FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=6/24/2008 TIME=10:52:24 AM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9ACC010 v3 IR
REV NUMBER :
SER NUMBER :
STATS COUNT : 1

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

'Inspected by ' : Robert Riley
'Cavity Number' : ACCEL TB9ACC010
' ' : 0806240814

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	-0.001			
FL	0.000	0.020	0.020	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	0.146	0.146	0.200	0.000	0.000

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.068	0.068	0.100	0.100	0.000

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.003	0.003	0.200	0.200	0.000
Z	0.000	-0.033	-0.033	0.200	0.200	0.000
D	140.000	140.066	0.066	0.300	0.300	0.000
RN	0.000	0.010	0.010	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	1.089	0.089	0.100	0.100	0.000

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

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⊕ MM	DIM TP NBPF BH7= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 195						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.951	-0.050				
PA	-165.000	-165.081	-0.081				
DF	8.800	8.824	0.024	0.300	0.300		0.000
TP	RFS		0.197	0.300		0.000	0.000
RN	0.000	0.015	0.015	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH8= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 225						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.960	-0.041				
PA	-135.000	-135.082	-0.082				
DF	8.800	8.820	0.020	0.300	0.300		0.000
TP	RFS		0.190	0.300		0.000	0.000
RN	0.000	0.011	0.011	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH9= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 255						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.975	-0.025				
PA	-105.000	-105.097	-0.097				
DF	8.800	8.819	0.019	0.300	0.300		0.000
TP	RFS		0.210	0.300		0.000	0.000
RN	0.000	0.013	0.013	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH10= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 285						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.989	-0.011				
PA	-75.000	-75.100	-0.100				
DF	8.800	8.826	0.026	0.300	0.300		0.000
TP	RFS		0.211	0.300		0.000	0.000
RN	0.000	0.018	0.018	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH11= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH315						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.962	-0.038				
PA	-45.000	-45.087	-0.087				
DF	8.800	8.826	0.026	0.300	0.300		0.000
TP	RFS		0.197	0.300		0.000	0.000
RN	0.000	0.015	0.015	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH12= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 345						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.948	-0.053				
PA	-15.000	-15.085	-0.085				
DF	8.800	8.827	0.027	0.300	0.300		0.000
TP	RFS		0.206	0.300		0.000	0.000
RN	0.000	0.014	0.014	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	1243.979	-3.421	3.000	3.000	0.421
V	0.002	1.000	-0.003			
FL	0.000	0.040	0.040	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.442	0.442	0.200	0.000	0.242

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.210	0.210	0.100	0.100	0.110

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.093	0.093	0.200	0.200	0.000
Z	0.000	-0.294	-0.294	0.200	0.200	0.094
D	140.000	140.082	0.082	0.300	0.300	0.000
RN	0.000	0.007	0.007	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 BH7= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 195

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.999	-0.001				
PA	-165.000	-164.695	0.305				
DF	8.800	8.838	0.038	0.300	0.300		0.000
TP	RFS		0.639	0.300		0.000	0.339
RN	0.000	0.019	0.019	0.300	0.000		0.000

MM DIM TP FBPF BH8= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 225

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.976	-0.024				
PA	-135.000	-134.739	0.261				
DF	8.800	8.841	0.041	0.300	0.300		0.000
TP	RFS		0.549	0.300		0.000	0.249
RN	0.000	0.016	0.016	0.300	0.000		0.000

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⊕ MM	DIM TP FBPF BH9= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 255						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.973	-0.028				
PA	-105.000	-104.730	0.270				
DF	8.800	8.840	0.040	0.300	0.300		0.000
TP	RFS		0.568	0.300		0.000	0.268
RN	0.000	0.012	0.012	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH10= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 285						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.991	-0.010				
PA	-75.000	-74.743	0.257				
DF	8.800	8.836	0.036	0.300	0.300		0.000
TP	RFS		0.538	0.300		0.000	0.238
RN	0.000	0.016	0.016	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH11= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 315						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.967	-0.033				
PA	-45.000	-44.751	0.249				
DF	8.800	8.838	0.038	0.300	0.300		0.000
TP	RFS		0.526	0.300		0.000	0.226
RN	0.000	0.028	0.028	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH12= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 345						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.998	-0.003				
PA	-15.000	-14.742	0.258				
DF	8.800	8.834	0.034	0.300	0.300		0.000
TP	RFS		0.541	0.300		0.000	0.241
RN	0.000	0.021	0.021	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	92.614	-0.226	0.200	0.200	0.026
V	-0.002	-1.000	-0.004			
FL	0.000	0.096	0.096	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	0.476	0.476	0.200	0.000	0.276

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.261	0.261	0.100	0.100	0.161

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	1150.400	-4.160	0.200	0.200	3.960
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 YMINUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.342	0.342	0.200	0.000	0.142

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.192	0.192	0.100	0.100	0.092

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	1057.786	-3.274	0.200	0.200	3.074

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	93.579	0.079	0.200	0.200	0.000

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PICKUP ANTENNA FLANGE NW8

MM	DIM LOC5= LOCATION OF PLANE PL NW8 ANTENNA FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-53.800	-53.897	-0.097	0.200	0.200	0.000
V	-1.000	-0.005	-0.004			
FL	0.000	0.006	0.006	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	0.186	0.186	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	0.395	0.395	0.100	0.100	0.295

MM	DIM LOC6= LOCATION OF CIRCLE CR_NW8_ANTENNA_FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.474	-0.126	0.200	0.200	0.000
Z	0.000	-0.058	-0.058	0.200	0.200	0.000
D	33.800	33.835	0.035	0.150	0.000	0.000
RN	0.000	0.017	0.017	0.150	0.000	0.000

MM	DIM DIST01= 2D DISTANCE FROM PLANE PL NW8 ANTENNA FLANGE TO PLANE PL NW8 ANTENNA FLANGE ORING PAR TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.535	0.035	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	87.796	-0.203	0.200	0.200	0.003
V	1.000	-0.005	0.004			
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	0.423	0.423	0.200	0.000	0.223

DEG	DIM ANGL4= 3D ANGLE (TRUE) FROM PLANE PL NW 40 FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.346	0.346	0.100	0.100	0.246

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MM DIM LOC8= LOCATION OF CIRCLE CR_NW_40_FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1183.239	-3.561	0.200	0.200	3.361
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	75.982	-0.018	0.200	0.000	0.018
RN	0.000	0.016	0.016	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	60.740	0.140	0.200	0.200	0.000

MM DIM DIST NW40 MC DEPTH OF ORING GROOVE= 2D DISTANCE FROM PLANE PL NW 40 FLANGE TO PLANE PL NW 40 FLANGE ORING 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	31.501	-0.249				
PA	112.500	112.549	0.049				
DF	6.700	6.819	0.119	0.200	0.200		0.000
TP	RFS		0.502	0.300		0.000	0.202
RN	0.000	0.043	0.043	0.200	0.000		0.000

MM DIM TP NW40 MC BH2= TRUE POSITION OF CIRCLE CR NW 40 FLANGE BH2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	31.750	31.531	-0.219				
PA	-67.500	-67.398	0.102				
DF	6.700	6.863	0.163	0.200	0.200		0.000
TP	RFS		0.453	0.300		0.000	0.153
RN	0.000	0.036	0.036	0.200	0.000		0.000

HOM-1 FLANGE NW12

MM DIM VECTOR HOM1 FLANGE= LOCATION OF PLANE PL-NW12-FLANGE-HOM1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.482	-0.254	-0.838			

MM DIM FLAT1= FLATNESS OF PLANE PL-NW12-FLANGE-HOM1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.007	0.007	0.200	0.000	0.000

DEG DIM ANGL16= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM1 TO ZAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	14.736	-0.264	0.500	0.500	0.000

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MM	DIM DIST FORMTEIL1 POINT= 2D DISTANCE FROM POINT PT-FORMTEIL1 TO PLANE PL-NW12-FLANGE-HOM1 PERP TO PLANE PL-NW12-FLANGE-HOM1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.619	0.199	0.100	0.100	0.099

MM	DIM DIST FORMTEIL1 PLANE= 2D DISTANCE FROM PLANE PL-FORMTEIL1 TO PLANE PL-NW12-FLANGE-HOM1 PERP TO PLANE PL-NW12-FLANGE-HOM1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.618	0.198	0.100	0.100	0.098

MM	DIM DIST02= 2D DISTANCE FROM PLANE PL-NW12-FLANGE-HOM1 TO PLANE PL-NW12-FLANGE O-RING PAR TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.510	0.010	0.050	0.000	0.000

DEG	DIM ANGL17= 2D ANGLE (COMPLEMENT) FROM PLANE PL-NW12-FLANGE-HOM1 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	29.904	-0.096	0.500	0.500	0.000

MM	DIM LOC= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	38.237	38.237	100.000	100.000	0.000
Y	0.000	57.224	57.224	100.000	100.000	0.000
Z	0.000	-62.223	-62.223	100.000	100.000	0.000
D	33.800	33.752	-0.048	0.150	0.000	0.048
RN	0.000	0.050	0.050	0.150	0.000	0.000

HOM-2 FLANGE NW12

MM	DIM VECTOR1= LOCATION OF PLANE PL-NW12-FLANGE-HOM2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.553	0.268	0.789			

MM	DIM FLAT4= FLATNESS OF PLANE PL-NW12-FLANGE-HOM2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.006	0.006	0.200	0.000	0.000

DEG	DIM ANGL5= 2D ANGLE (COMPLEMENT) FROM PLANE PL-NW12-FLANGE-HOM2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	15.533	0.533	0.500	0.500	0.033

DEG	DIM ANGL6= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	35.054	0.054	0.500	0.500	0.000

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MM	DIM LOC9= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-72.151	-72.151	100.000	100.000	0.000
Y	0.000	1187.005	1187.005	2000.000	2000.000	0.000
Z	0.000	-8.766	-8.766	100.000	100.000	0.000
D	33.800	33.811	0.011	0.150	0.000	0.000
RN	0.000	0.066	0.066	0.150	0.000	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	68.644	68.644	100.000	100.000	0.000
Y	60.600	60.487	-0.113	0.200	0.200	0.000
Z	0.000	-39.811	-39.811	100.000	100.000	0.000
D	44.000	43.793	-0.207	0.000	0.100	0.107
RN	0.000	0.210	0.210	0.100	0.000	0.110
V	-0.866	0.000	0.500			

DEG	DIM ANGL9= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	29.975	-0.025	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	89.988	-0.012	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	60.025	0.025	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	115.999	-0.001	0.200	0.200	0.000

MM	DIM HOM1 PLANE= LOCATION OF PLANE PL HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	111.181	0.181	0.200	0.200	0.000
FL	0.000	0.008	0.008	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	60.504	-0.096	0.200	0.200	0.000
Z	0.000	-0.220	-0.220	0.200	0.200	0.020

HOM 2 LOCATION

MM	DIM LOC-HOM2= LOCATION OF CYLINDER CY-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-64.745	-64.745	100.000	100.000	0.000
Y	1186.800	1183.575	-3.225	3.000	3.000	0.225
Z	0.000	-45.238	-45.238	100.000	100.000	0.000
D	44.000	43.899	-0.101	0.000	0.100	0.001
RN	0.000	0.087	0.087	0.100	0.000	0.000
V	0.821	-0.001	0.571			

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	60.404	-0.196	0.200	0.200	0.000

DEG	DIM ANGL12= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.799	-0.201	0.500	0.500	0.000

DEG	DIM ANGL13= 3D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	89.942	-0.058	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	55.201	0.201	0.500	0.500	0.000

MM	DIM LOC HOM2= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.210	0.210	0.200	0.200	0.010

MM	DIM HOM2 PLANE= LOCATION OF PLANE PL HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	111.103	0.103	0.200	0.200	0.000
FL	0.000	0.001	0.001	0.200	0.000	0.000

INTERSECTION OF HOM2 & YZ PLANE

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	1183.495	-3.305	3.000	3.000	0.305
Z	0.000	-0.241	-0.241	0.200	0.200	0.041

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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	94.538	94.538	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.897	-0.103	0.050	0.050	0.053
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	0.066	0.066	0.200	0.200	0.000
Y	0.000	123.079	123.079	2000.000	2000.000	0.000
Z	0.000	0.112	0.112	0.200	0.200	0.000
D	191.200	191.250	0.050	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	0.161	0.161	0.200	0.200	0.000
Y	0.000	156.493	156.493	2000.000	2000.000	0.000
Z	0.000	0.388	0.388	0.200	0.200	0.188
D	210.300	210.767	0.467	0.200	0.200	0.267
RN	0.000	0.261	0.261	0.200	0.000	0.061

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.123	0.123	0.200	0.200	0.000
Y	0.000	167.169	167.169	2000.000	2000.000	0.000
Z	0.000	0.386	0.386	0.200	0.200	0.186
D	210.300	210.610	0.310	0.200	0.200	0.110
RN	0.000	0.207	0.207	0.200	0.000	0.007

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.018	0.018	0.200	0.200	0.000
Y	0.000	270.792	270.792	2000.000	2000.000	0.000
Z	0.000	0.563	0.563	0.200	0.200	0.363
D	210.300	210.675	0.375	0.200	0.200	0.175
RN	0.000	0.092	0.092	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	0.010	0.010	0.200	0.200	0.000
Y	0.000	282.347	282.347	2000.000	2000.000	0.000
Z	0.000	0.577	0.577	0.200	0.200	0.377
D	210.300	210.588	0.288	0.200	0.200	0.088
RN	0.000	0.066	0.066	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	-0.065	-0.065	0.200	0.200	0.000
Y	0.000	385.978	385.978	2000.000	2000.000	0.000
Z	0.000	0.714	0.714	0.200	0.200	0.514
D	210.300	210.690	0.390	0.200	0.200	0.190
RN	0.000	0.196	0.196	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	-0.075	-0.075	0.200	0.200	0.000
Y	0.000	397.486	397.486	2000.000	2000.000	0.000
Z	0.000	0.700	0.699	0.200	0.200	0.499
D	210.300	210.567	0.268	0.200	0.200	0.068
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	-0.111	-0.111	0.200	0.200	0.000
Y	0.000	500.859	500.859	2000.000	2000.000	0.000
Z	0.000	0.740	0.740	0.200	0.200	0.540
D	210.300	210.634	0.334	0.200	0.200	0.134
RN	0.000	0.077	0.077	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	-0.125	-0.125	0.200	0.200	0.000
Y	0.000	512.456	512.456	2000.000	2000.000	0.000
Z	0.000	0.753	0.753	0.200	0.200	0.553
D	210.300	210.563	0.263	0.200	0.200	0.063
RN	0.000	0.046	0.046	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	-0.109	-0.109	0.200	0.200	0.000
Y	0.000	615.893	615.893	2000.000	2000.000	0.000
Z	0.000	0.785	0.785	0.200	0.200	0.585
D	210.300	210.631	0.332	0.200	0.200	0.132
RN	0.000	0.171	0.171	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	-0.129	-0.129	0.200	0.200	0.000
Y	0.000	627.539	627.539	2000.000	2000.000	0.000
Z	0.000	0.772	0.772	0.200	0.200	0.572
D	210.300	210.489	0.189	0.200	0.200	0.000
RN	0.000	0.239	0.239	0.200	0.000	0.039

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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	-0.145	-0.145	0.200	0.200	0.000
Y	0.000	730.862	730.862	2000.000	2000.000	0.000
Z	0.000	0.729	0.729	0.200	0.200	0.529
D	210.300	210.708	0.408	0.200	0.200	0.208
RN	0.000	0.172	0.172	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	-0.101	-0.101	0.200	0.200	0.000
Y	0.000	742.282	742.282	2000.000	2000.000	0.000
Z	0.000	0.723	0.723	0.200	0.200	0.523
D	210.300	210.517	0.217	0.200	0.200	0.017
RN	0.000	0.151	0.151	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	-0.031	-0.031	0.200	0.200	0.000
Y	0.000	846.131	846.131	2000.000	2000.000	0.000
Z	0.000	0.572	0.571	0.200	0.200	0.371
D	210.300	210.648	0.348	0.200	0.200	0.148
RN	0.000	0.143	0.143	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	-0.036	-0.036	0.200	0.200	0.000
Y	0.000	857.864	857.864	2000.000	2000.000	0.000
Z	0.000	0.561	0.560	0.200	0.200	0.360
D	210.300	210.602	0.302	0.200	0.200	0.102
RN	0.000	0.157	0.157	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	0.008	0.008	0.200	0.200	0.000
Y	0.000	961.115	961.115	2000.000	2000.000	0.000
Z	0.000	0.390	0.390	0.200	0.200	0.190
D	210.300	210.628	0.328	0.200	0.200	0.128
RN	0.000	0.135	0.135	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	0.020	0.020	0.200	0.200	0.000
Y	0.000	972.765	972.765	2000.000	2000.000	0.000
Z	0.000	0.369	0.369	0.200	0.200	0.169
D	210.300	210.572	0.272	0.200	0.200	0.072
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	0.132	0.132	0.200	0.200	0.000
Y	0.000	1076.465	1076.465	2000.000	2000.000	0.000
Z	0.000	0.119	0.118	0.200	0.200	0.000
D	210.300	210.664	0.364	0.200	0.200	0.164
RN	0.000	0.171	0.171	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	0.128	0.128	0.200	0.200	0.000
Y	0.000	1087.788	1087.788	2000.000	2000.000	0.000
Z	0.000	0.145	0.145	0.200	0.200	0.000
D	210.300	210.608	0.308	0.200	0.200	0.108
RN	0.000	0.129	0.129	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	0.088	0.088	0.200	0.200	0.000
Y	0.000	1117.401	1117.401	2000.000	2000.000	0.000
Z	0.000	0.068	0.068	0.200	0.200	0.000
D	200.000	200.119	0.119	0.200	0.200	0.000
RN	0.000	0.038	0.038	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	1148.503	1148.503	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.894	-0.106	0.050	0.050	0.056
RN	0.000	0.022	0.022	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	0.066	0.066				
Z	0.000	0.112	0.112				
TP	RFS		0.260	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	0.161	0.161				
Z	0.000	0.388	0.388				
TP	RFS		0.840	0.400		0.000	0.440

⊕ MM	DIM LOC-TP-CC4= TRUE POSITION OF CIRCLE CRC-CAV-1-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.123	0.123				
Z	0.000	0.386	0.386				
TP	RFS		0.811	0.400		0.000	0.411

⊕ MM	DIM LOC-TP-CC5= TRUE POSITION OF CIRCLE CRC-CAV-2-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.018	0.018				
Z	0.000	0.563	0.563				
TP	RFS		1.126	0.400		0.000	0.726

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.010	0.010				
Z	0.000	0.577	0.577				
TP	RFS		1.153	0.400		0.000	0.753

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.065	-0.065				
Z	0.000	0.714	0.714				
TP	RFS		1.434	0.400		0.000	1.034

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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	-0.075	-0.075				
Z	0.000	0.700	0.699				
TP	RFS		1.407	0.400		0.000	1.007

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.111	-0.111				
Z	0.000	0.740	0.740				
TP	RFS		1.496	0.400		0.000	1.096

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.125	-0.125				
Z	0.000	0.753	0.753				
TP	RFS		1.527	0.400		0.000	1.127

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.109	-0.109				
Z	0.000	0.785	0.785				
TP	RFS		1.585	0.400		0.000	1.185

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.129	-0.129				
Z	0.000	0.772	0.772				
TP	RFS		1.565	0.400		0.000	1.165

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.145	-0.145				
Z	0.000	0.729	0.729				
TP	RFS		1.486	0.400		0.000	1.086

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.101	-0.101				
Z	0.000	0.723	0.723				
TP	RFS		1.459	0.400		0.000	1.059

⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.031	-0.031				
Z	0.000	0.572	0.571				
TP	RFS		1.145	0.400		0.000	0.745

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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	-0.036	-0.036				
Z	0.000	0.561	0.560				
TP	RFS		1.123	0.400		0.000	0.723

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.008	0.008				
Z	0.000	0.390	0.390				
TP	RFS		0.781	0.400		0.000	0.381

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.020	0.020				
Z	0.000	0.369	0.369				
TP	RFS		0.739	0.400		0.000	0.339

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.132	0.132				
Z	0.000	0.119	0.118				
TP	RFS		0.355	0.400		0.000	0.000

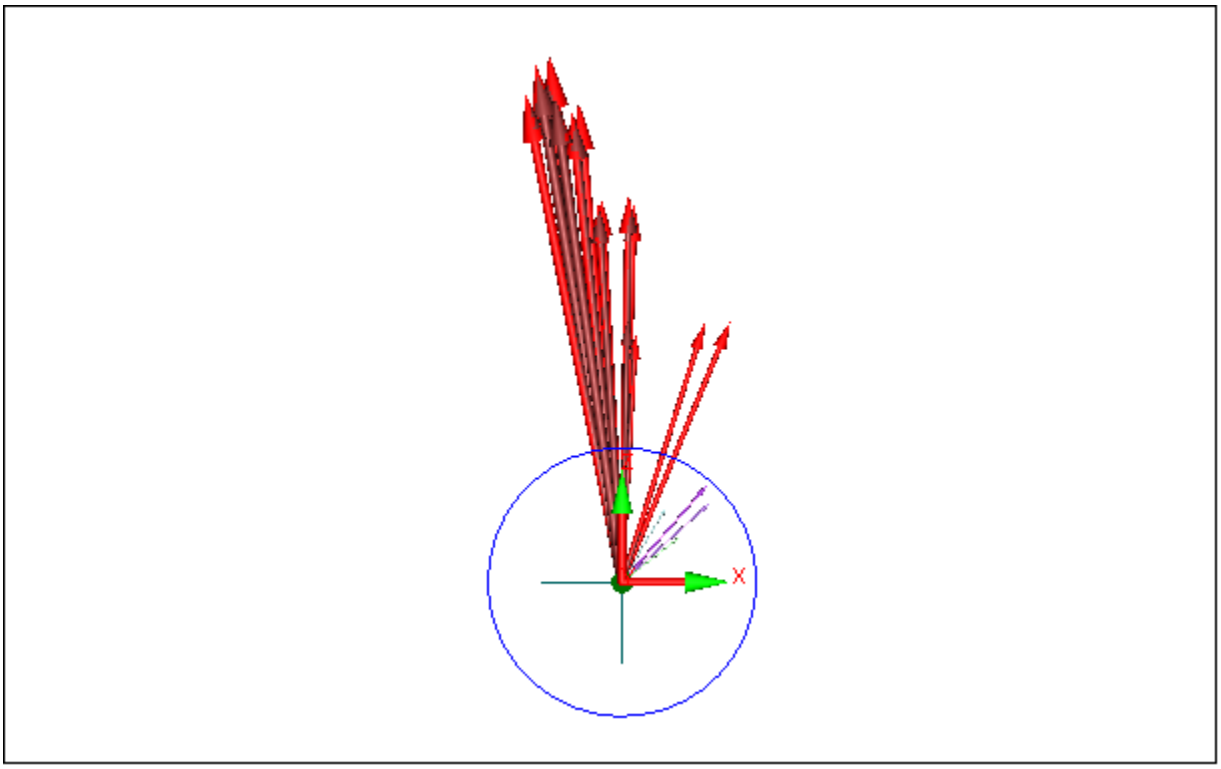
⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.128	0.128				
Z	0.000	0.145	0.145				
TP	RFS		0.386	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.088	0.088				
Z	0.000	0.068	0.068				
TP	RFS		0.222	0.400		0.000	0.000

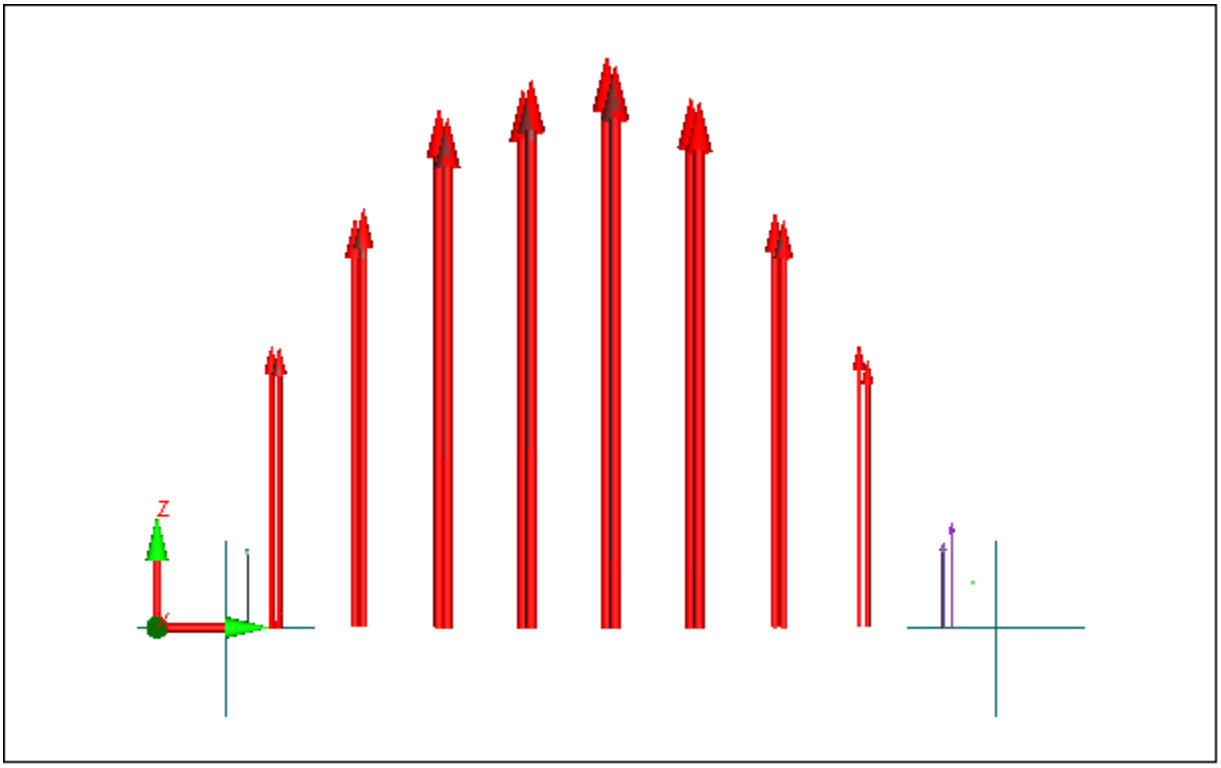
⊕ MM	DIM LOC-TP-CC22= TRUE POSITION OF CIRCLE CRC-DAT-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.000	0.000				
Z	0.000	0.000	0.000				
TP	RFS		0.000	0.400		0.000	0.000

True Position plots from 3 views
x1000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9ACC010 v3 IR DATE=6/24/2008

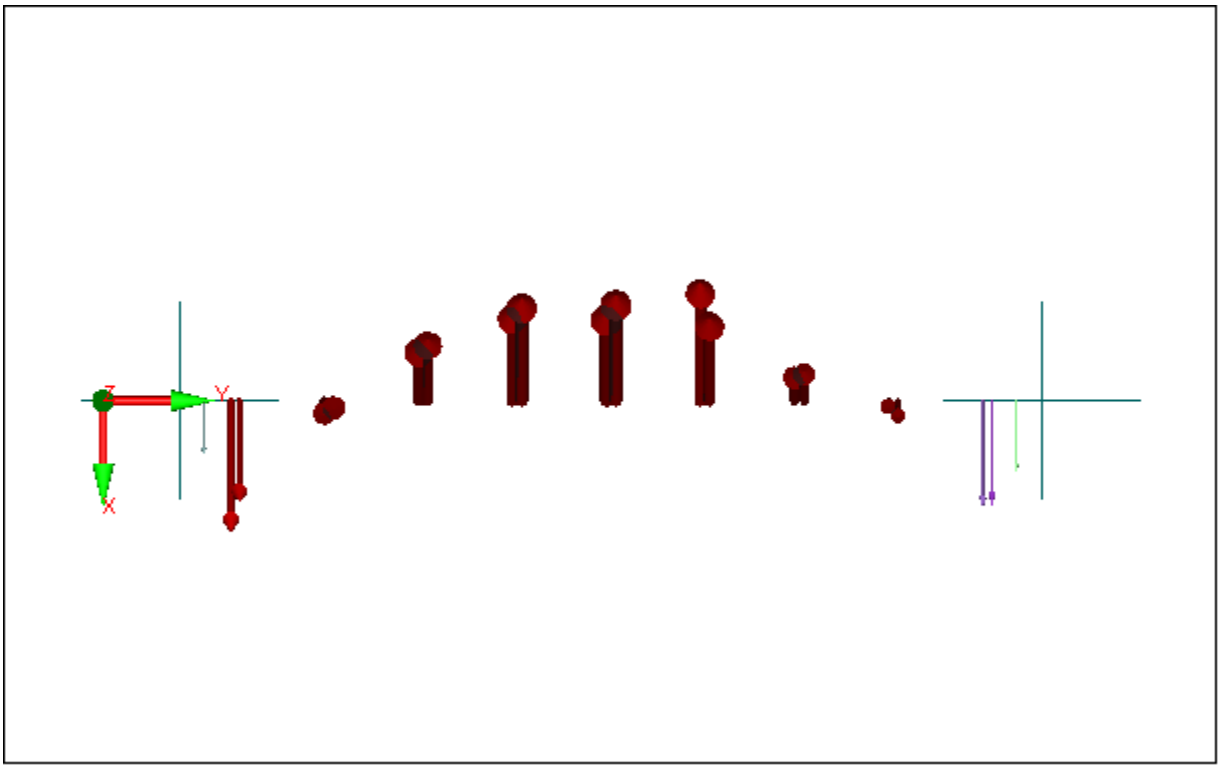


-Y View
x1000



+X View
x1000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9ACC010 v3 IR DATE=6/24/2008



+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	-0.008	-0.008	0.200	0.200	0.000
Y	0.000	621.627	621.627	2000.000	2000.000	0.000
Z	0.000	0.462	0.462	0.200	0.200	0.262
ST	0.000	0.883	0.883	0.200	0.000	0.683

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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	0.017	0.017	0.200	0.200	0.000
Y	0.000	217.789	217.789	2000.000	2000.000	0.000
Z	0.000	0.488	0.488	0.200	0.200	0.288
R	56.500	56.426	-0.074	0.200	0.200	0.000
RN	0.000	0.012	0.012	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-2= LOCATION OF CIRCLE CR-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.064	-0.064	0.200	0.200	0.000
Y	0.000	332.913	332.913	2000.000	2000.000	0.000
Z	0.000	0.586	0.586	0.200	0.200	0.386
R	56.500	56.383	-0.117	0.200	0.200	0.000
RN	0.000	0.024	0.024	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	-0.123	-0.123	0.200	0.200	0.000
Y	0.000	448.242	448.242	2000.000	2000.000	0.000
Z	0.000	0.704	0.704	0.200	0.200	0.504
R	56.500	56.402	-0.098	0.200	0.200	0.000
RN	0.000	0.013	0.013	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	-0.198	-0.198	0.200	0.200	0.000
Y	0.000	563.575	563.575	2000.000	2000.000	0.000
Z	0.000	0.761	0.761	0.200	0.200	0.561
R	56.500	56.333	-0.167	0.200	0.200	0.000
RN	0.000	0.012	0.012	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	-0.164	-0.164	0.200	0.200	0.000
Y	0.000	678.672	678.672	2000.000	2000.000	0.000
Z	0.000	0.678	0.678	0.200	0.200	0.478
R	56.500	56.385	-0.115	0.200	0.200	0.000
RN	0.000	0.007	0.007	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	-0.142	-0.142	0.200	0.200	0.000
Y	0.000	793.872	793.872	2000.000	2000.000	0.000
Z	0.000	0.603	0.603	0.200	0.200	0.403
R	56.500	56.385	-0.115	0.200	0.200	0.000
RN	0.000	0.004	0.004	0.200	0.000	0.000

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MM	DIM LOC-SUPPORT RING-7= LOCATION OF CIRCLE CR-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.023	0.023	0.200	0.200	0.000
Y	0.000	908.776	908.776	2000.000	2000.000	0.000
Z	0.000	0.454	0.454	0.200	0.200	0.254
R	56.500	56.340	-0.160	0.200	0.200	0.000
RN	0.000	0.005	0.005	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-8= LOCATION OF CIRCLE CR-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.004	0.004	0.200	0.200	0.000
Y	0.000	1024.074	1024.074	2000.000	2000.000	0.000
Z	0.000	0.348	0.348	0.200	0.200	0.148
R	56.500	56.373	-0.127	0.200	0.200	0.000
RN	0.000	0.007	0.007	0.200	0.000	0.000

SUPPORT RING POINT LOCATIONS

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	0.488	0.488	0.200	0.200	0.288

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	0.586	0.586	0.200	0.200	0.386

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	0.704	0.704	0.200	0.200	0.504

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	0.761	0.761	0.200	0.200	0.561

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	0.678	0.678	0.200	0.200	0.478

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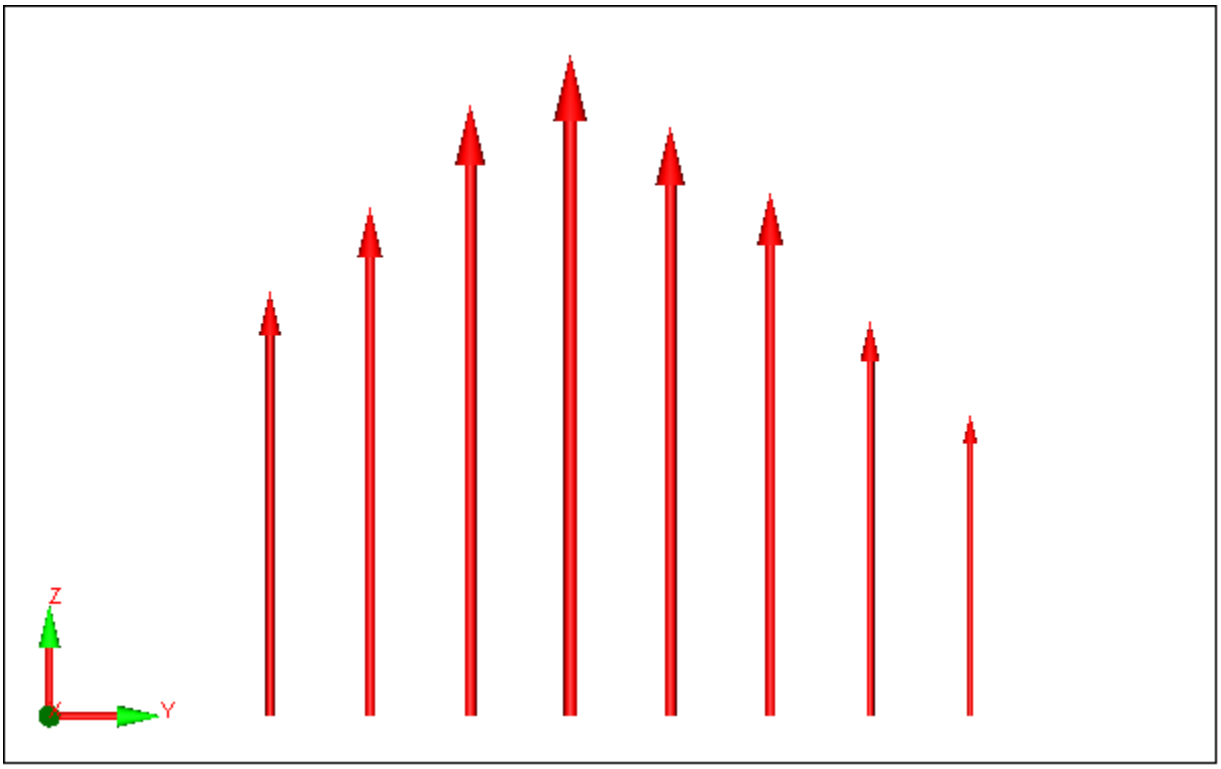
MM	DIM LOC Z SUPPORT RING CIRCLES 6= LOCATION OF CIRCLE CR-SUPPORT-RING-T6					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	0.603	0.603	0.200	0.200	0.403

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	0.454	0.454	0.200	0.200	0.254

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	0.348	0.348	0.200	0.200	0.148



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	-55.923	0.577	0.200	0.200	0.377

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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	-55.791	0.709	0.200	0.200	0.509

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	-55.661	0.839	0.200	0.200	0.639

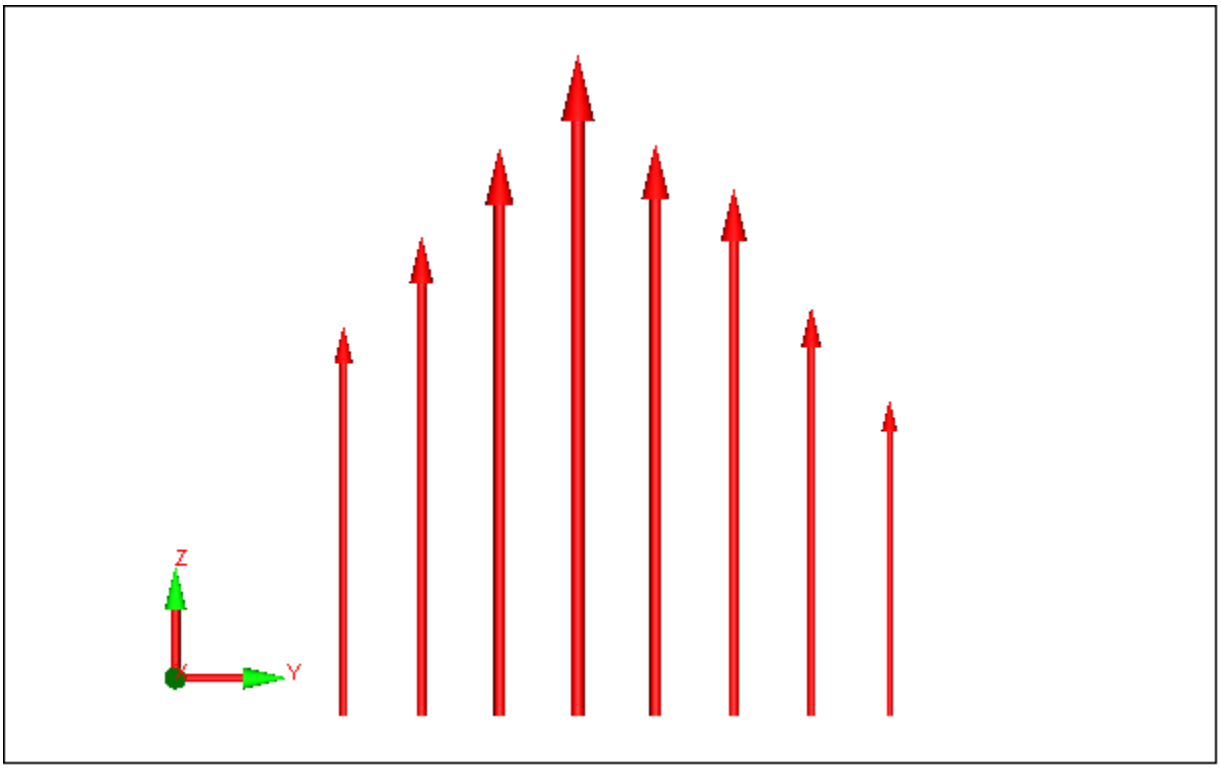
MM	DIM LOC Z SUPPORT RING POINTS 4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	-56.500	-55.524	0.976	0.200	0.200	0.776

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	-55.654	0.846	0.200	0.200	0.646

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	-55.721	0.779	0.200	0.200	0.579

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	-55.895	0.605	0.200	0.200	0.405

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	-56.032	0.468	0.200	0.200	0.268



PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9ACC010 v3 IR DATE=6/24/2008
SUPPORT RING POINTS IN Z
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9ACC010 v3 IR D
WG= SN=
TOTAL # OF MEAS =315 # OUT OF TOL =119