FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=6/18/2008 TIME=2:47:58 PM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC016 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-TB9ACC016
' ' : 0806171530

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	0.010	0.010	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	0.693	0.693	0.200	0.000	0.493

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.338	0.338	0.100	0.100	0.238

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.155	-0.156	0.200	0.200	0.000
Z	0.000	0.513	0.513	0.200	0.200	0.313
D	140.000	140.078	0.078	0.300	0.300	0.000
RN	0.000	0.004	0.004	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	1.092	0.092	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	59.979	-0.021				
PA	15.000	15.491	0.491				
DF	8.800	8.824	0.024	0.300	0.300		0.000
TP	RFS		1.029	0.300		0.000	0.729
RN	0.000	0.012	0.012	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	59.980	-0.020				
PA	45.000	45.468	0.468				
DF	8.800	8.827	0.027	0.300	0.300		0.000
TP	RFS		0.981	0.300		0.000	0.681
RN	0.000	0.013	0.013	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	60.000	0.000				
PA	75.000	75.437	0.437				
DF	8.800	8.838	0.038	0.300	0.300		0.000
TP	RFS		0.915	0.300		0.000	0.615
RN	0.000	0.035	0.035	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	60.009	0.009				
PA	105.000	105.466	0.466				
DF	8.800	8.828	0.028	0.300	0.300		0.000
TP	RFS		0.977	0.300		0.000	0.677
RN	0.000	0.021	0.021	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	59.973	-0.027				
PA	135.000	135.481	0.481				
DF	8.800	8.831	0.031	0.300	0.300		0.000
TP	RFS		1.008	0.300		0.000	0.708
RN	0.000	0.013	0.013	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	59.990	-0.010				
PA	165.000	165.470	0.471				
DF	8.800	8.830	0.030	0.300	0.300		0.000
TP	RFS		0.986	0.300		0.000	0.686
RN	0.000	0.017	0.017	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	1242.187	-5.213	3.000	3.000	2.213
V	0.003	1.000	0.003			
FL	0.000	0.010	0.010	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	0.542	0.542	0.200	0.000	0.342

DEG	DIM ANGL2= 3D ANGLE (COMPLEMENT) FROM PLANE PL-FAR-END TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.258	0.258	0.100	0.100	0.158

MM	DIM LOC4= LOCATION OF CIRCLE CR-FAR-END					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.149	0.149	0.200	0.200	0.000
Z	0.000	0.293	0.293	0.200	0.200	0.093
D	140.000	140.073	0.073	0.300	0.300	0.000
RN	0.000	0.010	0.010	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	1.074	0.074	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	59.918	-0.082				
PA	15.000	14.483	-0.517				
DF	8.800	8.830	0.030	0.300	0.300		0.000
TP	RFS		1.094	0.300		0.000	0.794
RN	0.000	0.018	0.018	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	59.927	-0.073				
PA	45.000	44.480	-0.520				
DF	8.800	8.836	0.036	0.300	0.300		0.000
TP	RFS		1.099	0.300		0.000	0.799
RN	0.000	0.014	0.014	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	59.929	-0.071				
PA	75.000	74.506	-0.494				
DF	8.800	8.828	0.028	0.300	0.300		0.000
TP	RFS		1.044	0.300		0.000	0.744
RN	0.000	0.011	0.011	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	59.916	-0.084				
PA	105.000	104.503	-0.497				
DF	8.800	8.836	0.036	0.300	0.300		0.000
TP	RFS		1.053	0.300		0.000	0.753
RN	0.000	0.013	0.013	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	59.914	-0.086				
PA	135.000	134.516	-0.484				
DF	8.800	8.850	0.050	0.300	0.300		0.000
TP	RFS		1.027	0.300		0.000	0.727
RN	0.000	0.012	0.012	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	59.914	-0.086				
PA	165.000	164.522	-0.478				
DF	8.800	8.836	0.036	0.300	0.300		0.000
TP	RFS		1.015	0.300		0.000	0.715
RN	0.000	0.020	0.020	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	93.079	0.239	0.200	0.200	0.039
V	-0.002	-1.000	0.006			
FL	0.000	0.029	0.029	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	0.650	0.650	0.200	0.000	0.450

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.365	0.365	0.100	0.100	0.265

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	1148.667	-5.893	0.200	0.200	5.693
V	-0.002	1.000	0.004			
FL	0.000	0.026	0.026	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	0.461	0.461	0.200	0.000	0.261

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.256	0.256	0.100	0.100	0.156

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	1055.588	-5.472	0.200	0.200	5.272

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	93.521	0.021	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	-54.001	-0.201	0.200	0.200	0.001
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	0.108	0.108	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	0.209	0.209	0.100	0.100	0.109

MM DIM LOC6= LOCATION OF CIRCLE CR_NW8_ANTENNA_FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.637	0.037	0.200	0.200	0.000
Z	0.000	0.331	0.330	0.200	0.200	0.130
D	33.800	33.826	0.026	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	0.532	0.032	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	87.936	-0.064	0.200	0.200	0.000
V	1.000	0.003	-0.005			
FL	0.000	0.034	0.034	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	0.405	0.405	0.200	0.000	0.205

DEG DIM ANGL4= 3D ANGLE (COMPLEMENT) FROM PLANE PL NW 40 FLANGE TO XAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.342	0.342	0.100	0.100	0.242

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MM	DIM LOC8= LOCATION OF CIRCLE CR_NW_40_FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1181.849	-4.951	0.200	0.200	4.751
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	75.978	-0.022	0.200	0.000	0.022
RN	0.000	0.013	0.013	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	60.338	-0.262	0.200	0.200	0.062

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	0.616	0.116	0.050	0.000	0.066

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	31.765	0.015				
PA	112.500	112.359	-0.141				
DF	6.700	6.843	0.143	0.200	0.200		0.000
TP	RFS		0.159	0.300		0.000	0.000
RN	0.000	0.023	0.023	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	0.003	0.003	0.200	0.000	0.000

MM	DIM VECTOR1= LOCATION OF PLANE PL-NW12-FLANGE-HOM2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.559	0.261	0.787			

DEG	DIM ANGL6= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	35.412	0.412	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	-72.738	-72.738	100.000	100.000	0.000
Y	0.000	1185.796	1185.796	2000.000	2000.000	0.000
Z	0.000	-8.060	-8.060	100.000	100.000	0.000
D	33.800	33.778	-0.022	0.150	0.000	0.022
RN	0.000	0.049	0.049	0.150	0.000	0.000

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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	28.483	0.063	0.100	0.100	0.000

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	28.480	0.060	0.100	0.100	0.000

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	15.066	0.066	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	68.575	68.575	100.000	100.000	0.000
Y	60.600	60.295	-0.305	0.200	0.200	0.105
Z	0.000	-40.049	-40.049	100.000	100.000	0.000
D	44.000	43.756	-0.244	0.000	0.100	0.144
RN	0.000	0.179	0.179	0.100	0.000	0.079
V	-0.863	0.001	0.506			

DEG	DIM ANGL9= 2D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-1 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.399	0.399	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	89.965	-0.035	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	59.601	-0.399	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	115.849	-0.151	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	110.871	-0.129	0.200	0.200	0.000
FL	0.000	0.011	0.011	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	60.344	-0.256	0.200	0.200	0.056
Z	0.000	0.182	0.182	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	-64.178	-64.178	100.000	100.000	0.000
Y	1186.800	1181.806	-4.994	3.000	3.000	1.994
Z	0.000	-45.517	-45.517	100.000	100.000	0.000
D	44.000	43.790	-0.210	0.000	0.100	0.110
RN	0.000	0.122	0.122	0.100	0.000	0.022
V	-0.819	0.002	-0.574			

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	60.381	-0.219	0.200	0.200	0.019

DEG	DIM ANGL12= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	35.040	0.040	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	90.105	0.105	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	54.960	-0.040	0.500	0.500	0.000

MM	DIM HOM2 POINT= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.006	0.006	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	110.915	-0.085	0.200	0.200	0.000
FL	0.000	0.012	0.012	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	1181.662	-5.138	3.000	3.000	2.138
Z	0.000	-0.511	-0.511	0.200	0.200	0.311

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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	95.028	95.028	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.935	-0.065	0.050	0.050	0.015
RN	0.000	0.028	0.028	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	0.029	0.029	0.200	0.200	0.000
Y	0.000	122.649	122.649	2000.000	2000.000	0.000
Z	0.000	-0.168	-0.168	0.200	0.200	0.000
D	191.200	191.213	0.013	0.200	0.200	0.000
RN	0.000	0.013	0.013	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	0.029	0.029	0.200	0.200	0.000
Y	0.000	155.991	155.991	2000.000	2000.000	0.000
Z	0.000	-0.275	-0.275	0.200	0.200	0.075
D	210.300	210.708	0.408	0.200	0.200	0.208
RN	0.000	0.034	0.034	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	0.017	0.017	0.200	0.200	0.000
Y	0.000	167.080	167.080	2000.000	2000.000	0.000
Z	0.000	-0.264	-0.264	0.200	0.200	0.064
D	210.300	210.661	0.361	0.200	0.200	0.161
RN	0.000	0.071	0.071	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	-0.026	-0.026	0.200	0.200	0.000
Y	0.000	270.163	270.163	2000.000	2000.000	0.000
Z	0.000	-0.509	-0.509	0.200	0.200	0.309
D	210.300	210.640	0.340	0.200	0.200	0.140
RN	0.000	0.182	0.182	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	0.007	0.007	0.200	0.200	0.000
Y	0.000	281.696	281.696	2000.000	2000.000	0.000
Z	0.000	-0.527	-0.527	0.200	0.200	0.327
D	210.300	210.572	0.272	0.200	0.200	0.072
RN	0.000	0.251	0.251	0.200	0.000	0.051

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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	-0.007	-0.007	0.200	0.200	0.000
Y	0.000	385.335	385.335	2000.000	2000.000	0.000
Z	0.000	-0.708	-0.708	0.200	0.200	0.508
D	210.300	210.615	0.315	0.200	0.200	0.115
RN	0.000	0.115	0.115	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	0.051	0.050	0.200	0.200	0.000
Y	0.000	396.907	396.907	2000.000	2000.000	0.000
Z	0.000	-0.695	-0.695	0.200	0.200	0.495
D	210.300	210.629	0.329	0.200	0.200	0.129
RN	0.000	0.184	0.184	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	0.022	0.022	0.200	0.200	0.000
Y	0.000	500.022	500.022	2000.000	2000.000	0.000
Z	0.000	-0.828	-0.828	0.200	0.200	0.628
D	210.300	210.657	0.357	0.200	0.200	0.157
RN	0.000	0.125	0.125	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	0.012	0.012	0.200	0.200	0.000
Y	0.000	511.360	511.360	2000.000	2000.000	0.000
Z	0.000	-0.878	-0.878	0.200	0.200	0.678
D	210.300	210.539	0.239	0.200	0.200	0.039
RN	0.000	0.144	0.144	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	0.053	0.053	0.200	0.200	0.000
Y	0.000	614.981	614.981	2000.000	2000.000	0.000
Z	0.000	-0.958	-0.958	0.200	0.200	0.758
D	210.300	210.605	0.305	0.200	0.200	0.105
RN	0.000	0.168	0.168	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	0.101	0.101	0.200	0.200	0.000
Y	0.000	626.372	626.372	2000.000	2000.000	0.000
Z	0.000	-0.973	-0.973	0.200	0.200	0.773
D	210.300	210.539	0.239	0.200	0.200	0.039
RN	0.000	0.165	0.165	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	0.147	0.147	0.200	0.200	0.000
Y	0.000	729.637	729.637	2000.000	2000.000	0.000
Z	0.000	-0.922	-0.922	0.200	0.200	0.722
D	210.300	210.602	0.302	0.200	0.200	0.102
RN	0.000	0.180	0.180	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	0.122	0.122	0.200	0.200	0.000
Y	0.000	740.916	740.916	2000.000	2000.000	0.000
Z	0.000	-0.942	-0.942	0.200	0.200	0.742
D	210.300	210.532	0.232	0.200	0.200	0.032
RN	0.000	0.240	0.240	0.200	0.000	0.040

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.143	0.143	0.200	0.200	0.000
Y	0.000	844.835	844.835	2000.000	2000.000	0.000
Z	0.000	-0.785	-0.785	0.200	0.200	0.585
D	210.300	210.614	0.314	0.200	0.200	0.114
RN	0.000	0.108	0.108	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	0.166	0.166	0.200	0.200	0.000
Y	0.000	855.814	855.814	2000.000	2000.000	0.000
Z	0.000	-0.766	-0.767	0.200	0.200	0.567
D	210.300	210.573	0.273	0.200	0.200	0.073
RN	0.000	0.189	0.189	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	0.204	0.204	0.200	0.200	0.004
Y	0.000	959.517	959.517	2000.000	2000.000	0.000
Z	0.000	-0.569	-0.570	0.200	0.200	0.370
D	210.300	210.661	0.361	0.200	0.200	0.161
RN	0.000	0.205	0.205	0.200	0.000	0.005

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.133	0.132	0.200	0.200	0.000
Y	0.000	970.948	970.948	2000.000	2000.000	0.000
Z	0.000	-0.572	-0.572	0.200	0.200	0.372
D	210.300	210.556	0.256	0.200	0.200	0.056
RN	0.000	0.135	0.135	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	0.213	0.212	0.200	0.200	0.012
Y	0.000	1074.804	1074.804	2000.000	2000.000	0.000
Z	0.000	-0.293	-0.293	0.200	0.200	0.093
D	210.300	210.600	0.300	0.200	0.200	0.100
RN	0.000	0.172	0.172	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	0.228	0.228	0.200	0.200	0.028
Y	0.000	1085.930	1085.930	2000.000	2000.000	0.000
Z	0.000	-0.256	-0.256	0.200	0.200	0.056
D	210.300	210.730	0.429	0.200	0.200	0.229
RN	0.000	0.173	0.173	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	0.071	0.071	0.200	0.200	0.000
Y	0.000	1115.632	1115.632	2000.000	2000.000	0.000
Z	0.000	-0.134	-0.134	0.200	0.200	0.000
D	200.000	200.095	0.095	0.200	0.200	0.000
RN	0.000	0.025	0.025	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	1146.654	1146.654	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.904	-0.096	0.050	0.050	0.046
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	0.029	0.029				
Z	0.000	-0.168	-0.168				
TP	RFS		0.341	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	0.029	0.029				
Z	0.000	-0.275	-0.275				
TP	RFS		0.553	0.400		0.000	0.153

⊕ MM	DIM LOC-TP-CC4= TRUE POSITION OF CIRCLE CRC-CAV-1-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.017	0.017				
Z	0.000	-0.264	-0.264				
TP	RFS		0.528	0.400		0.000	0.128

⊕ MM	DIM LOC-TP-CC5= TRUE POSITION OF CIRCLE CRC-CAV-2-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.026	-0.026				
Z	0.000	-0.509	-0.509				
TP	RFS		1.020	0.400		0.000	0.620

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.007	0.007				
Z	0.000	-0.527	-0.527				
TP	RFS		1.054	0.400		0.000	0.654

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.007	-0.007				
Z	0.000	-0.708	-0.708				
TP	RFS		1.416	0.400		0.000	1.016

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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	0.051	0.050				
Z	0.000	-0.695	-0.695				
TP	RFS		1.395	0.400		0.000	0.995

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.022	0.022				
Z	0.000	-0.828	-0.828				
TP	RFS		1.657	0.400		0.000	1.257

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.012	0.012				
Z	0.000	-0.878	-0.878				
TP	RFS		1.757	0.400		0.000	1.357

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.053	0.053				
Z	0.000	-0.958	-0.958				
TP	RFS		1.919	0.400		0.000	1.519

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.101	0.101				
Z	0.000	-0.973	-0.973				
TP	RFS		1.957	0.400		0.000	1.557

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.147	0.147				
Z	0.000	-0.922	-0.922				
TP	RFS		1.867	0.400		0.000	1.467

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.122	0.122				
Z	0.000	-0.942	-0.942				
TP	RFS		1.901	0.400		0.000	1.501

⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.143	0.143				
Z	0.000	-0.785	-0.785				
TP	RFS		1.596	0.400		0.000	1.196

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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	0.166	0.166				
Z	0.000	-0.766	-0.767				
TP	RFS		1.569	0.400		0.000	1.169

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.204	0.204				
Z	0.000	-0.569	-0.570				
TP	RFS		1.210	0.400		0.000	0.810

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.133	0.132				
Z	0.000	-0.572	-0.572				
TP	RFS		1.175	0.400		0.000	0.775

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.213	0.212				
Z	0.000	-0.293	-0.293				
TP	RFS		0.724	0.400		0.000	0.324

⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.228	0.228				
Z	0.000	-0.256	-0.256				
TP	RFS		0.686	0.400		0.000	0.286

⊕ MM	DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.071	0.071				
Z	0.000	-0.134	-0.134				
TP	RFS		0.303	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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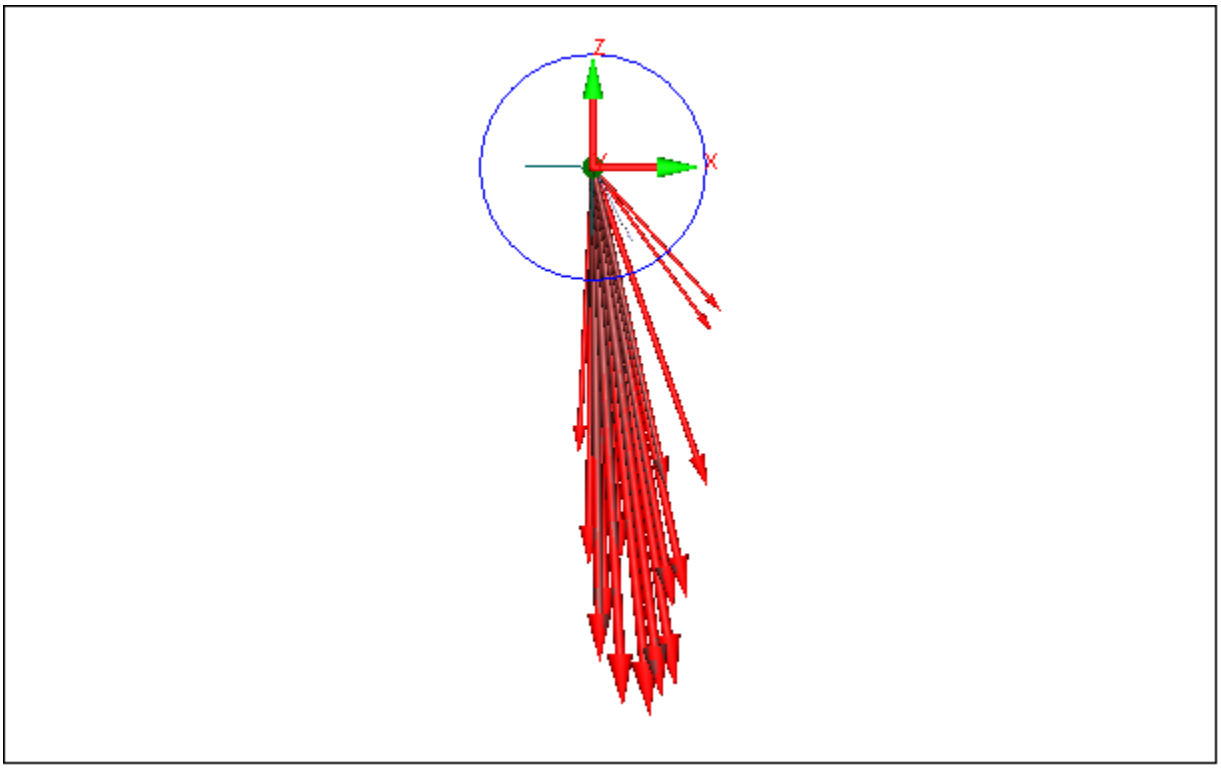
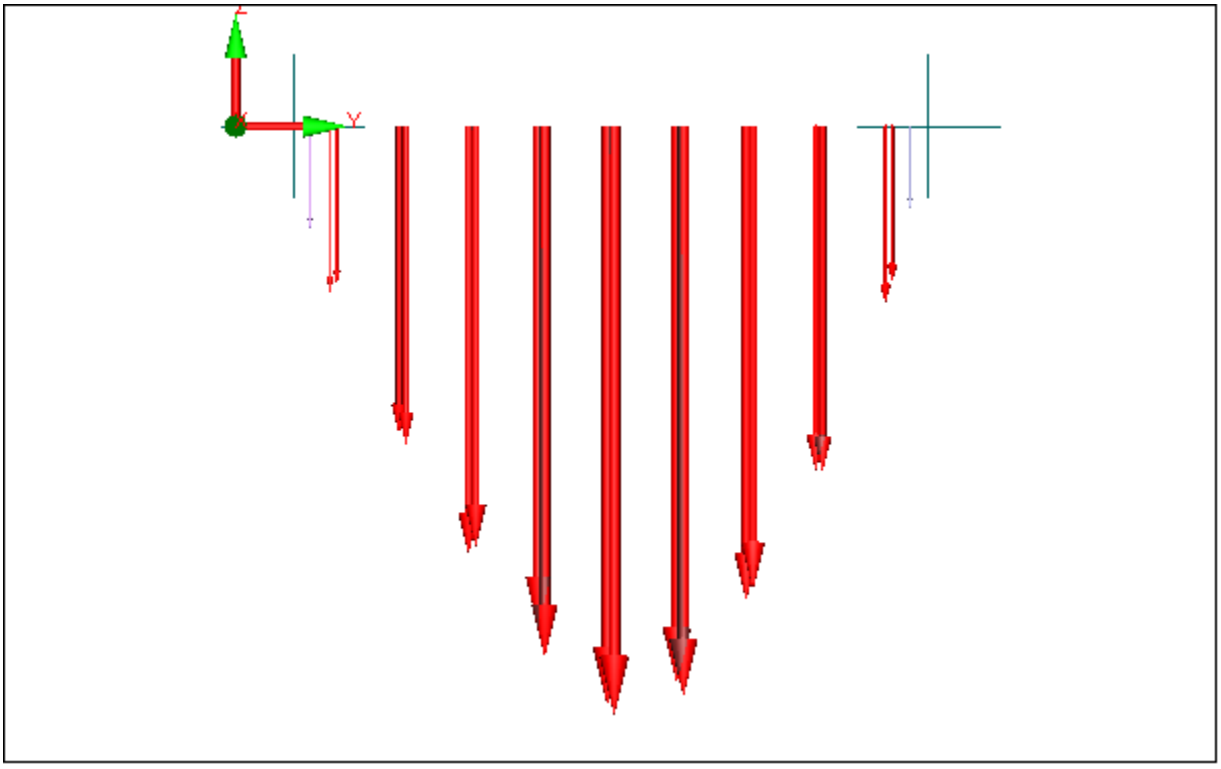
True Position plots from 3 views
x1000



-Y View
x1000



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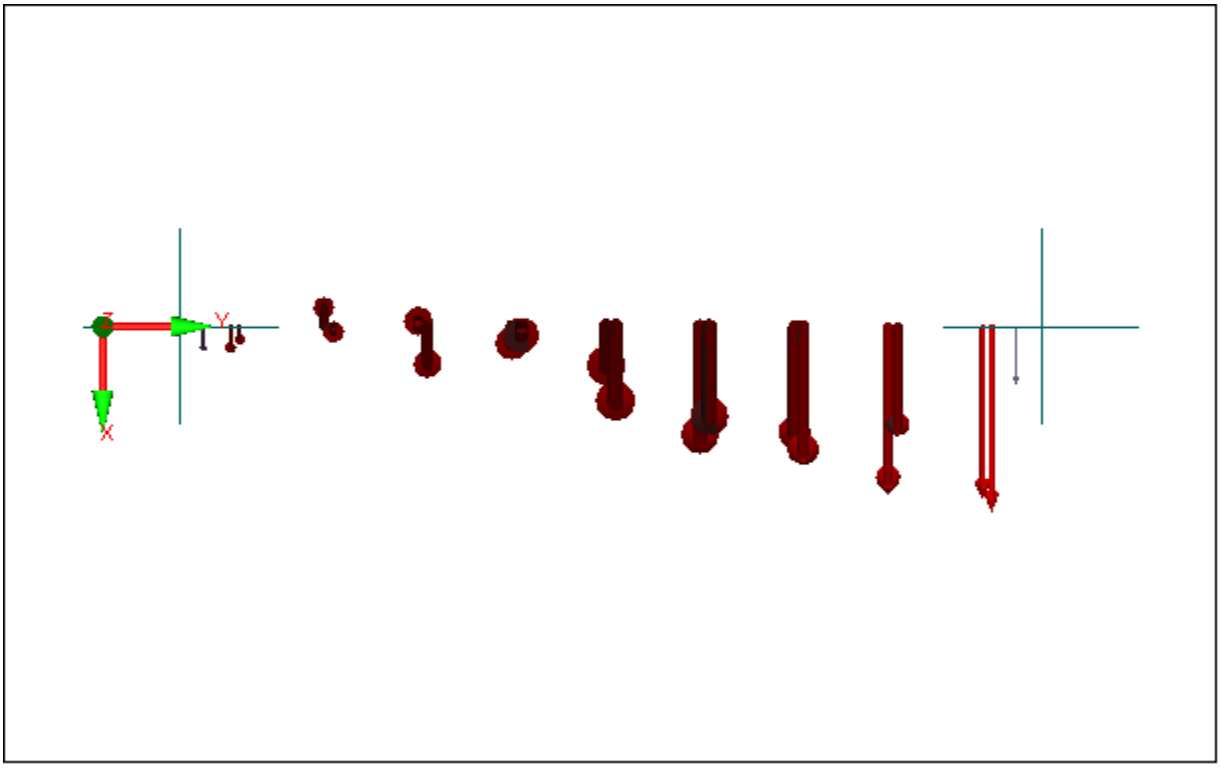
+X View

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	0.078	0.078	0.200	0.200	0.000
Y	0.000	620.558	620.558	2000.000	2000.000	0.000
Z	0.000	-0.547	-0.547	0.200	0.200	0.347
ST	0.000	1.005	1.005	0.200	0.000	0.805

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	0.019	0.018	0.200	0.200	0.000
Y	0.000	219.330	219.330	2000.000	2000.000	0.000
Z	0.000	-0.432	-0.432	0.200	0.200	0.232
R	56.500	56.403	-0.097	0.200	0.200	0.000
RN	0.000	0.010	0.010	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	-0.030	-0.030	0.200	0.200	0.000
Y	0.000	334.329	334.329	2000.000	2000.000	0.000
Z	0.000	-0.600	-0.600	0.200	0.200	0.400
R	56.500	56.391	-0.109	0.200	0.200	0.000
RN	0.000	0.022	0.022	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	-0.037	-0.038	0.200	0.200	0.000
Y	0.000	449.330	449.330	2000.000	2000.000	0.000
Z	0.000	-0.827	-0.827	0.200	0.200	0.627
R	56.500	56.409	-0.091	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	0.019	0.019	0.200	0.200	0.000
Y	0.000	565.336	565.336	2000.000	2000.000	0.000
Z	0.000	-0.823	-0.823	0.200	0.200	0.623
R	56.500	56.327	-0.173	0.200	0.200	0.000
RN	0.000	0.005	0.005	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	0.154	0.154	0.200	0.200	0.000
Y	0.000	680.334	680.334	2000.000	2000.000	0.000
Z	0.000	-0.921	-0.921	0.200	0.200	0.721
R	56.500	56.407	-0.093	0.200	0.200	0.000
RN	0.000	0.013	0.013	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	0.186	0.186	0.200	0.200	0.000
Y	0.000	795.334	795.334	2000.000	2000.000	0.000
Z	0.000	-0.824	-0.824	0.200	0.200	0.624
R	56.500	56.386	-0.114	0.200	0.200	0.000
RN	0.000	0.014	0.014	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	0.160	0.160	0.200	0.200	0.000
Y	0.000	910.334	910.334	2000.000	2000.000	0.000
Z	0.000	-0.696	-0.696	0.200	0.200	0.496
R	56.500	56.398	-0.102	0.200	0.200	0.000
RN	0.000	0.008	0.008	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	0.220	0.220	0.200	0.200	0.020
Y	0.000	1026.333	1026.333	2000.000	2000.000	0.000
Z	0.000	-0.354	-0.354	0.200	0.200	0.154
R	56.500	56.412	-0.088	0.200	0.200	0.000
RN	0.000	0.004	0.004	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	0.090	0.090	0.200	0.200	0.000
Y	0.000	213.151	213.151	2000.000	2000.000	0.000
Z	56.500	56.005	-0.495	0.200	0.200	0.295

MM	DIM LOC-SUPPORT RING-PT2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.117	0.116	0.200	0.200	0.000
Y	0.000	328.138	328.138	2000.000	2000.000	0.000
Z	56.500	55.807	-0.693	0.200	0.200	0.493

MM	DIM LOC-SUPPORT RING-PT3= LOCATION OF POINT PT-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.143	0.143	0.200	0.200	0.000
Y	0.000	443.238	443.238	2000.000	2000.000	0.000
Z	56.500	55.563	-0.937	0.200	0.200	0.737

MM	DIM LOC-SUPPORT RING-PT4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.170	0.169	0.200	0.200	0.000
Y	0.000	558.538	558.538	2000.000	2000.000	0.000
Z	56.500	55.496	-1.004	0.200	0.200	0.804

MM	DIM LOC-SUPPORT RING-PT5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.196	0.196	0.200	0.200	0.000
Y	0.000	673.588	673.588	2000.000	2000.000	0.000
Z	56.500	55.424	-1.076	0.200	0.200	0.876

MM	DIM LOC-SUPPORT RING-PT6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.224	0.224	0.200	0.200	0.024
Y	0.000	788.338	788.338	2000.000	2000.000	0.000
Z	56.500	55.578	-0.922	0.200	0.200	0.722

MM	DIM LOC-SUPPORT RING-PT7= LOCATION OF POINT PT-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.251	0.251	0.200	0.200	0.051
Y	0.000	903.438	903.438	2000.000	2000.000	0.000
Z	56.500	55.709	-0.791	0.200	0.200	0.591

MM	DIM LOC-SUPPORT RING-PT8= LOCATION OF POINT PT-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.279	0.279	0.200	0.200	0.079
Y	0.000	1018.438	1018.438	2000.000	2000.000	0.000
Z	56.500	56.015	-0.485	0.200	0.200	0.285

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	-0.432	-0.432	0.200	0.200	0.232

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	-0.600	-0.600	0.200	0.200	0.400

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	-0.827	-0.827	0.200	0.200	0.627

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	-0.823	-0.823	0.200	0.200	0.623

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	-0.921	-0.921	0.200	0.200	0.721

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	-0.824	-0.824	0.200	0.200	0.624

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	-0.696	-0.696	0.200	0.200	0.496

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	-0.354	-0.354	0.200	0.200	0.154

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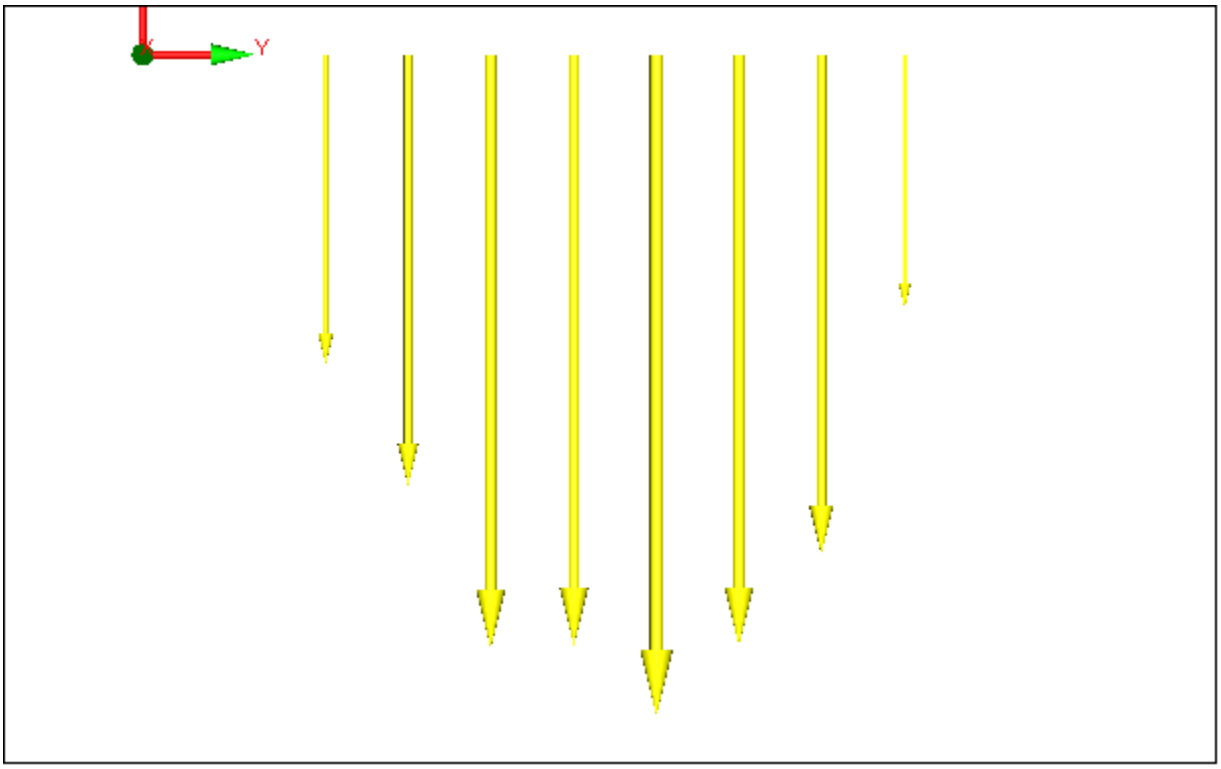

SUPPORT RING CIRCLES IN Z
x1000

SUPPORT RING POINTS IN Z

MM	DIM LOC Z SUPPORT RING POINTS 1= LOCATION OF POINT PT-SUPPORT-RING-T12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	56.005	-0.495	0.200	0.200	0.295

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	55.807	-0.693	0.200	0.200	0.493

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	55.563	-0.937	0.200	0.200	0.737

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	55.496	-1.004	0.200	0.200	0.804

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	55.424	-1.076	0.200	0.200	0.876

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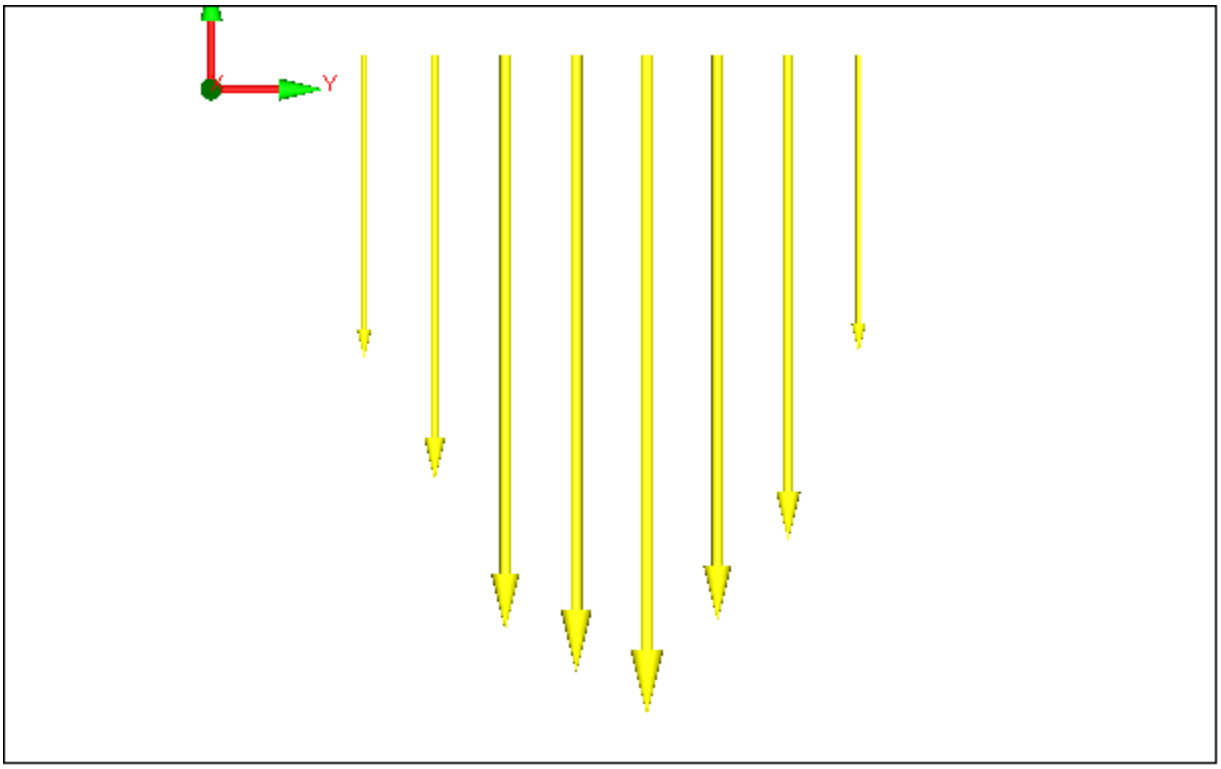
MM	DIM LOC Z SUPPORT RING POINTS 6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	56.500	55.578	-0.922	0.200	0.200	0.722

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	55.709	-0.791	0.200	0.200	0.591

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	56.015	-0.485	0.200	0.200	0.285



SUPPORT RING POINTS IN Z
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9ACC016 v3 IR D
WG= SN=
TOTAL # OF MEAS =329 # OUT OF TOL =146