DATE=4/18/2008 TIME=10:06:50 AM
PART NAME : ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004
REV NUMBER :
SER NUMBER :
STATS COUNT : 1

'RF#' : 87897
'Inspected by' : Oscar Lira
'Cavity Number' : TB9ACC012

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	-0.001	-1.000	0.006			
FL	0.000	0.008	0.008	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	0.670	0.670	0.200	0.000	0.470

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.324	0.324	0.100	0.100	0.224

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END -FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.100	-0.100	0.200	0.200	0.000
Z	0.000	0.587	0.587	0.200	0.200	0.387
D	140.000	140.064	0.064	0.300	0.300	0.000
RN	0.000	0.010	0.010	0.200	0.000	0.000

BEAM PIPE FLANGE FAR

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

MM	DIM LOC3= LOCATION OF PLANE PL-FAR-END					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1247.400	1242.934	-4.466	3.000	3.000	1.466
V	0.003	1.000	0.003			
FL	0.000	0.011	0.011	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	0.483	0.483	0.200	0.000	0.283

DEG	DIM ANGL2= 3D ANGLE (COMPLEMENT) FROM PLANE PL-FAR-END TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.227	0.227	0.100	0.100	0.127

MM	DIM LOC4= LOCATION OF CIRCLE CR-FAR-END					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.017	0.017	0.200	0.200	0.000
Z	0.000	0.159	0.159	0.200	0.200	0.000
D	140.000	140.070	0.070	0.300	0.300	0.000
RN	0.000	0.005	0.005	0.200	0.000	0.000

DATUM-1-PLANE

MM	DIM LOC-DATUM-1-PLANE-LE= LOCATION OF PLANE PLC-DAT-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	92.840	92.604	-0.236	0.200	0.200	0.036
V	-0.001	-1.000	0.005			
FL	0.000	0.057	0.057	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	0.589	0.589	0.200	0.000	0.389

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.315	0.315	0.100	0.100	0.215

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	1149.400	-5.160	0.200	0.200	4.960
V	-0.003	1.000	0.002			
FL	0.000	0.014	0.014	0.200	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

// 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	0.315	0.315	0.200	0.000	0.115

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.185	0.185	0.100	0.100	0.085

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	1056.796	-4.264	0.200	0.200	4.064

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	93.534	0.034	0.200	0.200	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

PICKUP ANTENNA FLANGE NW8

MM	DIM LOC5= LOCATION OF PLANE PL-NW8-ANTENNA-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-53.800	-53.960	-0.160	0.200	0.200	0.000
V	-1.000	-0.003	-0.001			
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	0.072	0.072	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	0.159	0.159	0.100	0.100	0.059

MM	DIM LOC6= LOCATION OF CIRCLE CR-NW8-ANTENNA-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.603	0.003	0.200	0.200	0.000
Z	0.000	0.418	0.418	0.200	0.200	0.218
D	33.800	33.843	0.043	0.150	0.000	0.000
RN	0.000	0.015	0.015	0.150	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	87.777	-0.223	0.200	0.200	0.023
V	1.000	-0.003	0.000			
FL	0.000	0.033	0.033	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	0.169	0.169	0.200	0.000	0.000

DEG	DIM ANGL4= 3D ANGLE (TRUE) FROM PLANE PL-NW-40-FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.155	0.155	0.100	0.100	0.055

MM	DIM LOC8= LOCATION OF CIRCLE CR-NW-40-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1182.252	-4.548	0.200	0.200	4.348
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	75.998	-0.002	0.200	0.000	0.002
RN	0.000	0.012	0.012	0.200	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

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	60.682	0.082	0.200	0.200	0.000

HOM-2 FLANGE NW12

MM	DIM FLAT4= FLATNESS OF PLANE PL-NW12-HOM-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.004	0.004	0.200	0.000	0.000

DEG	DIM ANGL5= 2D ANGLE (COMPLEMENT) FROM PLANE PL-NW12-HOM-FLANGE TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	18.095	3.095	0.500	0.500	2.595

DEG	DIM ANGL6= 2D ANGLE (TRUE) FROM PLANE PL-NW12-HOM-FLANGE TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.404	-0.596	0.500	0.500	0.096

MM	DIM LOC9= LOCATION OF CIRCLE CR-NW12-HOM-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-72.001	-71.970	0.031	100.000	100.000	0.000
Y	1315.757	1186.032	-129.725	2000.000	2000.000	0.000
Z	-8.999	-8.520	0.479	100.000	100.000	0.000
D	33.800	33.822	0.022	0.150	0.000	0.000
RN	0.000	0.038	0.038	0.150	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

HOM 1 LOCATION

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	68.590	68.590	100.000	100.000	0.000
Y	60.600	60.202	-0.398	0.200	0.200	0.198
Z	0.000	-39.920	-39.920	100.000	100.000	0.000
D	44.000	43.799	-0.201	0.000	0.100	0.101
RN	0.000	0.154	0.154	0.100	0.000	0.054
V	-0.864	0.005	0.504			

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.267	0.267	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	89.716	-0.284	0.500	0.500	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	60.000	59.733	-0.267	0.500	0.500	0.000

MM DIM LOC-HOM3= LOCATION OF POINT PT-RT-HOM-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.019	0.019	0.200	0.200	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	60.596	-0.004	0.200	0.200	0.000
Z	0.000	0.107	0.107	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	-65.071	-65.071	100.000	100.000	0.000
Y	1186.800	1182.718	-4.082	3.000	3.000	1.082
Z	0.000	-44.586	-44.586	100.000	100.000	0.000
D	44.000	43.876	-0.124	0.000	0.100	0.024
RN	0.000	0.109	0.109	0.100	0.000	0.009
V	-0.829	-0.000	-0.559			

MM DIM DIST2= 2D DISTANCE FROM PLANE PL-FAR-END TO CYLINDER CY-HOM-2 PAR TO YAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	60.600	60.216	-0.384	0.200	0.200	0.184

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

DEG	DIM ANGL12= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	33.977	-1.023	0.500	0.500	0.523

DEG	DIM ANGL13= 3D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	89.985	-0.015	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	56.023	1.023	0.500	0.500	0.523

MM	DIM LOC-HOM4= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.059	0.059	0.200	0.200	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	1182.738	-4.062	3.000	3.000	1.062
Z	0.000	-0.733	-0.733	0.200	0.200	0.533

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

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	95.131	95.131	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.885	-0.115	0.050	0.050	0.065
RN	0.000	0.016	0.016	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	0.027	0.026	0.200	0.200	0.000
Y	0.000	122.155	122.155	2000.000	2000.000	0.000
Z	0.000	-0.154	-0.154	0.200	0.200	0.000
D	200.000	191.262	-8.738	0.200	0.200	8.538
RN	0.000	0.041	0.041	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	-0.035	-0.035	0.200	0.200	0.000
Y	0.000	156.058	156.058	2000.000	2000.000	0.000
Z	0.000	-0.136	-0.136	0.200	0.200	0.000
D	210.300	210.730	0.429	0.200	0.200	0.229
RN	0.000	0.158	0.158	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.025	-0.025	0.200	0.200	0.000
Y	0.000	167.318	167.318	2000.000	2000.000	0.000
Z	0.000	-0.159	-0.159	0.200	0.200	0.000
D	210.300	210.605	0.305	0.200	0.200	0.105
RN	0.000	0.111	0.111	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.038	-0.038	0.200	0.200	0.000
Y	0.000	270.371	270.371	2000.000	2000.000	0.000
Z	0.000	-0.342	-0.342	0.200	0.200	0.142
D	210.300	210.642	0.342	0.200	0.200	0.142
RN	0.000	0.082	0.082	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	-0.074	-0.074	0.200	0.200	0.000
Y	0.000	281.559	281.559	2000.000	2000.000	0.000
Z	0.000	-0.377	-0.377	0.200	0.200	0.177
D	210.300	210.612	0.312	0.200	0.200	0.112
RN	0.000	0.132	0.132	0.200	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.074	-0.074	0.200	0.200	0.000
Y	0.000	385.295	385.295	2000.000	2000.000	0.000
Z	0.000	-0.522	-0.522	0.200	0.200	0.322
D	210.300	210.647	0.347	0.200	0.200	0.147
RN	0.000	0.116	0.116	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	-0.066	-0.067	0.200	0.200	0.000
Y	0.000	397.158	397.158	2000.000	2000.000	0.000
Z	0.000	-0.520	-0.520	0.200	0.200	0.320
D	210.300	210.603	0.303	0.200	0.200	0.103
RN	0.000	0.051	0.051	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.062	-0.063	0.200	0.200	0.000
Y	0.000	500.098	500.098	2000.000	2000.000	0.000
Z	0.000	-0.582	-0.582	0.200	0.200	0.382
D	210.300	210.661	0.361	0.200	0.200	0.161
RN	0.000	0.111	0.111	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	-0.027	-0.028	0.200	0.200	0.000
Y	0.000	511.571	511.571	2000.000	2000.000	0.000
Z	0.000	-0.573	-0.573	0.200	0.200	0.373
D	210.300	210.605	0.305	0.200	0.200	0.105
RN	0.000	0.082	0.082	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	-0.055	-0.055	0.200	0.200	0.000
Y	0.000	615.193	615.193	2000.000	2000.000	0.000
Z	0.000	-0.619	-0.619	0.200	0.200	0.419
D	210.300	210.643	0.343	0.200	0.200	0.143
RN	0.000	0.090	0.090	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	-0.001	-0.001	0.200	0.200	0.000
Y	0.000	627.121	627.121	2000.000	2000.000	0.000
Z	0.000	-0.625	-0.625	0.200	0.200	0.425
D	210.300	210.589	0.288	0.200	0.200	0.088
RN	0.000	0.133	0.133	0.200	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.053	-0.053	0.200	0.200	0.000
Y	0.000	730.349	730.349	2000.000	2000.000	0.000
Z	0.000	-0.621	-0.621	0.200	0.200	0.421
D	210.300	210.660	0.360	0.200	0.200	0.160
RN	0.000	0.034	0.034	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	-0.058	-0.058	0.200	0.200	0.000
Y	0.000	741.992	741.992	2000.000	2000.000	0.000
Z	0.000	-0.634	-0.634	0.200	0.200	0.434
D	210.300	210.637	0.337	0.200	0.200	0.137
RN	0.000	0.069	0.069	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	-0.063	-0.063	0.200	0.200	0.000
Y	0.000	845.696	845.696	2000.000	2000.000	0.000
Z	0.000	-0.509	-0.509	0.200	0.200	0.309
D	210.300	210.663	0.363	0.200	0.200	0.163
RN	0.000	0.170	0.170	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	0.003	0.003	0.200	0.200	0.000
Y	0.000	857.246	857.246	2000.000	2000.000	0.000
Z	0.000	-0.487	-0.488	0.200	0.200	0.288
D	210.300	210.632	0.332	0.200	0.200	0.132
RN	0.000	0.120	0.120	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	0.007	0.007	0.200	0.200	0.000
Y	0.000	960.619	960.619	2000.000	2000.000	0.000
Z	0.000	-0.354	-0.354	0.200	0.200	0.154
D	210.300	210.656	0.355	0.200	0.200	0.155
RN	0.000	0.186	0.186	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	0.027	0.027	0.200	0.200	0.000
Y	0.000	972.046	972.046	2000.000	2000.000	0.000
Z	0.000	-0.343	-0.343	0.200	0.200	0.143
D	210.300	210.539	0.239	0.200	0.200	0.039
RN	0.000	0.218	0.218	0.200	0.000	0.018

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.044	0.044	0.200	0.200	0.000
Y	0.000	1075.229	1075.229	2000.000	2000.000	0.000
Z	0.000	-0.175	-0.176	0.200	0.200	0.000
D	210.300	210.680	0.380	0.200	0.200	0.180
RN	0.000	0.111	0.111	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	0.030	0.030	0.200	0.200	0.000
Y	0.000	1087.233	1087.233	2000.000	2000.000	0.000
Z	0.000	-0.152	-0.152	0.200	0.200	0.000
D	210.300	210.655	0.355	0.200	0.200	0.155
RN	0.000	0.097	0.097	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	1116.705	1116.705	2000.000	2000.000	0.000
Z	0.000	-0.051	-0.051	0.200	0.200	0.000
D	200.000	200.087	0.087	0.200	0.200	0.000
RN	0.000	0.026	0.026	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	1147.479	1147.479	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.933	-0.067	0.050	0.050	0.017
RN	0.000	0.015	0.015	0.050	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

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	0.200		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	0.027	0.026				
Z	0.000	-0.154	-0.154				
TP	RFS		0.313	0.200		0.000	0.113

⊕ MM	DIM LOC-TP-CC3= TRUE POSITION OF CIRCLE CRC-CAV-1-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.035	-0.035				
Z	0.000	-0.136	-0.136				
TP	RFS		0.281	0.200		0.000	0.081

⊕ MM	DIM LOC-TP-CC4= TRUE POSITION OF CIRCLE CRC-CAV-1-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.025	-0.025				
Z	0.000	-0.159	-0.159				
TP	RFS		0.323	0.200		0.000	0.123

⊕ MM	DIM LOC-TP-CC5= TRUE POSITION OF CIRCLE CRC-CAV-2-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.038	-0.038				
Z	0.000	-0.342	-0.342				
TP	RFS		0.688	0.200		0.000	0.488

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.074	-0.074				
Z	0.000	-0.377	-0.377				
TP	RFS		0.768	0.200		0.000	0.568

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.074	-0.074				
Z	0.000	-0.522	-0.522				
TP	RFS		1.055	0.200		0.000	0.855

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

⊕ MM DIM LOC-TP-CC8= TRUE POSITION OF CIRCLE CRC-CAV-3-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.066	-0.067				
Z	0.000	-0.520	-0.520				
TP	RFS		1.049	0.200		0.000	0.849

⊕ MM DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.062	-0.063				
Z	0.000	-0.582	-0.582				
TP	RFS		1.171	0.200		0.000	0.971

⊕ MM DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.027	-0.028				
Z	0.000	-0.573	-0.573				
TP	RFS		1.148	0.200		0.000	0.948

⊕ MM DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.055	-0.055				
Z	0.000	-0.619	-0.619				
TP	RFS		1.243	0.200		0.000	1.043

⊕ MM DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.001	-0.001				
Z	0.000	-0.625	-0.625				
TP	RFS		1.251	0.200		0.000	1.051

⊕ MM DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.053	-0.053				
Z	0.000	-0.621	-0.621				
TP	RFS		1.246	0.200		0.000	1.046

⊕ MM DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.058	-0.058				
Z	0.000	-0.634	-0.634				
TP	RFS		1.273	0.200		0.000	1.073

⊕ MM DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.063	-0.063				
Z	0.000	-0.509	-0.509				
TP	RFS		1.025	0.200		0.000	0.825

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM

⊕ MM	DIM LOC-TP-CC16= TRUE POSITION OF CIRCLE CRC-CAV-7-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.003	0.003				
Z	0.000	-0.487	-0.488				
TP	RFS		0.975	0.200		0.000	0.775

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.007	0.007				
Z	0.000	-0.354	-0.354				
TP	RFS		0.708	0.200		0.000	0.508

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.027	0.027				
Z	0.000	-0.343	-0.343				
TP	RFS		0.689	0.200		0.000	0.489

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.044	0.044				
Z	0.000	-0.175	-0.176				
TP	RFS		0.362	0.200		0.000	0.162

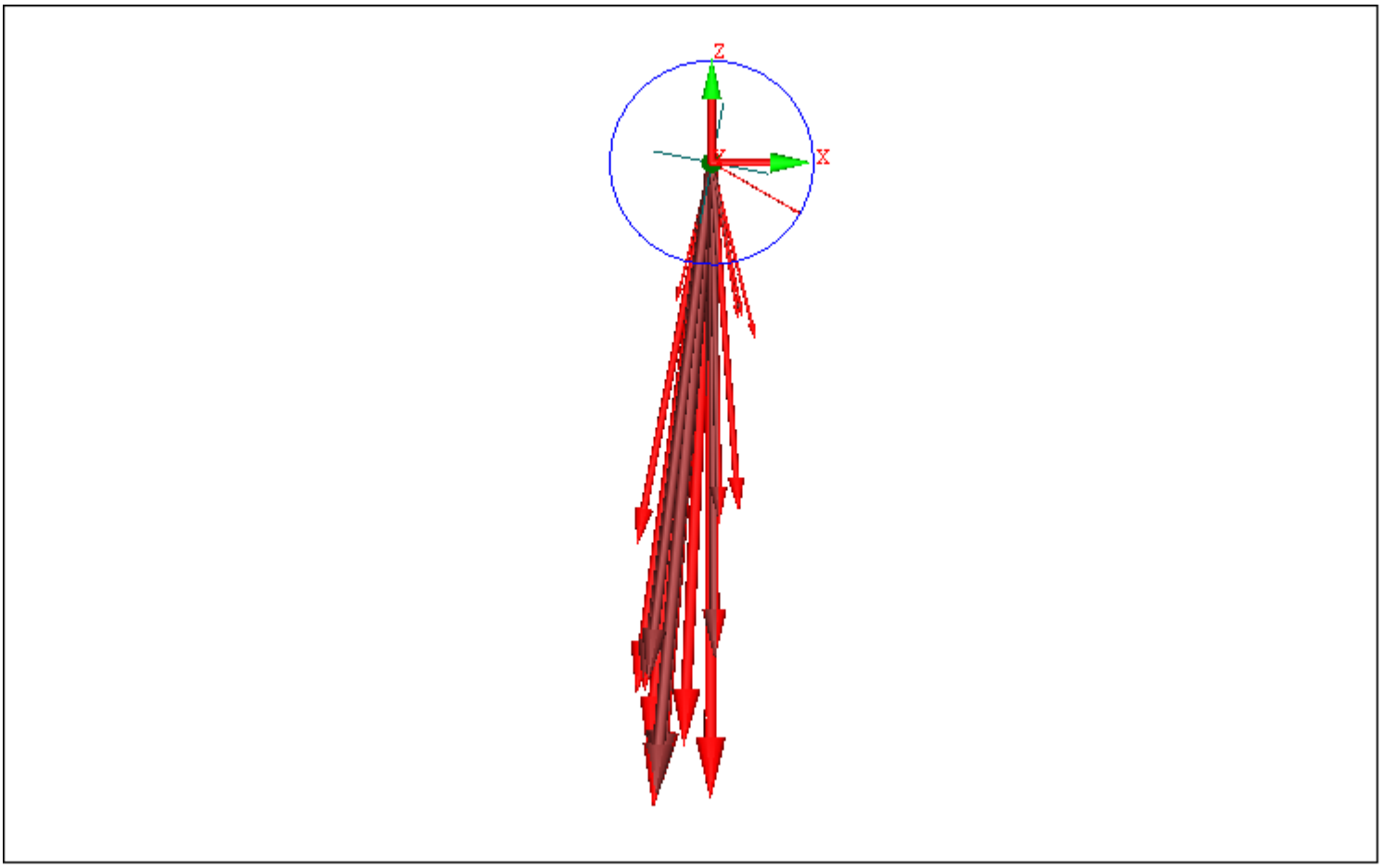
⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.030	0.030				
Z	0.000	-0.152	-0.152				
TP	RFS		0.310	0.200		0.000	0.110

⊕ 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	-0.051	-0.051				
TP	RFS		0.205	0.200		0.000	0.005

⊕ 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	0.200		0.000	0.000

True Position plots from 3 views
x1000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:50 AM



-Y View
x1000

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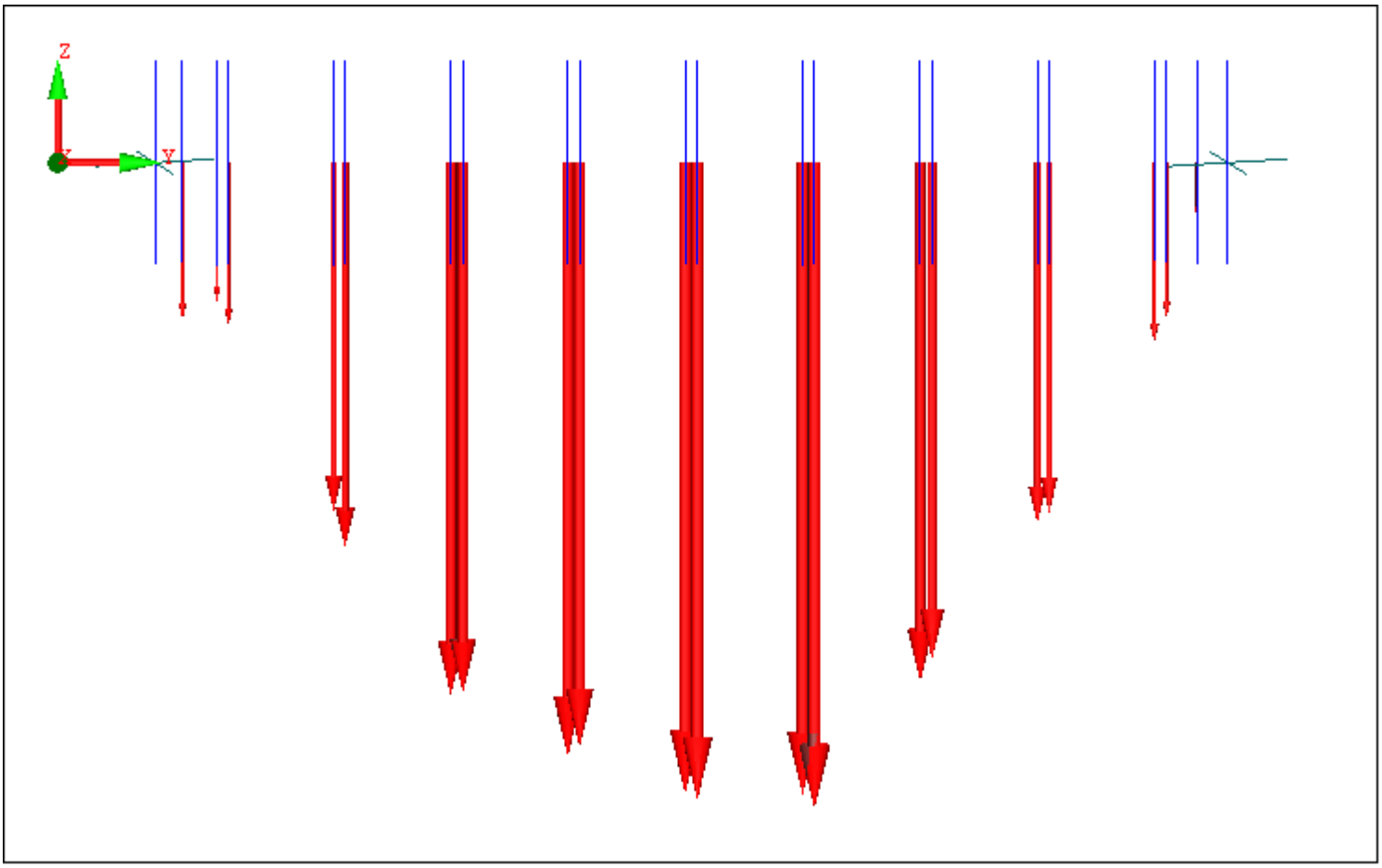

+X View
x1000

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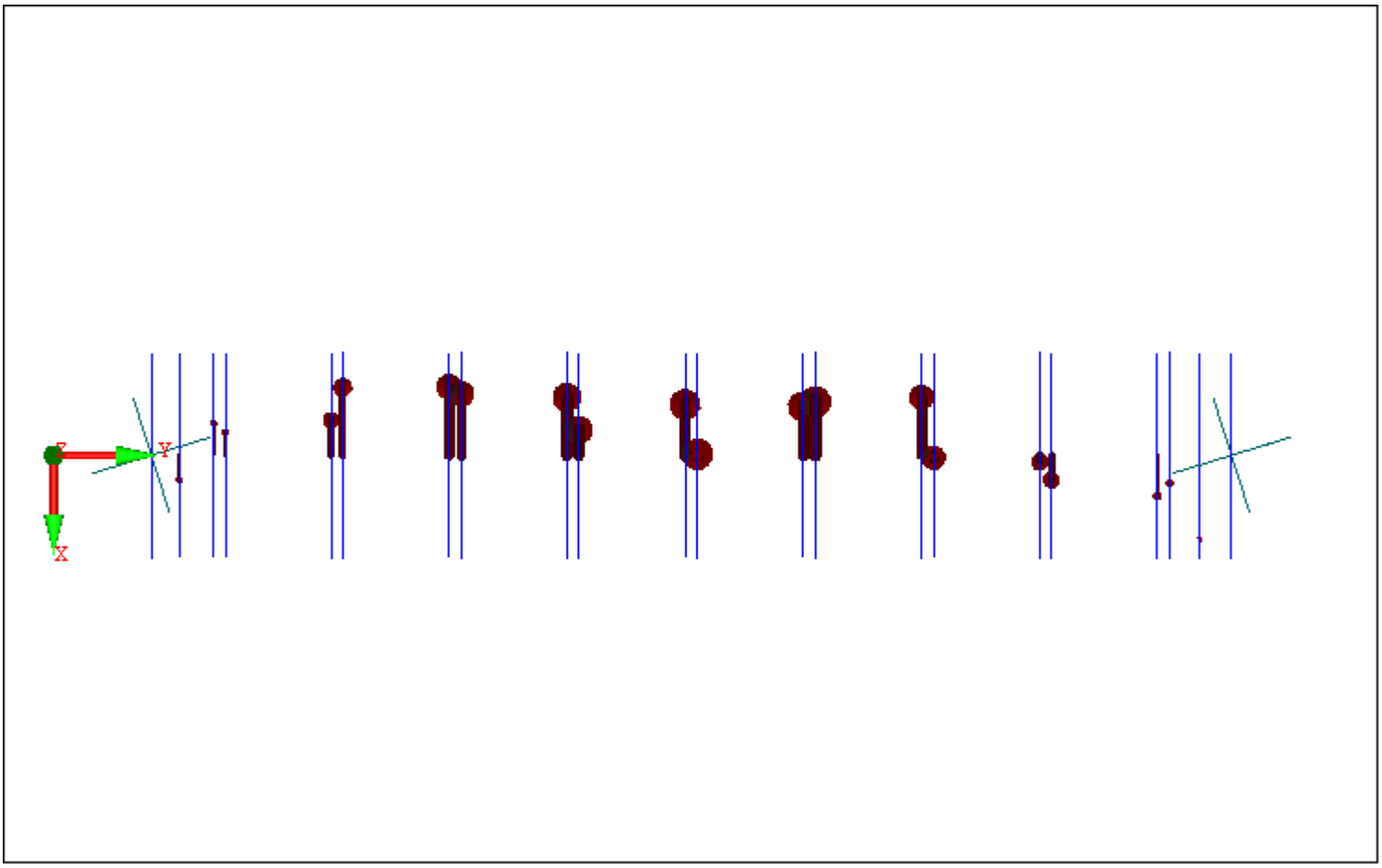


+Z View
x1000

MM	DIM LOC-BEST FIT CONSTRUCTED LINE= LOCATION OF LINE LNC-BEST-FIT					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.018	-0.018	0.200	0.200	0.000
Y	0.000	621.074	621.074	2000.000	2000.000	0.000
Z	0.000	-0.361	-0.361	0.200	0.200	0.161
ST	0.000	0.652	0.652	0.200	0.000	0.452

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	-0.014	-0.014	0.200	0.200	0.000
Y	0.000	221.121	221.121	2000.000	2000.000	0.000
Z	0.000	-0.146	-0.146	0.200	0.200	0.000
R	56.500	56.394	-0.106	0.200	0.200	0.000
RN	0.000	0.002	0.002	0.200	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:51 AM

MM DIM LOC-SUPPORT RING-2= LOCATION OF CIRCLE CR-SUPPORT-RING-T23

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.017	0.016	0.200	0.200	0.000
Y	0.000	336.448	336.448	2000.000	2000.000	0.000
Z	0.000	-0.528	-0.528	0.200	0.200	0.328
R	56.500	56.480	-0.020	0.200	0.200	0.000
RN	0.000	0.006	0.006	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	-0.040	-0.040	0.200	0.200	0.000
Y	0.000	451.781	451.781	2000.000	2000.000	0.000
Z	0.000	-0.458	-0.458	0.200	0.200	0.258
R	56.500	56.406	-0.094	0.200	0.200	0.000
RN	0.000	0.016	0.016	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	-0.125	-0.126	0.200	0.200	0.000
Y	0.000	567.118	567.118	2000.000	2000.000	0.000
Z	0.000	-0.498	-0.498	0.200	0.200	0.298
R	56.500	56.373	-0.127	0.200	0.200	0.000
RN	0.000	0.019	0.019	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	0.064	0.063	0.200	0.200	0.000
Y	0.000	682.222	682.222	2000.000	2000.000	0.000
Z	0.000	-0.483	-0.483	0.200	0.200	0.283
R	56.500	56.387	-0.113	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	-0.114	-0.114	0.200	0.200	0.000
Y	0.000	797.426	797.426	2000.000	2000.000	0.000
Z	0.000	-0.541	-0.541	0.200	0.200	0.341
R	56.500	56.394	-0.106	0.200	0.200	0.000
RN	0.000	0.010	0.010	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	0.070	0.070	0.200	0.200	0.000
Y	0.000	912.815	912.815	2000.000	2000.000	0.000
Z	0.000	-0.384	-0.384	0.200	0.200	0.184
R	56.500	56.416	-0.084	0.200	0.200	0.000
RN	0.000	0.015	0.015	0.200	0.000	0.000

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:51 AM

MM	DIM LOC-SUPPORT RING-8= LOCATION OF CIRCLE CR-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.067	0.067	0.200	0.200	0.000
Y	0.000	1028.122	1028.122	2000.000	2000.000	0.000
Z	0.000	-0.319	-0.320	0.200	0.200	0.120
R	56.500	56.407	-0.093	0.200	0.200	0.000
RN	0.000	0.020	0.020	0.200	0.000	0.000

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	0.107	0.107	0.200	0.200	0.000
Y	0.000	215.222	215.222	2000.000	2000.000	0.000
Z	56.500	56.277	-0.223	0.200	0.200	0.023

MM	DIM LOC-SUPPORT RING-PT2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.111	0.111	0.200	0.200	0.000
Y	0.000	330.552	330.552	2000.000	2000.000	0.000
Z	56.500	55.941	-0.559	0.200	0.200	0.359

MM	DIM LOC-SUPPORT RING-PT3= LOCATION OF POINT PT-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.114	0.114	0.200	0.200	0.000
Y	0.000	444.884	444.884	2000.000	2000.000	0.000
Z	56.500	55.933	-0.567	0.200	0.200	0.367

MM	DIM LOC-SUPPORT RING-PT4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.115	0.115	0.200	0.200	0.000
Y	0.000	560.215	560.215	2000.000	2000.000	0.000
Z	56.500	55.817	-0.683	0.200	0.200	0.483

MM	DIM LOC-SUPPORT RING-PT5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.110	0.110	0.200	0.200	0.000
Y	0.000	675.227	675.227	2000.000	2000.000	0.000
Z	56.500	55.911	-0.589	0.200	0.200	0.389

MM	DIM LOC-SUPPORT RING-PT6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.114	0.114	0.200	0.200	0.000
Y	0.000	790.520	790.520	2000.000	2000.000	0.000
Z	56.500	55.843	-0.657	0.200	0.200	0.457

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:51 AM

MM	DIM LOC-SUPPORT RING-PT7= LOCATION OF POINT PT-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.114	0.114	0.200	0.200	0.000
Y	0.000	905.823	905.823	2000.000	2000.000	0.000
Z	56.500	55.987	-0.513	0.200	0.200	0.313

MM	DIM LOC-SUPPORT RING-PT8= LOCATION OF POINT PT-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.114	0.114	0.200	0.200	0.000
Y	0.000	1021.222	1021.222	2000.000	2000.000	0.000
Z	56.500	56.058	-0.442	0.200	0.200	0.242

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	-0.146	-0.146	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	-0.528	-0.528	0.200	0.200	0.328

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	-0.458	-0.458	0.200	0.200	0.258

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	-0.498	-0.498	0.200	0.200	0.298

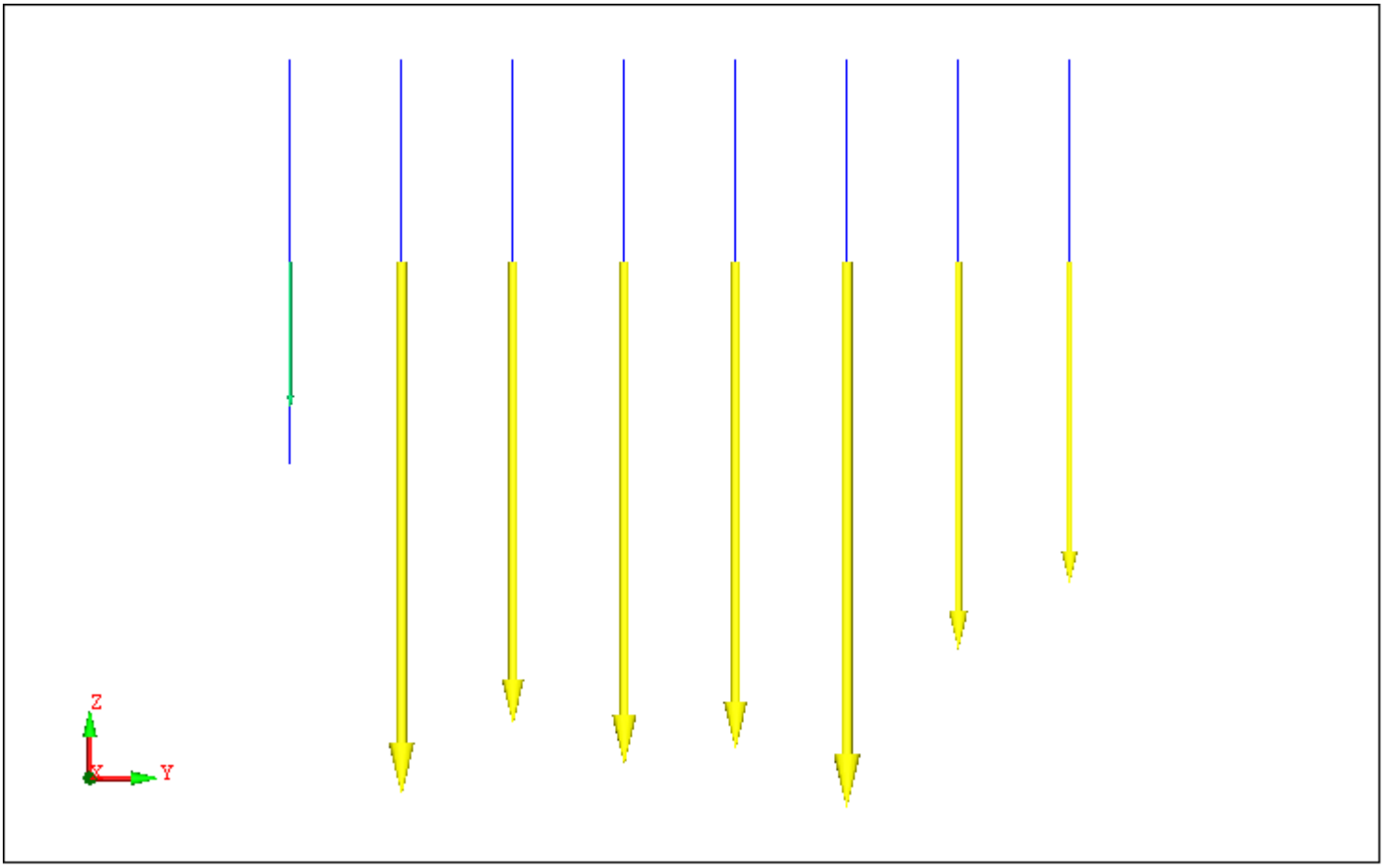
MM	DIM LOC Z SUPPORT RING CIRCLES 5= LOCATION OF CIRCLE CR-SUPPORT-RING-T5					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.483	-0.483	0.200	0.200	0.283

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	-0.541	-0.541	0.200	0.200	0.341

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	-0.384	-0.384	0.200	0.200	0.184

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:51 AM

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	-0.319	-0.320	0.200	0.200	0.120



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	56.277	-0.223	0.200	0.200	0.023

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	55.941	-0.559	0.200	0.200	0.359

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:51 AM

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	55.933	-0.567	0.200	0.200	0.367

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	55.817	-0.683	0.200	0.200	0.483

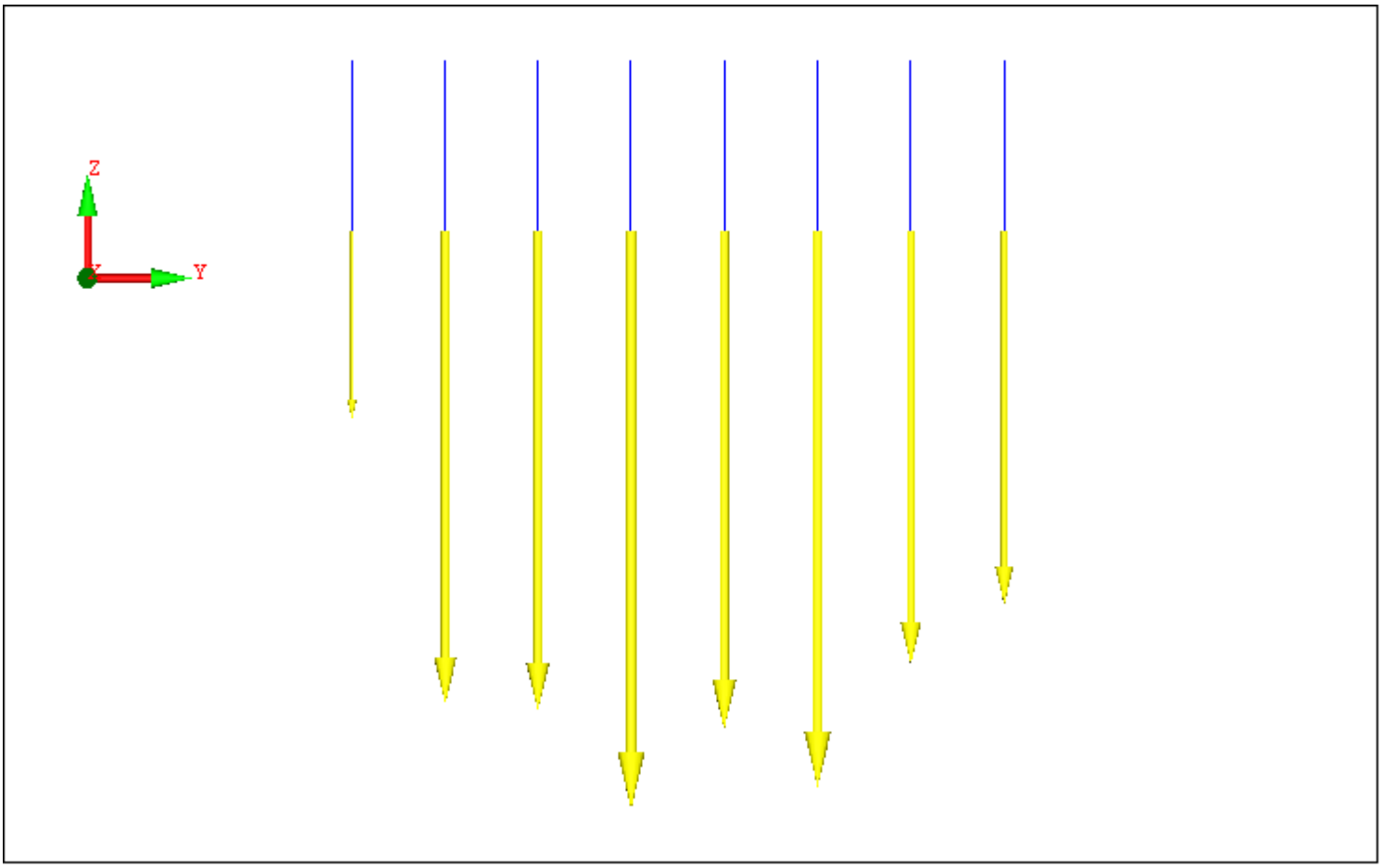
MM	DIM LOC Z SUPPORT RING POINTS 5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.911	-0.589	0.200	0.200	0.389

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	55.843	-0.657	0.200	0.200	0.457

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	55.987	-0.513	0.200	0.200	0.313

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	56.058	-0.442	0.200	0.200	0.242

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:51 AM



SUPPORT RING POINTS IN Z
x1000

DEG	DIM ANGL15= 2D ANGLE (TRUE) FROM LINE LNC-FOR 180 OFFSET TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.00000	15.21165	0.21165	0.50000	0.50000	0.00000

MM	DIM LOC Z SUPPORT RING POINTS 9= LOCATION OF LINE LNC-FOR 180 OFFSET					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	0.26239	0.00000	0.96496			

(9) ANGLE I: 0.2631146 - 15.25495207
ANGLE K: 0.9647646
(7) ANGLE I: 0.2588121 - 14.99958804
ANGLE K: 0.9659277
(6) ANGLE I: 0.2439225 - 14.11816578
ANGLE K: 0.9697947

PART NUMBER=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DATE=4/18/2008 TIME=10:06:51 AM

END OF MEASUREMENT FOR
PN=ILC DESY 1.3GHZ RF CAVITY ASSEMBLY 440004 DWG= SN=
TOTAL # OF MEAS =293 # OUT OF TOL =120 # OF HOURS =00:00:09