FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=6/25/2008 TIME=10:56:07 AM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC013 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-TB9ACC013
' ' : 0806250858

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	0.005			
FL	0.000	0.018	0.018	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	0.638	0.638	0.200	0.000	0.438

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.313	0.313	0.100	0.100	0.213

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.144	-0.144	0.200	0.200	0.000
Z	0.000	0.616	0.616	0.200	0.200	0.416
D	140.000	140.081	0.081	0.300	0.300	0.000
RN	0.000	0.003	0.003	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	1.081	0.081	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	59.945	-0.055				
PA	15.000	15.395	0.395				
DF	8.800	8.837	0.037	0.300	0.300		0.000
TP	RFS		0.835	0.300		0.000	0.535
RN	0.000	0.015	0.015	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	59.933	-0.067				
PA	45.000	45.367	0.367				
DF	8.800	8.828	0.028	0.300	0.300		0.000
TP	RFS		0.780	0.300		0.000	0.480
RN	0.000	0.017	0.017	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	59.953	-0.047				
PA	75.000	75.377	0.377				
DF	8.800	8.837	0.037	0.300	0.300		0.000
TP	RFS		0.796	0.300		0.000	0.496
RN	0.000	0.021	0.021	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	59.924	-0.076				
PA	105.000	105.367	0.367				
DF	8.800	8.820	0.020	0.300	0.300		0.000
TP	RFS		0.784	0.300		0.000	0.484
RN	0.000	0.025	0.025	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	59.946	-0.054				
PA	135.000	135.369	0.369				
DF	8.800	8.831	0.031	0.300	0.300		0.000
TP	RFS		0.779	0.300		0.000	0.479
RN	0.000	0.015	0.015	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	59.941	-0.059				
PA	165.000	165.374	0.374				
DF	8.800	8.835	0.035	0.300	0.300		0.000
TP	RFS		0.792	0.300		0.000	0.492
RN	0.000	0.011	0.011	0.300	0.000		0.000

BEAM PIPE FLANGE FAR

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1247.400	1243.750	-3.650	3.000	3.000	0.650
V	0.002	1.000	0.003			
FL	0.000	0.024	0.024	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	0.505	0.505	0.200	0.000	0.305

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.235	0.235	0.100	0.100	0.135

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.019	0.018	0.200	0.200	0.000
Z	0.000	0.210	0.210	0.200	0.200	0.010
D	140.000	140.076	0.076	0.300	0.300	0.000
RN	0.000	0.004	0.004	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	1.092	0.092	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	59.975	-0.025				
PA	15.000	14.983	-0.017				
DF	8.800	8.821	0.021	0.300	0.300		0.000
TP	RFS		0.062	0.300		0.000	0.000
RN	0.000	0.011	0.011	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	59.943	-0.057				
PA	45.000	45.021	0.021				
DF	8.800	8.833	0.033	0.300	0.300		0.000
TP	RFS		0.123	0.300		0.000	0.000
RN	0.000	0.019	0.019	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	59.966	-0.034				
PA	75.000	74.991	-0.009				
DF	8.800	8.847	0.047	0.300	0.300		0.000
TP	RFS		0.070	0.300		0.000	0.000
RN	0.000	0.025	0.025	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	59.976	-0.024				
PA	105.000	104.990	-0.010				
DF	8.800	8.822	0.022	0.300	0.300		0.000
TP	RFS		0.053	0.300		0.000	0.000
RN	0.000	0.022	0.022	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	59.963	-0.037				
PA	135.000	135.021	0.021				
DF	8.800	8.828	0.028	0.300	0.300		0.000
TP	RFS		0.087	0.300		0.000	0.000
RN	0.000	0.023	0.023	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	59.965	-0.035				
PA	165.000	165.035	0.035				
DF	8.800	8.851	0.051	0.300	0.300		0.000
TP	RFS		0.103	0.300		0.000	0.000
RN	0.000	0.026	0.026	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	93.098	0.258	0.200	0.200	0.058
V	-0.002	-1.000	0.005			
FL	0.000	0.038	0.038	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	0.555	0.555	0.200	0.000	0.355

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.316	0.316	0.100	0.100	0.216

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	1150.155	-4.405	0.200	0.200	4.205
V	-0.003	1.000	0.003			
FL	0.000	0.019	0.019	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	0.422	0.422	0.200	0.000	0.222

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.249	0.249	0.100	0.100	0.149

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	1057.057	-4.003	0.200	0.200	3.803

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	-53.872	-0.072	0.200	0.200	0.000
V	-1.000	-0.002	-0.002			
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	0.060	0.060	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	0.123	0.123	0.100	0.100	0.023

MM	DIM LOC6= LOCATION OF CIRCLE CR_NW8_ANTENNA_FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.686	0.086	0.200	0.200	0.000
Z	0.000	0.464	0.464	0.200	0.200	0.264
D	33.800	33.839	0.039	0.150	0.000	0.000
RN	0.000	0.020	0.020	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	0.521	0.021	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	87.698	-0.302	0.200	0.200	0.102
V	1.000	-0.001	-0.001			
FL	0.000	0.029	0.029	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	0.126	0.126	0.200	0.000	0.000

DEG	DIM ANGL4= 3D ANGLE (COMPLEMENT) FROM PLANE PL NW 40 FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.093	0.093	0.100	0.100	0.000

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MM DIM LOC8= LOCATION OF CIRCLE CR_NW_40_FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1183.401	-3.399	0.200	0.200	3.199
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	75.993	-0.007	0.200	0.000	0.007
RN	0.000	0.011	0.011	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	60.349	-0.251	0.200	0.200	0.051

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	0.622	0.122	0.050	0.000	0.072

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	31.706	-0.044				
PA	112.500	112.201	-0.299				
DF	6.700	6.811	0.111	0.200	0.200		0.000
TP	RFS		0.342	0.300		0.000	0.042
RN	0.000	0.080	0.080	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	0.009	0.009	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.548	0.265	0.793			

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.648	-0.352	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	-72.231	-72.231	100.000	100.000	0.000
Y	0.000	1186.534	1186.534	2000.000	2000.000	0.000
Z	0.000	-8.443	-8.443	100.000	100.000	0.000
D	33.800	33.892	0.092	0.150	0.000	0.000
RN	0.000	0.167	0.167	0.150	0.000	0.017

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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	28.536	0.116	0.100	0.100	0.016

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	28.539	0.119	0.100	0.100	0.019

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	0.514	0.014	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	15.284	0.284	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	68.918	68.918	100.000	100.000	0.000
Y	60.600	60.310	-0.290	0.200	0.200	0.090
Z	0.000	-40.063	-40.063	100.000	100.000	0.000
D	44.000	43.851	-0.149	0.000	0.100	0.049
RN	0.000	0.139	0.139	0.100	0.000	0.039
V	-0.864	0.002	0.503			

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.210	0.210	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	89.874	-0.126	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	59.790	-0.210	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	115.913	-0.087	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	110.848	-0.152	0.200	0.200	0.000
FL	0.000	0.007	0.007	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	60.485	-0.115	0.200	0.200	0.000
Z	0.000	0.065	0.065	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	-64.916	-64.916	100.000	100.000	0.000
Y	1186.800	1183.087	-3.713	3.000	3.000	0.713
Z	0.000	-44.949	-44.949	100.000	100.000	0.000
D	44.000	43.824	-0.176	0.000	0.100	0.076
RN	0.000	0.089	0.089	0.100	0.000	0.000
V	-0.826	0.003	-0.564			

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	60.663	0.063	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	34.325	-0.675	0.500	0.500	0.175

DEG	DIM ANGL13= 3D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	90.146	0.146	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	55.675	0.675	0.500	0.500	0.175

MM	DIM HOM2 POINT= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.082	0.082	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	111.055	0.055	0.200	0.200	0.000
FL	0.000	0.019	0.019	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	1182.887	-3.913	3.000	3.000	0.913
Z	0.000	-0.625	-0.625	0.200	0.200	0.425

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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	94.947	94.947	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.923	-0.077	0.050	0.050	0.027
RN	0.000	0.010	0.010	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	123.080	123.080	2000.000	2000.000	0.000
Z	0.000	-0.139	-0.139	0.200	0.200	0.000
D	191.200	191.260	0.060	0.200	0.200	0.000
RN	0.000	0.046	0.046	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	0.115	0.115	0.200	0.200	0.000
Y	0.000	156.134	156.134	2000.000	2000.000	0.000
Z	0.000	-0.061	-0.061	0.200	0.200	0.000
D	210.300	210.707	0.407	0.200	0.200	0.207
RN	0.000	0.059	0.059	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	0.120	0.120	0.200	0.200	0.000
Y	0.000	167.398	167.398	2000.000	2000.000	0.000
Z	0.000	-0.092	-0.092	0.200	0.200	0.000
D	210.300	210.571	0.271	0.200	0.200	0.071
RN	0.000	0.060	0.060	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	0.177	0.177	0.200	0.200	0.000
Y	0.000	270.482	270.482	2000.000	2000.000	0.000
Z	0.000	-0.301	-0.301	0.200	0.200	0.101
D	210.300	210.630	0.330	0.200	0.200	0.130
RN	0.000	0.222	0.222	0.200	0.000	0.022

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.192	0.192	0.200	0.200	0.000
Y	0.000	282.389	282.389	2000.000	2000.000	0.000
Z	0.000	-0.310	-0.310	0.200	0.200	0.110
D	210.300	210.544	0.244	0.200	0.200	0.044
RN	0.000	0.162	0.162	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	0.170	0.170	0.200	0.200	0.000
Y	0.000	385.863	385.863	2000.000	2000.000	0.000
Z	0.000	-0.460	-0.460	0.200	0.200	0.260
D	210.300	210.655	0.355	0.200	0.200	0.155
RN	0.000	0.162	0.162	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	0.189	0.189	0.200	0.200	0.000
Y	0.000	397.864	397.864	2000.000	2000.000	0.000
Z	0.000	-0.506	-0.506	0.200	0.200	0.306
D	210.300	210.564	0.264	0.200	0.200	0.064
RN	0.000	0.185	0.185	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	0.234	0.234	0.200	0.200	0.034
Y	0.000	500.815	500.815	2000.000	2000.000	0.000
Z	0.000	-0.586	-0.586	0.200	0.200	0.386
D	210.300	210.676	0.376	0.200	0.200	0.176
RN	0.000	0.139	0.139	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	0.243	0.243	0.200	0.200	0.043
Y	0.000	512.110	512.110	2000.000	2000.000	0.000
Z	0.000	-0.615	-0.615	0.200	0.200	0.415
D	210.300	210.562	0.262	0.200	0.200	0.062
RN	0.000	0.194	0.194	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	0.297	0.297	0.200	0.200	0.097
Y	0.000	616.055	616.055	2000.000	2000.000	0.000
Z	0.000	-0.719	-0.719	0.200	0.200	0.519
D	210.300	210.620	0.320	0.200	0.200	0.120
RN	0.000	0.161	0.161	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	0.315	0.315	0.200	0.200	0.115
Y	0.000	627.264	627.264	2000.000	2000.000	0.000
Z	0.000	-0.708	-0.708	0.200	0.200	0.508
D	210.300	210.582	0.282	0.200	0.200	0.082
RN	0.000	0.162	0.162	0.200	0.000	0.000

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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	0.361	0.361	0.200	0.200	0.161
Y	0.000	731.037	731.037	2000.000	2000.000	0.000
Z	0.000	-0.688	-0.688	0.200	0.200	0.488
D	210.300	210.645	0.345	0.200	0.200	0.145
RN	0.000	0.229	0.229	0.200	0.000	0.029

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.382	0.382	0.200	0.200	0.182
Y	0.000	742.789	742.789	2000.000	2000.000	0.000
Z	0.000	-0.690	-0.690	0.200	0.200	0.490
D	210.300	210.508	0.208	0.200	0.200	0.008
RN	0.000	0.161	0.161	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	0.377	0.377	0.200	0.200	0.177
Y	0.000	846.644	846.644	2000.000	2000.000	0.000
Z	0.000	-0.641	-0.642	0.200	0.200	0.442
D	210.300	210.611	0.310	0.200	0.200	0.110
RN	0.000	0.288	0.288	0.200	0.000	0.088

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.365	0.365	0.200	0.200	0.165
Y	0.000	858.181	858.181	2000.000	2000.000	0.000
Z	0.000	-0.568	-0.568	0.200	0.200	0.368
D	210.300	210.602	0.302	0.200	0.200	0.102
RN	0.000	0.247	0.247	0.200	0.000	0.047

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.294	0.294	0.200	0.200	0.094
Y	0.000	961.353	961.353	2000.000	2000.000	0.000
Z	0.000	-0.414	-0.414	0.200	0.200	0.214
D	210.300	210.652	0.352	0.200	0.200	0.152
RN	0.000	0.195	0.195	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	0.210	0.210	0.200	0.200	0.010
Y	0.000	972.380	972.380	2000.000	2000.000	0.000
Z	0.000	-0.404	-0.404	0.200	0.200	0.204
D	210.300	210.565	0.265	0.200	0.200	0.065
RN	0.000	0.208	0.208	0.200	0.000	0.008

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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	0.191	0.191	0.200	0.200	0.000
Y	0.000	1076.051	1076.051	2000.000	2000.000	0.000
Z	0.000	-0.188	-0.188	0.200	0.200	0.000
D	210.300	210.643	0.343	0.200	0.200	0.143
RN	0.000	0.112	0.112	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	0.151	0.151	0.200	0.200	0.000
Y	0.000	1087.786	1087.786	2000.000	2000.000	0.000
Z	0.000	-0.161	-0.161	0.200	0.200	0.000
D	210.300	210.621	0.321	0.200	0.200	0.121
RN	0.000	0.143	0.143	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	0.116	0.116	0.200	0.200	0.000
Y	0.000	1117.480	1117.480	2000.000	2000.000	0.000
Z	0.000	-0.086	-0.087	0.200	0.200	0.000
D	200.000	200.093	0.093	0.200	0.200	0.000
RN	0.000	0.036	0.036	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	1148.235	1148.235	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	0.020	0.020	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	-0.139	-0.139				
TP	RFS		0.308	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	0.115	0.115				
Z	0.000	-0.061	-0.061				
TP	RFS		0.260	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	0.120	0.120				
Z	0.000	-0.092	-0.092				
TP	RFS		0.302	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	0.177	0.177				
Z	0.000	-0.301	-0.301				
TP	RFS		0.699	0.400		0.000	0.299

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.192	0.192				
Z	0.000	-0.310	-0.310				
TP	RFS		0.730	0.400		0.000	0.330

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.170	0.170				
Z	0.000	-0.460	-0.460				
TP	RFS		0.981	0.400		0.000	0.581

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.189	0.189				
Z	0.000	-0.506	-0.506				
TP	RFS		1.081	0.400		0.000	0.681

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.234	0.234				
Z	0.000	-0.586	-0.586				
TP	RFS		1.263	0.400		0.000	0.863

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.243	0.243				
Z	0.000	-0.615	-0.615				
TP	RFS		1.322	0.400		0.000	0.922

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.297	0.297				
Z	0.000	-0.719	-0.719				
TP	RFS		1.555	0.400		0.000	1.155

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.315	0.315				
Z	0.000	-0.708	-0.708				
TP	RFS		1.550	0.400		0.000	1.150

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.361	0.361				
Z	0.000	-0.688	-0.688				
TP	RFS		1.553	0.400		0.000	1.153

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.382	0.382				
Z	0.000	-0.690	-0.690				
TP	RFS		1.577	0.400		0.000	1.177

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.377	0.377				
Z	0.000	-0.641	-0.642				
TP	RFS		1.488	0.400		0.000	1.088

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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	0.365	0.365				
Z	0.000	-0.568	-0.568				
TP	RFS		1.350	0.400		0.000	0.950

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.294	0.294				
Z	0.000	-0.414	-0.414				
TP	RFS		1.016	0.400		0.000	0.616

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.210	0.210				
Z	0.000	-0.404	-0.404				
TP	RFS		0.911	0.400		0.000	0.511

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.191	0.191				
Z	0.000	-0.188	-0.188				
TP	RFS		0.537	0.400		0.000	0.137

⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.151	0.151				
Z	0.000	-0.161	-0.161				
TP	RFS		0.442	0.400		0.000	0.042

⊕ MM	DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.116	0.116				
Z	0.000	-0.086	-0.087				
TP	RFS		0.289	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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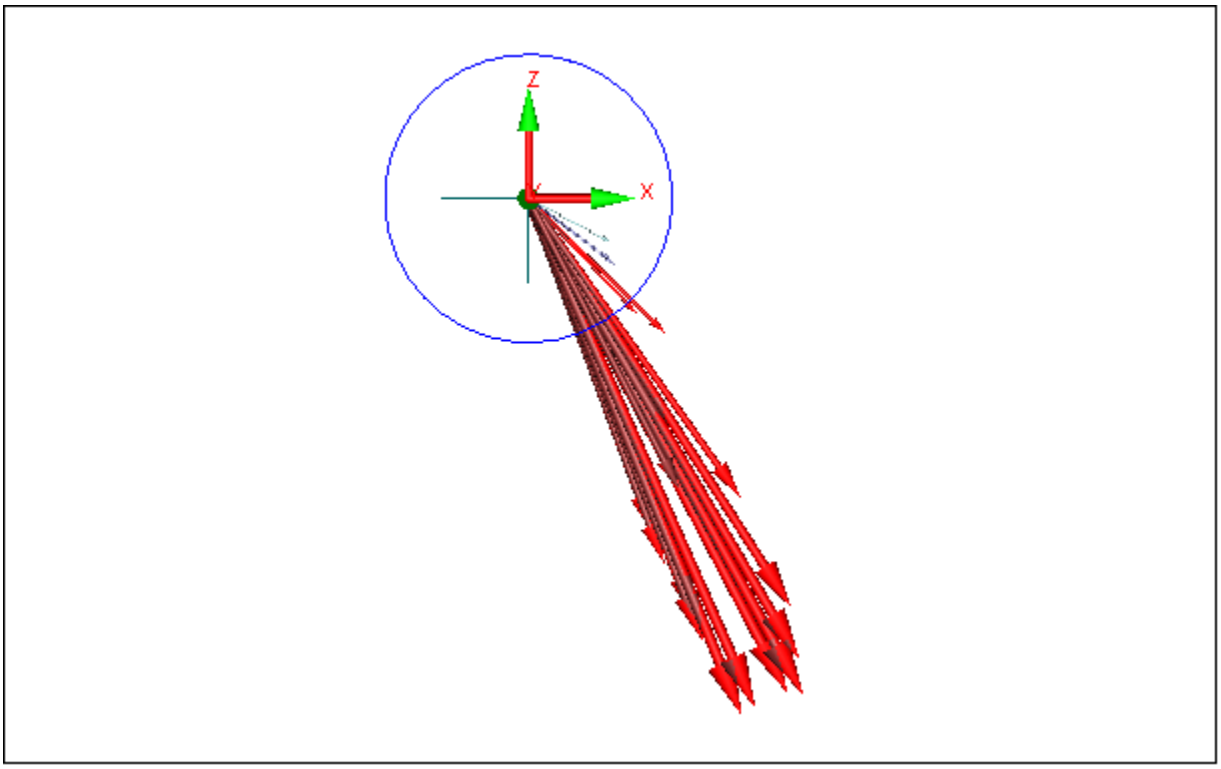
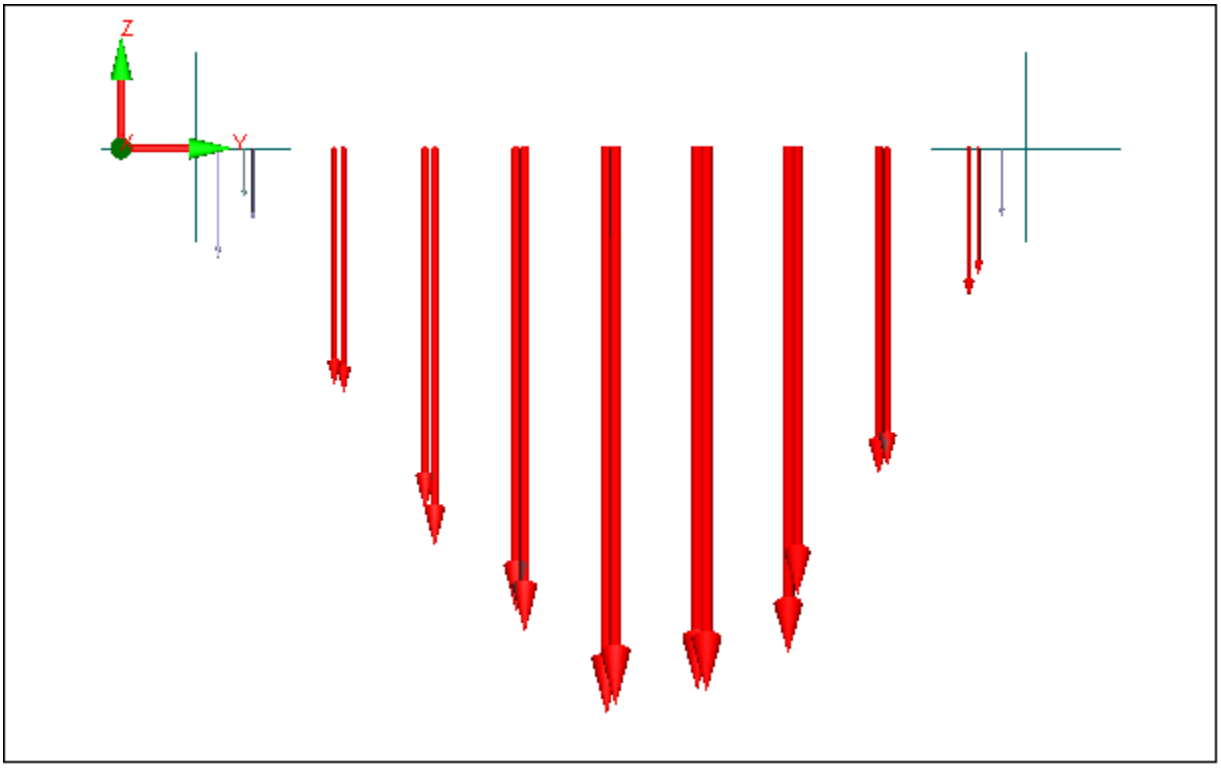
True Position plots from 3 views
x1000



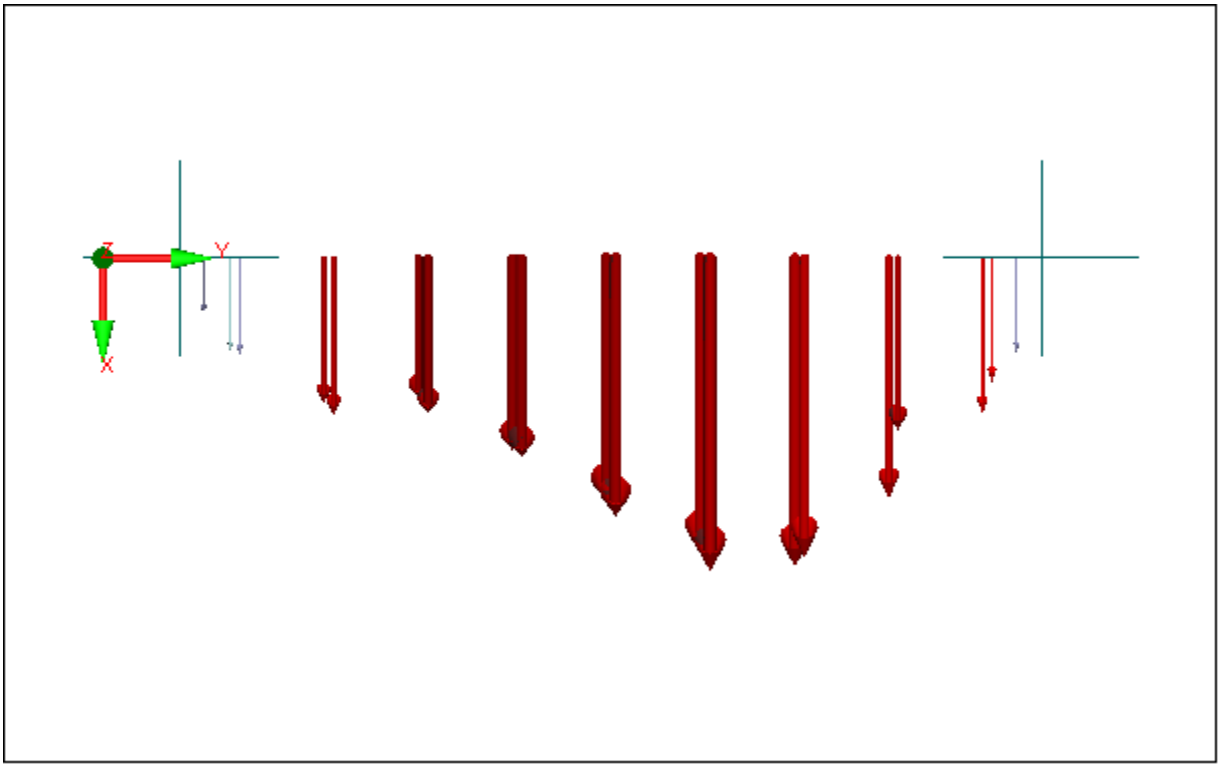
-Y View
x1000



PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC013 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	0.208	0.207	0.200	0.200	0.007
Y	0.000	621.652	621.652	2000.000	2000.000	0.000
Z	0.000	-0.379	-0.379	0.200	0.200	0.179
ST	0.000	0.836	0.836	0.200	0.000	0.636

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	0.096	0.095	0.200	0.200	0.000
Y	0.000	219.328	219.328	2000.000	2000.000	0.000
Z	0.000	-0.139	-0.139	0.200	0.200	0.000
R	56.500	56.328	-0.172	0.200	0.200	0.000
RN	0.000	0.060	0.060	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	0.287	0.287	0.200	0.200	0.087
Y	0.000	334.331	334.331	2000.000	2000.000	0.000
Z	0.000	-0.373	-0.373	0.200	0.200	0.173
R	56.500	56.403	-0.097	0.200	0.200	0.000
RN	0.000	0.000	0.000	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	0.310	0.310	0.200	0.200	0.110
Y	0.000	449.328	449.328	2000.000	2000.000	0.000
Z	0.000	-0.494	-0.494	0.200	0.200	0.294
R	56.500	56.373	-0.127	0.200	0.200	0.000
RN	0.000	0.009	0.009	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	0.290	0.290	0.200	0.200	0.090
Y	0.000	565.327	565.327	2000.000	2000.000	0.000
Z	0.000	-0.581	-0.581	0.200	0.200	0.381
R	56.500	56.392	-0.108	0.200	0.200	0.000
RN	0.000	0.017	0.017	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	0.341	0.341	0.200	0.200	0.141
Y	0.000	680.328	680.328	2000.000	2000.000	0.000
Z	0.000	-0.611	-0.611	0.200	0.200	0.411
R	56.500	56.380	-0.120	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	0.393	0.392	0.200	0.200	0.192
Y	0.000	795.327	795.327	2000.000	2000.000	0.000
Z	0.000	-0.650	-0.651	0.200	0.200	0.451
R	56.500	56.421	-0.079	0.200	0.200	0.000
RN	0.000	0.005	0.005	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	0.398	0.398	0.200	0.200	0.198
Y	0.000	910.334	910.334	2000.000	2000.000	0.000
Z	0.000	-0.551	-0.551	0.200	0.200	0.351
R	56.500	56.380	-0.120	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	0.213	0.213	0.200	0.200	0.013
Y	0.000	1026.334	1026.334	2000.000	2000.000	0.000
Z	0.000	-0.283	-0.284	0.200	0.200	0.084
R	56.500	56.439	-0.061	0.200	0.200	0.000
RN	0.000	0.044	0.044	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	0.015	0.015	0.200	0.200	0.000
Y	0.000	213.144	213.144	2000.000	2000.000	0.000
Z	56.500	56.200	-0.300	0.200	0.200	0.100

MM	DIM LOC-SUPPORT RING-PT2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.015	0.200	0.200	0.000
Y	0.000	328.131	328.131	2000.000	2000.000	0.000
Z	56.500	55.983	-0.517	0.200	0.200	0.317

MM	DIM LOC-SUPPORT RING-PT3= LOCATION OF POINT PT-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.015	0.200	0.200	0.000
Y	0.000	443.231	443.231	2000.000	2000.000	0.000
Z	56.500	55.827	-0.673	0.200	0.200	0.473

MM	DIM LOC-SUPPORT RING-PT4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.015	0.200	0.200	0.000
Y	0.000	558.531	558.531	2000.000	2000.000	0.000
Z	56.500	55.795	-0.705	0.200	0.200	0.505

MM	DIM LOC-SUPPORT RING-PT5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.015	0.200	0.200	0.000
Y	0.000	673.581	673.581	2000.000	2000.000	0.000
Z	56.500	55.769	-0.731	0.200	0.200	0.531

MM	DIM LOC-SUPPORT RING-PT6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.014	0.200	0.200	0.000
Y	0.000	788.331	788.331	2000.000	2000.000	0.000
Z	56.500	55.725	-0.775	0.200	0.200	0.575

MM	DIM LOC-SUPPORT RING-PT7= LOCATION OF POINT PT-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.014	0.200	0.200	0.000
Y	0.000	903.431	903.431	2000.000	2000.000	0.000
Z	56.500	55.810	-0.690	0.200	0.200	0.490

MM	DIM LOC-SUPPORT RING-PT8= LOCATION OF POINT PT-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.014	0.200	0.200	0.000
Y	0.000	1018.431	1018.431	2000.000	2000.000	0.000
Z	56.500	56.127	-0.373	0.200	0.200	0.173

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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	-0.139	-0.139	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	-0.373	-0.373	0.200	0.200	0.173

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	-0.494	-0.494	0.200	0.200	0.294

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	-0.581	-0.581	0.200	0.200	0.381

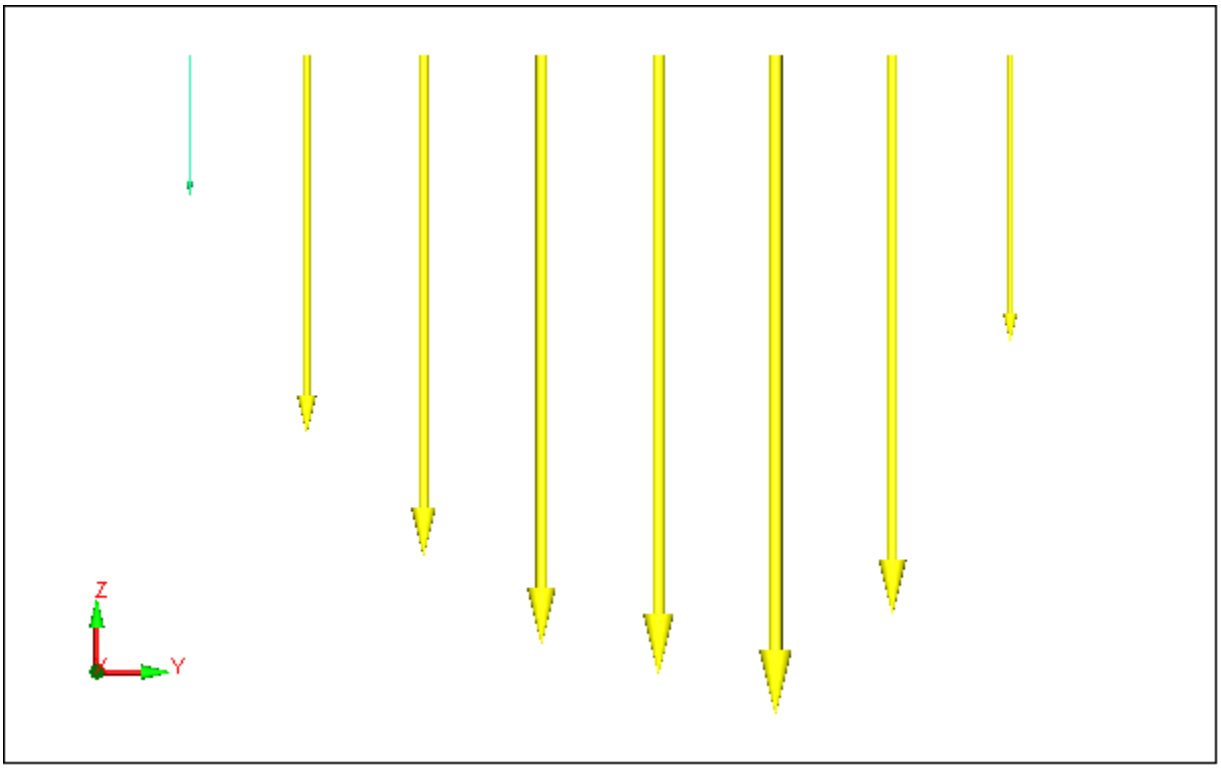
MM	DIM LOC Z SUPPORT RING CIRCLES 5= LOCATION OF CIRCLE CR-SUPPORT-RING-T5					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.611	-0.611	0.200	0.200	0.411

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	-0.650	-0.651	0.200	0.200	0.451

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	-0.551	-0.551	0.200	0.200	0.351

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	-0.283	-0.284	0.200	0.200	0.084

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC013 v3 IR DATE=6/25/2008



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	56.200	-0.300	0.200	0.200	0.100

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	55.983	-0.517	0.200	0.200	0.317

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	55.827	-0.673	0.200	0.200	0.473

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	55.795	-0.705	0.200	0.200	0.505

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	55.769	-0.731	0.200	0.200	0.531

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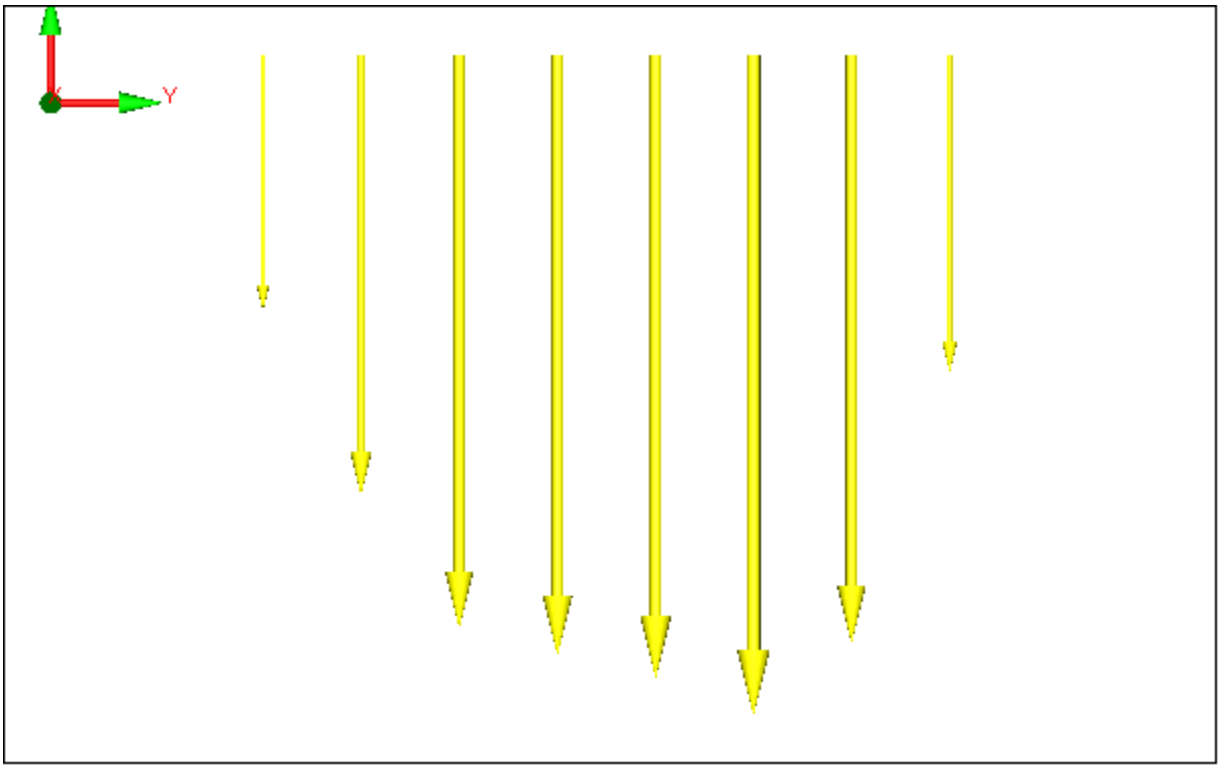
MM	DIM LOC Z SUPPORT RING POINTS 6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.725	-0.775	0.200	0.200	0.575

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	55.810	-0.690	0.200	0.200	0.490

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	56.127	-0.373	0.200	0.200	0.173



SUPPORT RING POINTS IN Z
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC013 v3 IR D
WG= SN=
TOTAL # OF MEAS =329 # OUT OF TOL =145