.282	0.400		0.000	0.882

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.073	-0.073				
Z	0.000	-0.624	-0.625				
TP	RFS		1.258	0.400		0.000	0.858

⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.010	-0.010				
Z	0.000	-0.564	-0.564				
TP	RFS		1.129	0.400		0.000	0.729

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⊕ MM DIM LOC-TP-CC16= TRUE POSITION OF CIRCLE CRC-CAV-7-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.019	-0.019				
Z	0.000	-0.552	-0.552				
TP	RFS		1.104	0.400		0.000	0.704

⊕ MM DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.025	0.025				
Z	0.000	-0.389	-0.389				
TP	RFS		0.780	0.400		0.000	0.380

⊕ MM DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.031	0.031				
Z	0.000	-0.381	-0.381				
TP	RFS		0.764	0.400		0.000	0.364

⊕ MM DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.136	0.136				
Z	0.000	-0.197	-0.197				
TP	RFS		0.478	0.400		0.000	0.078

⊕ MM DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.137	0.137				
Z	0.000	-0.133	-0.133				
TP	RFS		0.382	0.400		0.000	0.000

⊕ MM DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.089	0.089				
Z	0.000	-0.076	-0.076				
TP	RFS		0.234	0.400		0.000	0.000

⊕ MM DIM LOC-TP-CC22= TRUE POSITION OF CIRCLE CRC-DAT-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.000	0.000				
Z	0.000	0.000	0.000				
TP	RFS		0.000	0.400		0.000	0.000

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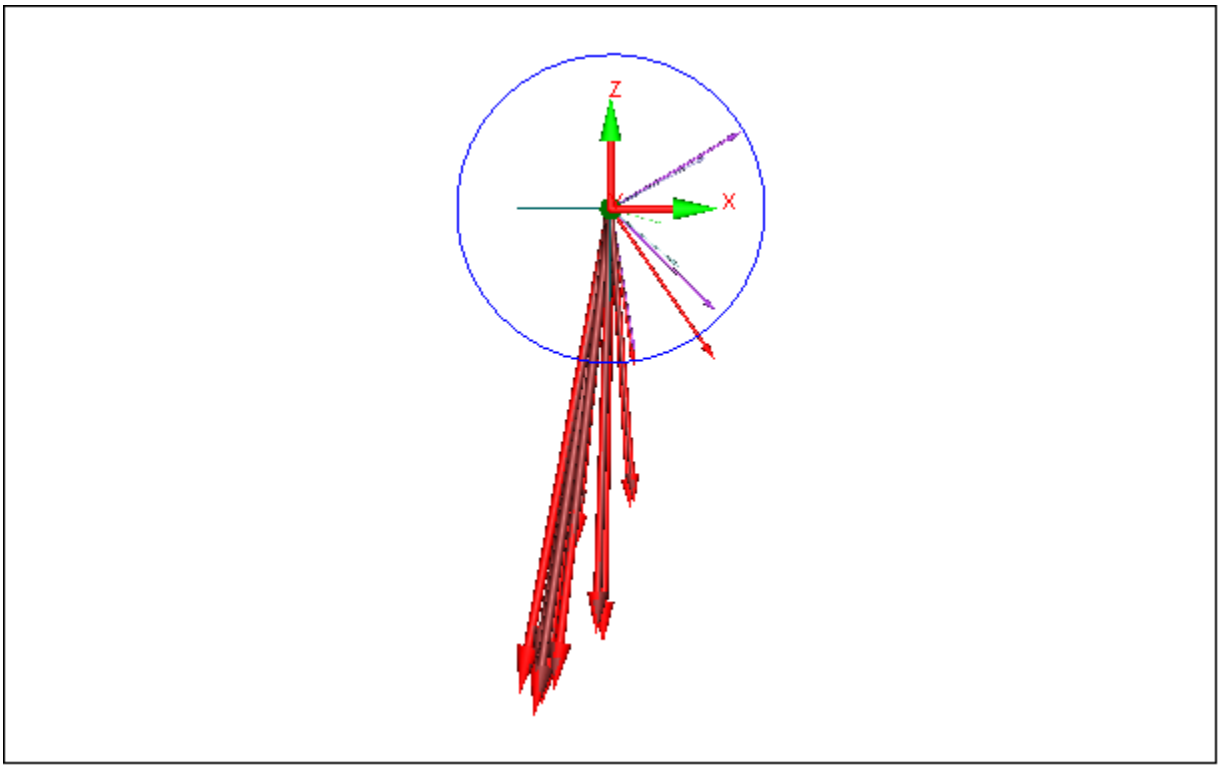
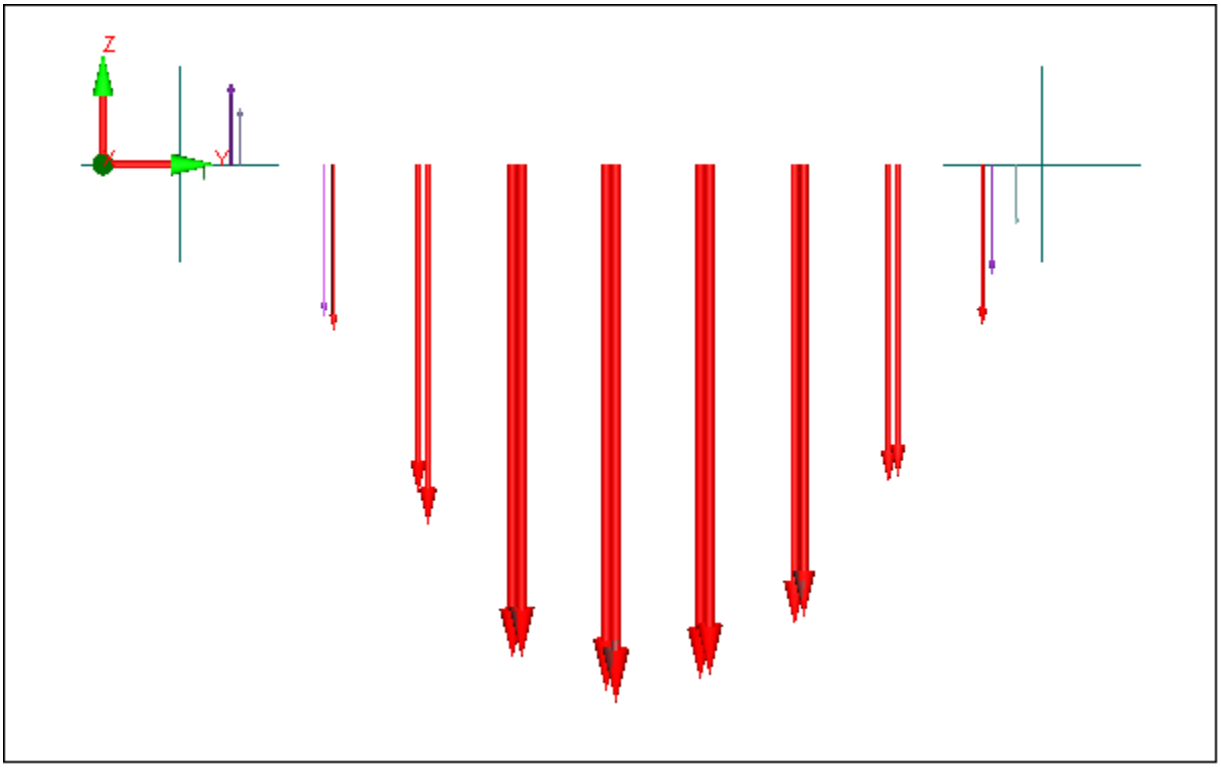
True Position plots from 3 views
x1000



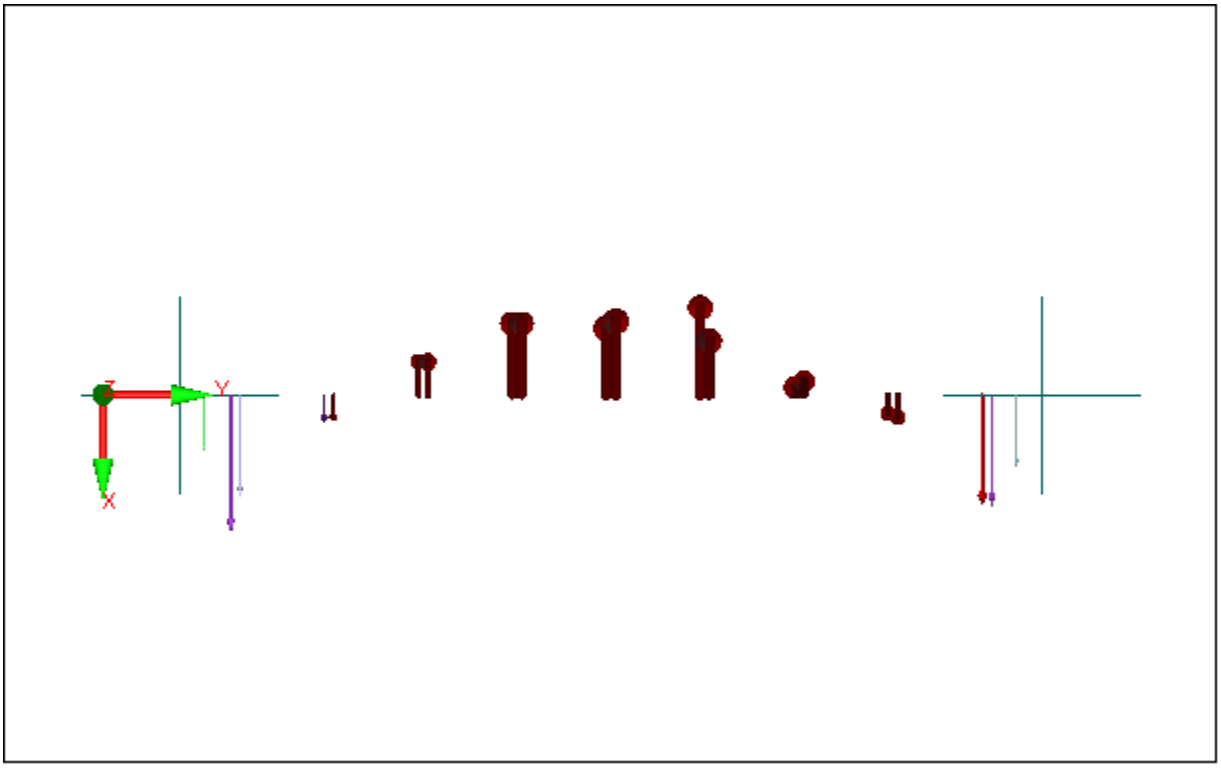
-Y View
x1000



PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC010 v3 IR DATE=6/25/2008

+X View

x1000



+Z View

x1000

MM	DIM LOC-BEST FIT CONSTRUCTED LINE= LOCATION OF LINE LNC-BEST-FIT					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.007	0.007	0.200	0.200	0.000
Y	0.000	621.636	621.636	2000.000	2000.000	0.000
Z	0.000	-0.324	-0.324	0.200	0.200	0.124
ST	0.000	0.754	0.754	0.200	0.000	0.554

SUPPORT RING CIRCLE LOCATIONS

MM	DIM LOC-SUPPORT RING-1= LOCATION OF CIRCLE CR-SUPPORT-RING-T12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.035	0.035	0.200	0.200	0.000
Y	0.000	218.652	218.652	2000.000	2000.000	0.000
Z	0.000	0.035	0.035	0.200	0.200	0.000
R	56.500	56.395	-0.105	0.200	0.200	0.000
RN	0.000	0.011	0.011	0.200	0.000	0.000

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MM	DIM LOC-SUPPORT RING-2= LOCATION OF CIRCLE CR-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.033	-0.033	0.200	0.200	0.000
Y	0.000	333.647	333.647	2000.000	2000.000	0.000
Z	0.000	-0.274	-0.274	0.200	0.200	0.074
R	56.500	56.410	-0.090	0.200	0.200	0.000
RN	0.000	0.005	0.005	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-3= LOCATION OF CIRCLE CR-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.091	-0.091	0.200	0.200	0.000
Y	0.000	448.648	448.648	2000.000	2000.000	0.000
Z	0.000	-0.521	-0.521	0.200	0.200	0.321
R	56.500	56.419	-0.081	0.200	0.200	0.000
RN	0.000	0.004	0.004	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-4= LOCATION OF CIRCLE CR-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.137	-0.137	0.200	0.200	0.000
Y	0.000	564.650	564.650	2000.000	2000.000	0.000
Z	0.000	-0.573	-0.573	0.200	0.200	0.373
R	56.500	56.344	-0.156	0.200	0.200	0.000
RN	0.000	0.007	0.007	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-5= LOCATION OF CIRCLE CR-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.122	-0.122	0.200	0.200	0.000
Y	0.000	679.650	679.650	2000.000	2000.000	0.000
Z	0.000	-0.668	-0.668	0.200	0.200	0.468
R	56.500	56.414	-0.086	0.200	0.200	0.000
RN	0.000	0.027	0.027	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-6= LOCATION OF CIRCLE CR-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.105	-0.105	0.200	0.200	0.000
Y	0.000	794.644	794.644	2000.000	2000.000	0.000
Z	0.000	-0.565	-0.565	0.200	0.200	0.365
R	56.500	56.427	-0.073	0.200	0.200	0.000
RN	0.000	0.004	0.004	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-7= LOCATION OF CIRCLE CR-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.044	0.044	0.200	0.200	0.000
Y	0.000	909.647	909.647	2000.000	2000.000	0.000
Z	0.000	-0.427	-0.427	0.200	0.200	0.227
R	56.500	56.340	-0.160	0.200	0.200	0.000
RN	0.000	0.019	0.019	0.200	0.000	0.000

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MM	DIM LOC-SUPPORT RING-8= LOCATION OF CIRCLE CR-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.002	0.002	0.200	0.200	0.000
Y	0.000	1025.649	1025.649	2000.000	2000.000	0.000
Z	0.000	-0.248	-0.248	0.200	0.200	0.048
R	56.500	56.390	-0.110	0.200	0.200	0.000
RN	0.000	0.043	0.043	0.200	0.000	0.000

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SUPPORT RING POINT LOCATIONS

MM	DIM LOC-SUPPORT RING-PT1= LOCATION OF POINT PT-SUPPORT-RING-T12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.097	0.097	0.200	0.200	0.000
Y	0.000	212.465	212.465	2000.000	2000.000	0.000
Z	56.500	56.464	-0.036	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PT2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.096	0.096	0.200	0.200	0.000
Y	0.000	327.452	327.452	2000.000	2000.000	0.000
Z	56.500	56.143	-0.357	0.200	0.200	0.157

MM	DIM LOC-SUPPORT RING-PT3= LOCATION OF POINT PT-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.095	0.095	0.200	0.200	0.000
Y	0.000	442.552	442.552	2000.000	2000.000	0.000
Z	56.500	55.851	-0.650	0.200	0.200	0.450

MM	DIM LOC-SUPPORT RING-PT4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.094	0.094	0.200	0.200	0.000
Y	0.000	557.852	557.852	2000.000	2000.000	0.000
Z	56.500	55.806	-0.695	0.200	0.200	0.495

MM	DIM LOC-SUPPORT RING-PT5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.093	0.093	0.200	0.200	0.000
Y	0.000	672.902	672.902	2000.000	2000.000	0.000
Z	56.500	55.738	-0.762	0.200	0.200	0.562

MM	DIM LOC-SUPPORT RING-PT6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.093	0.092	0.200	0.200	0.000
Y	0.000	787.652	787.652	2000.000	2000.000	0.000
Z	56.500	55.799	-0.701	0.200	0.200	0.501

MM	DIM LOC-SUPPORT RING-PT7= LOCATION OF POINT PT-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.092	0.092	0.200	0.200	0.000
Y	0.000	902.752	902.752	2000.000	2000.000	0.000
Z	56.500	55.860	-0.640	0.200	0.200	0.440

MM	DIM LOC-SUPPORT RING-PT8= LOCATION OF POINT PT-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.091	0.091	0.200	0.200	0.000
Y	0.000	1017.752	1017.752	2000.000	2000.000	0.000
Z	56.500	56.138	-0.362	0.200	0.200	0.162

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SUPPORT RING CIRCLES IN Z

MM	DIM LOC Z SUPPORT RING CIRCLES 1= LOCATION OF CIRCLE CR-SUPPORT-RING-T1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	0.035	0.035	0.200	0.200	0.000

MM	DIM LOC Z SUPPORT RING CIRCLES 2= LOCATION OF CIRCLE CR-SUPPORT-RING-T2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.274	-0.274	0.200	0.200	0.074

MM	DIM LOC Z SUPPORT RING CIRCLES 3= LOCATION OF CIRCLE CR-SUPPORT-RING-T3					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.521	-0.521	0.200	0.200	0.321

MM	DIM LOC Z SUPPORT RING CIRCLES 4= LOCATION OF CIRCLE CR-SUPPORT-RING-T4					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.573	-0.573	0.200	0.200	0.373

MM	DIM LOC Z SUPPORT RING CIRCLES 5= LOCATION OF CIRCLE CR-SUPPORT-RING-T5					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.668	-0.668	0.200	0.200	0.468

MM	DIM LOC Z SUPPORT RING CIRCLES 6= LOCATION OF CIRCLE CR-SUPPORT-RING-T6					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.565	-0.565	0.200	0.200	0.365

MM	DIM LOC Z SUPPORT RING CIRCLES 7= LOCATION OF CIRCLE CR-SUPPORT-RING-T7					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.427	-0.427	0.200	0.200	0.227

MM	DIM LOC Z SUPPORT RING CIRCLES 8= LOCATION OF CIRCLE CR-SUPPORT-RING-T8					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.248	-0.248	0.200	0.200	0.048

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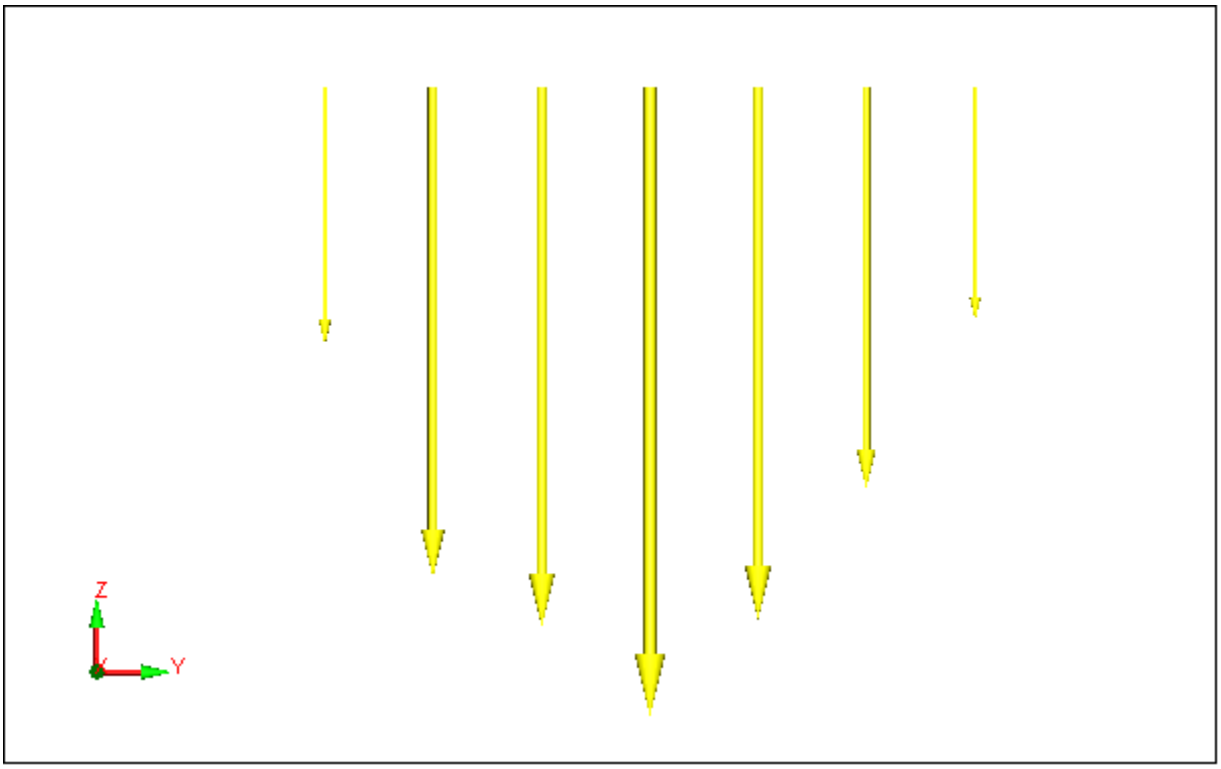

SUPPORT RING CIRCLES IN Z
x1000

SUPPORT RING POINTS IN Z

MM	DIM LOC Z SUPPORT RING POINTS 1= LOCATION OF POINT PT-SUPPORT-RING-T12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	56.464	-0.036	0.200	0.200	0.000

MM	DIM LOC Z SUPPORT RING POINTS 2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	56.143	-0.357	0.200	0.200	0.157

MM	DIM LOC Z SUPPORT RING POINTS 3= LOCATION OF POINT PT-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.851	-0.650	0.200	0.200	0.450

MM	DIM LOC Z SUPPORT RING POINTS 4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.806	-0.695	0.200	0.200	0.495

MM	DIM LOC Z SUPPORT RING POINTS 5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.738	-0.762	0.200	0.200	0.562

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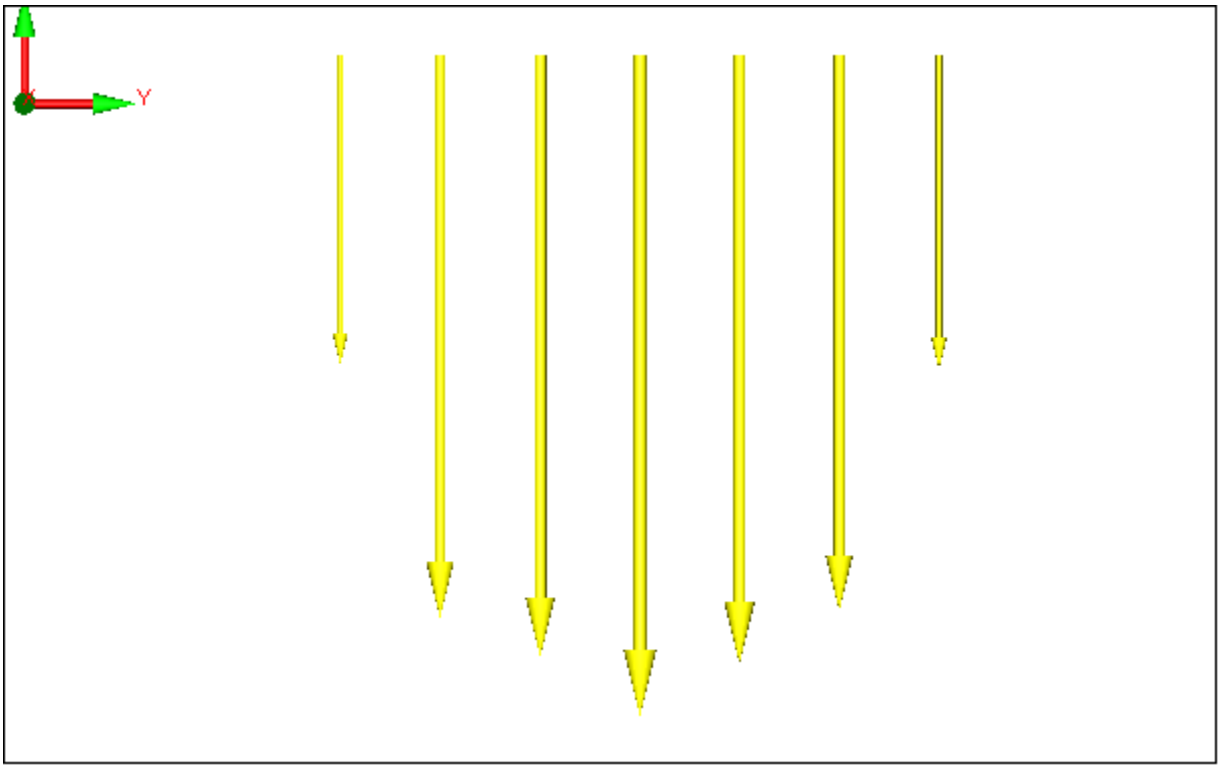
MM	DIM LOC Z SUPPORT RING POINTS 6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.799	-0.701	0.200	0.200	0.501

MM	DIM LOC Z SUPPORT RING POINTS 7= LOCATION OF POINT PT-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.860	-0.640	0.200	0.200	0.440

MM	DIM LOC Z SUPPORT RING POINTS 8= LOCATION OF POINT PT-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	56.138	-0.362	0.200	0.200	0.162



SUPPORT RING POINTS IN Z
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC010 v3 IR D
WG= SN=
TOTAL # OF MEAS =329 # OUT OF TOL =124