FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=6/5/2008 TIME=4:25:31 PM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY v3 TB9ACC016-180 IR
REV NUMBER :
SER NUMBER :
STATS COUNT : 1

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

'Inspected by ' : Robert Riley
'Cavity Number' : ACCEL TB9ACC016
' ' : 0806051414

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	0.001			
FL	0.000	0.014	0.014	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	0.223	0.223	0.200	0.000	0.023

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.105	0.105	0.100	0.100	0.005

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.156	-0.156	0.200	0.200	0.000
Z	0.000	0.079	0.079	0.200	0.200	0.000
D	140.000	140.075	0.075	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	1.102	0.102	0.100	0.100	0.002

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

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⊕ MM	DIM TP NBPF BH7= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 195						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.964	-0.036				
PA	-165.000	-164.423	0.577				
DF	8.800	8.826	0.026	0.300	0.300		0.000
TP	RFS		1.211	0.300		0.000	0.911
RN	0.000	0.016	0.016	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH8= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 225						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.965	-0.035				
PA	-135.000	-134.451	0.549				
DF	8.800	8.846	0.046	0.300	0.300		0.000
TP	RFS		1.151	0.300		0.000	0.851
RN	0.000	0.016	0.016	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH9= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 255						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.991	-0.009				
PA	-105.000	-104.404	0.596				
DF	8.800	8.827	0.027	0.300	0.300		0.000
TP	RFS		1.249	0.300		0.000	0.949
RN	0.000	0.013	0.013	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH10= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 285						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.998	-0.002				
PA	-75.000	-74.383	0.617				
DF	8.800	8.835	0.035	0.300	0.300		0.000
TP	RFS		1.292	0.300		0.000	0.992
RN	0.000	0.018	0.018	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH11= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH315						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.984	-0.016				
PA	-45.000	-44.390	0.610				
DF	8.800	8.930	0.130	0.300	0.300		0.000
TP	RFS		1.278	0.300		0.000	0.978
RN	0.000	0.017	0.017	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH12= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 345						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.977	-0.023				
PA	-15.000	-14.390	0.610				
DF	8.800	8.828	0.028	0.300	0.300		0.000
TP	RFS		1.279	0.300		0.000	0.979
RN	0.000	0.016	0.016	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	1242.204	-5.196	3.000	3.000	2.196
V	0.003	1.000	-0.002			
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	0.439	0.439	0.200	0.000	0.239

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.209	0.209	0.100	0.100	0.109

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	-0.155	-0.155	0.200	0.200	0.000
D	140.000	140.075	0.075	0.300	0.300	0.000
RN	0.000	0.013	0.013	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	1.075	0.075	0.100	0.100	0.000

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

MM DIM TP FBPF BH7= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 195

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.907	-0.093				
PA	-165.000	-165.376	-0.376				
DF	8.800	8.848	0.048	0.300	0.300		0.000
TP	RFS		0.808	0.300		0.000	0.508
RN	0.000	0.027	0.027	0.300	0.000		0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.929	-0.072				
PA	-135.000	-135.389	-0.389				
DF	8.800	8.851	0.051	0.300	0.300		0.000
TP	RFS		0.827	0.300		0.000	0.527
RN	0.000	0.015	0.015	0.300	0.000		0.000

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⊕ MM	DIM TP FBPF BH9= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 255						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.934	-0.067				
PA	-105.000	-105.403	-0.403				
DF	8.800	8.843	0.043	0.300	0.300		0.000
TP	RFS		0.854	0.300		0.000	0.554
RN	0.000	0.014	0.014	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH10= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 285						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.937	-0.064				
PA	-75.000	-75.418	-0.418				
DF	8.800	8.833	0.033	0.300	0.300		0.000
TP	RFS		0.884	0.300		0.000	0.584
RN	0.000	0.026	0.026	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH11= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 315						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.927	-0.073				
PA	-45.000	-45.431	-0.431				
DF	8.800	8.834	0.034	0.300	0.300		0.000
TP	RFS		0.915	0.300		0.000	0.615
RN	0.000	0.015	0.015	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH12= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 345						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.932	-0.068				
PA	-15.000	-15.411	-0.411				
DF	8.800	8.828	0.028	0.300	0.300		0.000
TP	RFS		0.870	0.300		0.000	0.570
RN	0.000	0.015	0.015	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	93.066	0.226	0.200	0.200	0.026
V	-0.002	-1.000	0.001			
FL	0.000	0.032	0.032	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	0.251	0.251	0.200	0.000	0.051

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.142	0.142	0.100	0.100	0.042

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	1148.701	-5.859	0.200	0.200	5.659
V	-0.001	1.000	-0.000			
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 YMINUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.135	0.135	0.200	0.000	0.000

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.089	0.089	0.100	0.100	0.000

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	1055.635	-5.425	0.200	0.200	5.225

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	93.503	0.003	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	-54.000	-0.200	0.200	0.200	0.000
V	-1.000	-0.003	-0.003			
FL	0.000	0.004	0.004	0.200	0.000	0.000

// MM	DIM PARL3= PARALLEL OF PLANE PL NW8 ANTENNA FLANGE,RFS TO WORKPLANE XMINUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.120	0.120	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	0.257	0.257	0.100	0.100	0.157

MM	DIM LOC6= LOCATION OF CIRCLE CR_NW8_ANTENNA_FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.651	0.051	0.200	0.200	0.000
Z	0.000	0.071	0.071	0.200	0.200	0.000
D	33.800	33.826	0.026	0.150	0.000	0.000
RN	0.000	0.018	0.018	0.150	0.000	0.000

MM	DIM DIST01= 2D DISTANCE FROM PLANE PL NW8 ANTENNA FLANGE TO PLANE PL NW8 ANTENNA FLANGE ORING PAR TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.531	0.031	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	87.938	-0.062	0.200	0.200	0.000
V	1.000	0.003	-0.003			
FL	0.000	0.032	0.032	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	0.320	0.320	0.200	0.000	0.120

DEG	DIM ANGL4= 3D ANGLE (TRUE) FROM PLANE PL NW 40 FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.264	0.264	0.100	0.100	0.164

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MM DIM LOC8= LOCATION OF CIRCLE CR_NW_40_FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1181.859	-4.941	0.200	0.200	4.741
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	75.977	-0.023	0.200	0.000	0.023
RN	0.000	0.009	0.009	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	60.345	-0.255	0.200	0.200	0.055

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.617	0.117	0.050	0.000	0.067

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	112.629	0.129				
DF	6.700	6.842	0.142	0.200	0.200		0.000
TP	RFS		0.146	0.300		0.000	0.000
RN	0.000	0.022	0.022	0.200	0.000		0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	31.750	31.677	-0.073				
PA	-67.500	-67.173	0.327				
DF	6.700	6.825	0.125	0.200	0.200		0.000
TP	RFS		0.391	0.300		0.000	0.091
RN	0.000	0.023	0.023	0.200	0.000		0.000

HOM-1 FLANGE NW12

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.484	-0.258	-0.836			

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.002	0.002	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	14.956	-0.044	0.500	0.500	0.000

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MM DIM DIST FORMTEIL1 POINT= 2D DISTANCE FROM POINT PT-FORMTEIL1 TO PLANE PL-NW12-FLANGE-HOM1 PERP TO PLANE PL-NW12-FLANGE-HOM1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.774	0.354	0.100	0.100	0.254

MM DIM DIST FORMTEIL1 PLANE= 2D DISTANCE FROM PLANE PL-FORMTEIL1 TO PLANE PL-NW12-FLANGE-HOM1 PERP TO PLANE PL-NW12-FLANGE-HOM1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.775	0.355	0.100	0.100	0.255

MM DIM DIST02= 2D DISTANCE FROM PLANE PL-NW12-FLANGE-HOM1 TO PLANE PL-NW12-FLANGE O-RING PAR TO ZAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.517	0.017	0.050	0.000	0.000

DEG DIM ANGL17= 2D ANGLE (COMPLEMENT) FROM PLANE PL-NW12-FLANGE-HOM1 TO ZAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.048	0.048	0.500	0.500	0.000

MM DIM LOC= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	38.048	38.048	100.000	100.000	0.000
Y	0.000	57.253	57.253	100.000	100.000	0.000
Z	0.000	-62.099	-62.099	100.000	100.000	0.000
D	33.800	33.762	-0.038	0.150	0.000	0.038
RN	0.000	0.054	0.054	0.150	0.000	0.000

HOM-2 FLANGE NW12

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.561	0.265	0.785			

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.005	0.005	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	15.363	0.363	0.500	0.500	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	35.548	0.548	0.500	0.500	0.048

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MM	DIM LOC9= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-72.581	-72.581	100.000	100.000	0.000
Y	0.000	1185.536	1185.536	2000.000	2000.000	0.000
Z	0.000	-8.572	-8.572	100.000	100.000	0.000
D	33.800	33.786	-0.014	0.150	0.000	0.014
RN	0.000	0.066	0.066	0.150	0.000	0.000

HOM 1 LOCATION

MM	DIM LOC-HOM1= LOCATION OF CYLINDER CY-HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	68.523	68.523	100.000	100.000	0.000
Y	60.600	60.492	-0.108	0.200	0.200	0.000
Z	0.000	-40.038	-40.038	100.000	100.000	0.000
D	44.000	43.770	-0.230	0.000	0.100	0.130
RN	0.000	0.191	0.191	0.100	0.000	0.091
V	-0.863	-0.002	0.505			

DEG	DIM ANGL9= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.334	0.334	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	89.911	-0.089	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	59.666	-0.334	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	115.926	-0.074	0.200	0.200	0.000

MM	DIM HOM1 PLANE= LOCATION OF PLANE PL HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	110.948	-0.052	0.200	0.200	0.000
FL	0.000	0.013	0.013	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	60.369	-0.231	0.200	0.200	0.031
Z	0.000	0.058	0.058	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	-64.242	-64.242	100.000	100.000	0.000
Y	1186.800	1181.591	-5.209	3.000	3.000	2.209
Z	0.000	-45.941	-45.941	100.000	100.000	0.000
D	44.000	43.809	-0.191	0.000	0.100	0.091
RN	0.000	0.141	0.141	0.100	0.000	0.041
V	0.816	0.001	0.577			

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	60.613	0.013	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	35.272	0.272	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	90.032	0.032	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	54.728	-0.272	0.500	0.500	0.000

MM	DIM LOC HOM2= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.097	0.097	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	111.008	0.008	0.200	0.200	0.000
FL	0.000	0.010	0.010	0.200	0.000	0.000

INTERSECTION OF HOM2 & YZ PLANE

MM	DIM LOC-HOM2 X PLANE= LOCATION OF POINT PTC-HOM2 X YZ PLANE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	1186.800	1181.635	-5.165	3.000	3.000	2.165
Z	0.000	-0.501	-0.501	0.200	0.200	0.301

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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	94.989	94.989	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.928	-0.072	0.050	0.050	0.022
RN	0.000	0.029	0.029	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	0.031	0.031	0.200	0.200	0.000
Y	0.000	122.529	122.529	2000.000	2000.000	0.000
Z	0.000	-0.039	-0.039	0.200	0.200	0.000
D	191.200	191.207	0.007	0.200	0.200	0.000
RN	0.000	0.016	0.016	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	0.028	0.028	0.200	0.200	0.000
Y	0.000	155.625	155.625	2000.000	2000.000	0.000
Z	0.000	0.007	0.007	0.200	0.200	0.000
D	210.300	210.691	0.391	0.200	0.200	0.191
RN	0.000	0.031	0.031	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	0.021	0.021	0.200	0.200	0.000
Y	0.000	167.301	167.301	2000.000	2000.000	0.000
Z	0.000	0.051	0.051	0.200	0.200	0.000
D	210.300	210.651	0.351	0.200	0.200	0.151
RN	0.000	0.074	0.074	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	-0.021	-0.021	0.200	0.200	0.000
Y	0.000	270.235	270.235	2000.000	2000.000	0.000
Z	0.000	0.241	0.241	0.200	0.200	0.041
D	210.300	210.638	0.338	0.200	0.200	0.138
RN	0.000	0.181	0.181	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	0.015	0.015	0.200	0.200	0.000
Y	0.000	281.894	281.894	2000.000	2000.000	0.000
Z	0.000	0.256	0.256	0.200	0.200	0.056
D	210.300	210.565	0.265	0.200	0.200	0.065
RN	0.000	0.253	0.253	0.200	0.000	0.053

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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	-0.012	-0.012	0.200	0.200	0.000
Y	0.000	385.510	385.510	2000.000	2000.000	0.000
Z	0.000	0.411	0.411	0.200	0.200	0.211
D	210.300	210.618	0.318	0.200	0.200	0.118
RN	0.000	0.113	0.113	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	0.060	0.060	0.200	0.200	0.000
Y	0.000	397.070	397.070	2000.000	2000.000	0.000
Z	0.000	0.443	0.442	0.200	0.200	0.242
D	210.300	210.624	0.325	0.200	0.200	0.125
RN	0.000	0.165	0.165	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	0.010	0.010	0.200	0.200	0.000
Y	0.000	499.938	499.938	2000.000	2000.000	0.000
Z	0.000	0.517	0.517	0.200	0.200	0.317
D	210.300	210.653	0.353	0.200	0.200	0.153
RN	0.000	0.128	0.128	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	0.009	0.009	0.200	0.200	0.000
Y	0.000	511.713	511.713	2000.000	2000.000	0.000
Z	0.000	0.480	0.480	0.200	0.200	0.280
D	210.300	210.528	0.228	0.200	0.200	0.028
RN	0.000	0.139	0.139	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	0.049	0.049	0.200	0.200	0.000
Y	0.000	614.981	614.981	2000.000	2000.000	0.000
Z	0.000	0.472	0.472	0.200	0.200	0.272
D	210.300	210.605	0.305	0.200	0.200	0.105
RN	0.000	0.171	0.171	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.097	0.097	0.200	0.200	0.000
Y	0.000	626.619	626.619	2000.000	2000.000	0.000
Z	0.000	0.457	0.457	0.200	0.200	0.257
D	210.300	210.530	0.230	0.200	0.200	0.030
RN	0.000	0.168	0.168	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	0.138	0.138	0.200	0.200	0.000
Y	0.000	729.632	729.632	2000.000	2000.000	0.000
Z	0.000	0.441	0.440	0.200	0.200	0.240
D	210.300	210.595	0.295	0.200	0.200	0.095
RN	0.000	0.178	0.178	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	0.123	0.122	0.200	0.200	0.000
Y	0.000	741.250	741.250	2000.000	2000.000	0.000
Z	0.000	0.412	0.411	0.200	0.200	0.211
D	210.300	210.517	0.217	0.200	0.200	0.017
RN	0.000	0.232	0.232	0.200	0.000	0.032

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.136	0.136	0.200	0.200	0.000
Y	0.000	844.943	844.943	2000.000	2000.000	0.000
Z	0.000	0.353	0.353	0.200	0.200	0.153
D	210.300	210.616	0.316	0.200	0.200	0.116
RN	0.000	0.104	0.104	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	0.165	0.165	0.200	0.200	0.000
Y	0.000	856.342	856.342	2000.000	2000.000	0.000
Z	0.000	0.351	0.351	0.200	0.200	0.151
D	210.300	210.555	0.255	0.200	0.200	0.055
RN	0.000	0.181	0.181	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	0.192	0.192	0.200	0.200	0.000
Y	0.000	959.295	959.295	2000.000	2000.000	0.000
Z	0.000	0.209	0.209	0.200	0.200	0.009
D	210.300	210.653	0.353	0.200	0.200	0.153
RN	0.000	0.215	0.215	0.200	0.000	0.015

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.140	0.140	0.200	0.200	0.000
Y	0.000	971.386	971.386	2000.000	2000.000	0.000
Z	0.000	0.174	0.174	0.200	0.200	0.000
D	210.300	210.537	0.237	0.200	0.200	0.037
RN	0.000	0.136	0.136	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	0.208	0.208	0.200	0.200	0.008
Y	0.000	1074.831	1074.831	2000.000	2000.000	0.000
Z	0.000	0.021	0.020	0.200	0.200	0.000
D	210.300	210.596	0.296	0.200	0.200	0.096
RN	0.000	0.167	0.167	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	0.224	0.224	0.200	0.200	0.024
Y	0.000	1086.139	1086.139	2000.000	2000.000	0.000
Z	0.000	0.022	0.021	0.200	0.200	0.000
D	210.300	210.719	0.419	0.200	0.200	0.219
RN	0.000	0.177	0.177	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	0.068	0.068	0.200	0.200	0.000
Y	0.000	1115.664	1115.664	2000.000	2000.000	0.000
Z	0.000	0.009	0.009	0.200	0.200	0.000
D	200.000	200.091	0.091	0.200	0.200	0.000
RN	0.000	0.023	0.023	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	1146.740	1146.740	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.901	-0.099	0.050	0.050	0.049
RN	0.000	0.021	0.021	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	0.031	0.031				
Z	0.000	-0.039	-0.039				
TP	RFS		0.100	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	0.028	0.028				
Z	0.000	0.007	0.007				
TP	RFS		0.058	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	0.021	0.021				
Z	0.000	0.051	0.051				
TP	RFS		0.110	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	-0.021	-0.021				
Z	0.000	0.241	0.241				
TP	RFS		0.485	0.400		0.000	0.085

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.015	0.015				
Z	0.000	0.256	0.256				
TP	RFS		0.513	0.400		0.000	0.113

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.012	-0.012				
Z	0.000	0.411	0.411				
TP	RFS		0.822	0.400		0.000	0.422

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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	0.060	0.060				
Z	0.000	0.443	0.442				
TP	RFS		0.893	0.400		0.000	0.493

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.010	0.010				
Z	0.000	0.517	0.517				
TP	RFS		1.035	0.400		0.000	0.635

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.009	0.009				
Z	0.000	0.480	0.480				
TP	RFS		0.961	0.400		0.000	0.561

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.049	0.049				
Z	0.000	0.472	0.472				
TP	RFS		0.949	0.400		0.000	0.549

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.097	0.097				
Z	0.000	0.457	0.457				
TP	RFS		0.935	0.400		0.000	0.535

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.138	0.138				
Z	0.000	0.441	0.440				
TP	RFS		0.923	0.400		0.000	0.523

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.123	0.122				
Z	0.000	0.412	0.411				
TP	RFS		0.859	0.400		0.000	0.459

⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.136	0.136				
Z	0.000	0.353	0.353				
TP	RFS		0.756	0.400		0.000	0.356

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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	0.165	0.165				
Z	0.000	0.351	0.351				
TP	RFS		0.775	0.400		0.000	0.375

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.192	0.192				
Z	0.000	0.209	0.209				
TP	RFS		0.568	0.400		0.000	0.168

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.140	0.140				
Z	0.000	0.174	0.174				
TP	RFS		0.445	0.400		0.000	0.045

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.208	0.208				
Z	0.000	0.021	0.020				
TP	RFS		0.419	0.400		0.000	0.019

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.224	0.224				
Z	0.000	0.022	0.021				
TP	RFS		0.449	0.400		0.000	0.049

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.068	0.068				
Z	0.000	0.009	0.009				
TP	RFS		0.138	0.400		0.000	0.000

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

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

True Position plots from 3 views
x1000

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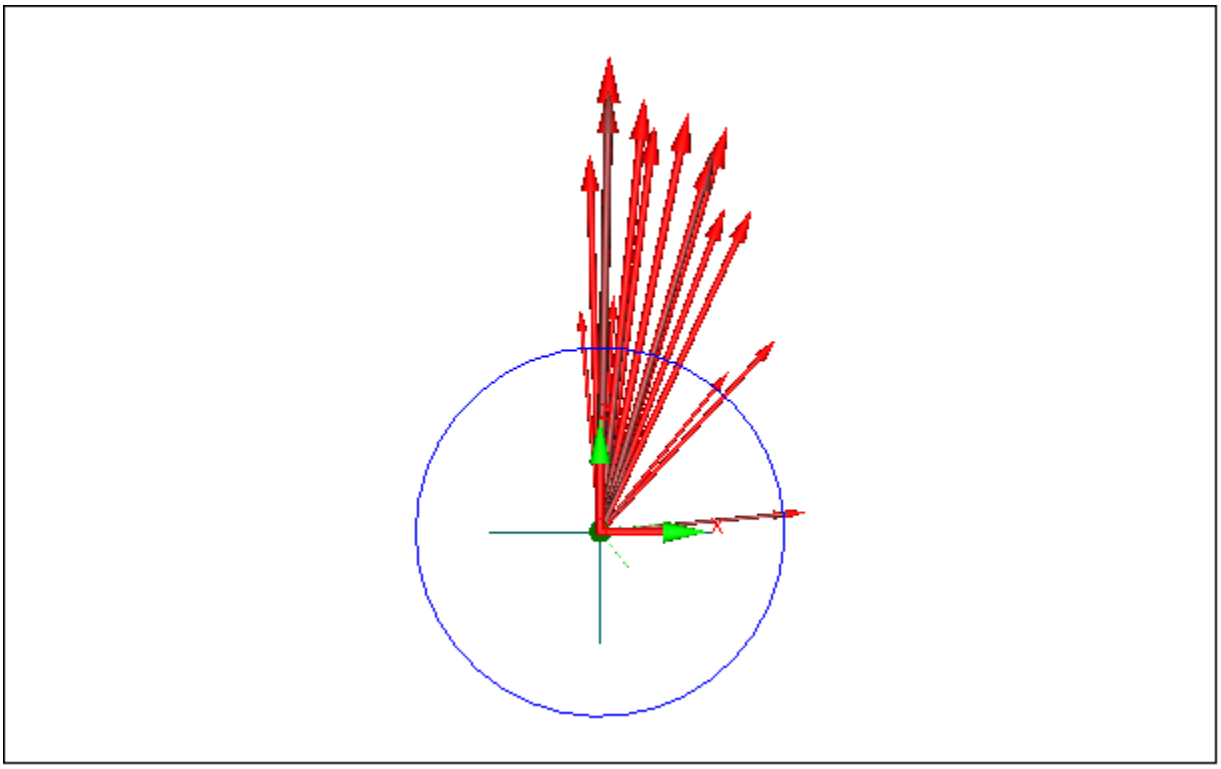
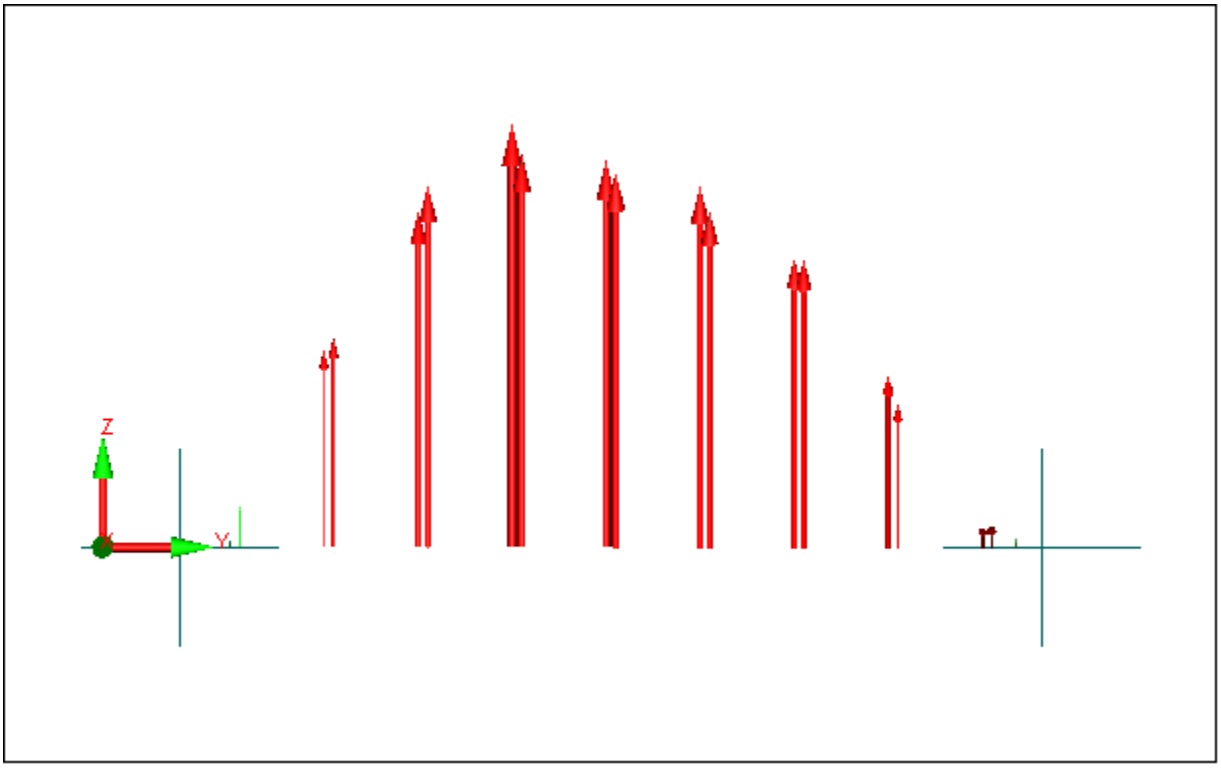
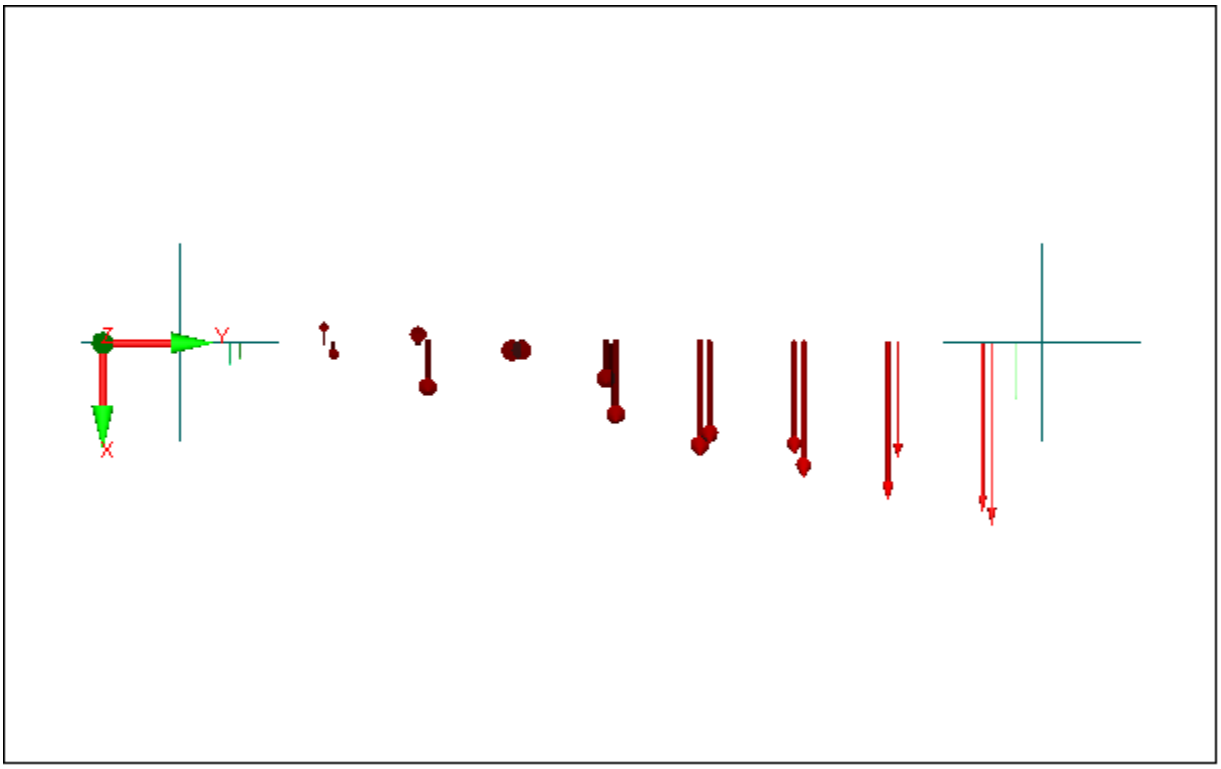


-Y View
x1000



+X View
x1000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY v3 TB9ACC016-180 IR DATE=6/5/2008



+Z View
x1000

MM	DIM LOC-BEST FIT CONSTRUCTED LINE= LOCATION OF LINE LNC-BEST-FIT					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.076	0.076	0.200	0.200	0.000
Y	0.000	620.665	620.665	2000.000	2000.000	0.000
Z	0.000	0.240	0.240	0.200	0.200	0.040
ST	0.000	0.572	0.572	0.200	0.000	0.372

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SUPPORT RING CIRCLE LOCATIONS

MM	DIM LOC-SUPPORT RING-1= LOCATION OF CIRCLE CR-SUPPORT-RING-T12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.015	0.015	0.200	0.200	0.000
Y	0.000	217.987	217.987	2000.000	2000.000	0.000
Z	0.000	0.125	0.125	0.200	0.200	0.000
R	56.500	56.412	-0.088	0.200	0.200	0.000
RN	0.000	0.010	0.010	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-2= LOCATION OF CIRCLE CR-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.032	-0.032	0.200	0.200	0.000
Y	0.000	333.124	333.124	2000.000	2000.000	0.000
Z	0.000	0.303	0.303	0.200	0.200	0.103
R	56.500	56.409	-0.091	0.200	0.200	0.000
RN	0.000	0.019	0.019	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	-0.059	-0.059	0.200	0.200	0.000
Y	0.000	448.452	448.452	2000.000	2000.000	0.000
Z	0.000	0.411	0.411	0.200	0.200	0.211
R	56.500	56.375	-0.125	0.200	0.200	0.000
RN	0.000	0.001	0.001	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	0.084	0.084	0.200	0.200	0.000
Y	0.000	563.785	563.785	2000.000	2000.000	0.000
Z	0.000	0.520	0.520	0.200	0.200	0.320
R	56.500	56.374	-0.126	0.200	0.200	0.000
RN	0.000	0.012	0.012	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-5= LOCATION OF CIRCLE CR-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.114	0.114	0.200	0.200	0.000
Y	0.000	678.891	678.891	2000.000	2000.000	0.000
Z	0.000	0.304	0.304	0.200	0.200	0.104
R	56.500	56.376	-0.124	0.200	0.200	0.000
RN	0.000	0.048	0.048	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	0.172	0.172	0.200	0.200	0.000
Y	0.000	794.093	794.093	2000.000	2000.000	0.000
Z	0.000	0.405	0.405	0.200	0.200	0.205
R	56.500	56.388	-0.112	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-7= LOCATION OF CIRCLE CR-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.157	0.157	0.200	0.200	0.000
Y	0.000	908.990	908.990	2000.000	2000.000	0.000
Z	0.000	0.240	0.240	0.200	0.200	0.040
R	56.500	56.368	-0.132	0.200	0.200	0.000
RN	0.000	0.028	0.028	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-8= LOCATION OF CIRCLE CR-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.193	0.193	0.200	0.200	0.000
Y	0.000	1024.285	1024.285	2000.000	2000.000	0.000
Z	0.000	0.074	0.074	0.200	0.200	0.000
R	56.500	56.417	-0.083	0.200	0.200	0.000
RN	0.000	0.017	0.017	0.200	0.000	0.000

SUPPORT RING POINT LOCATIONS

SUPPORT RING CIRCLES IN Z

MM	DIM LOC Z SUPPORT RING CIRCLES 1= LOCATION OF CIRCLE CR-SUPPORT-RING-T1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	0.125	0.125	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	0.303	0.303	0.200	0.200	0.103

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	0.411	0.411	0.200	0.200	0.211

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	0.520	0.520	0.200	0.200	0.320

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	0.304	0.304	0.200	0.200	0.104

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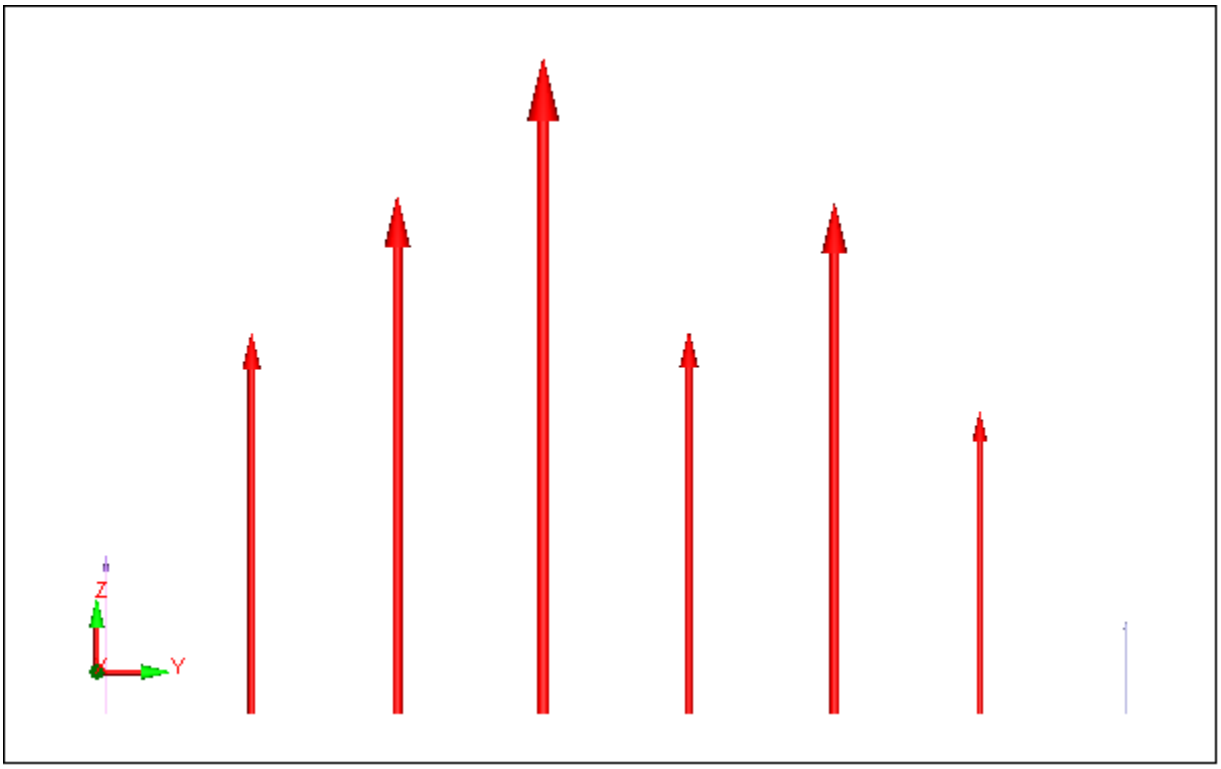
MM	DIM LOC Z SUPPORT RING CIRCLES 6= LOCATION OF CIRCLE CR-SUPPORT-RING-T6					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	0.405	0.405	0.200	0.200	0.205

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	0.240	0.240	0.200	0.200	0.040

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	0.074	0.074	0.200	0.200	0.000



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	-56.307	0.193	0.200	0.200	0.000

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MM	DIM LOC Z SUPPORT RING POINTS 2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	-56.500	-56.105	0.395	0.200	0.200	0.195

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	-55.957	0.543	0.200	0.200	0.343

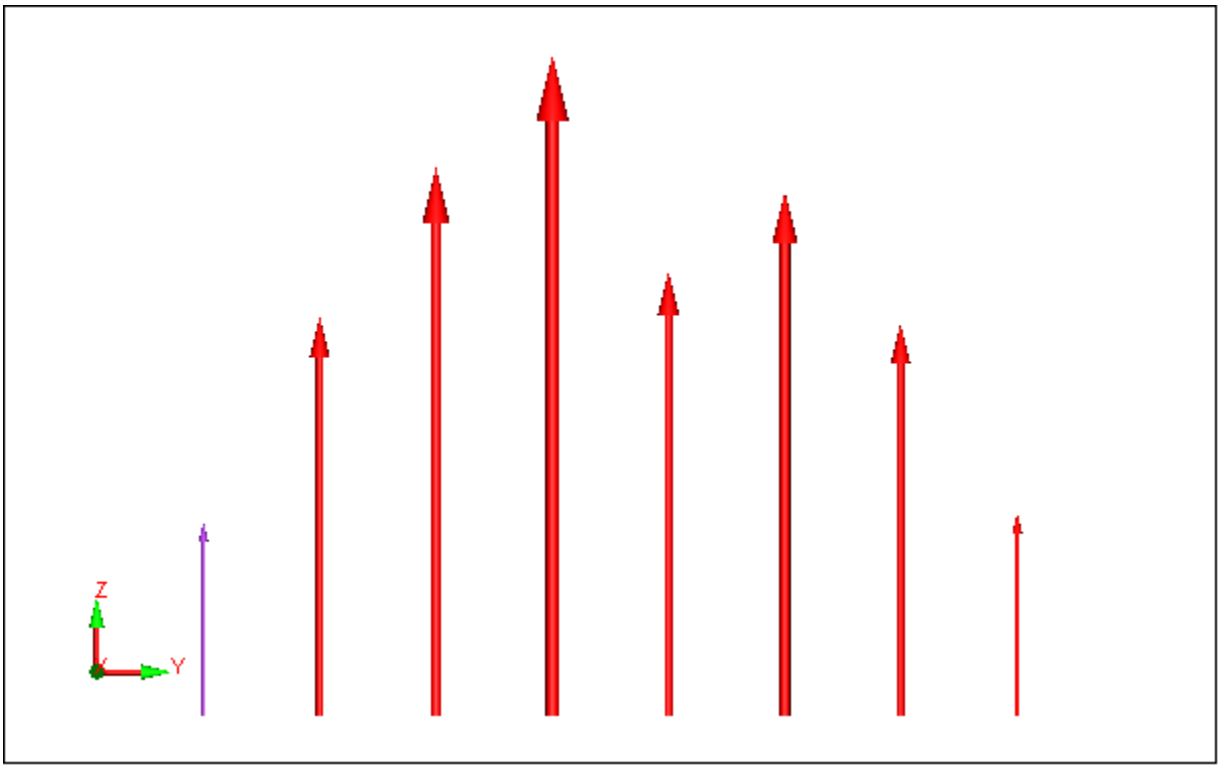
MM	DIM LOC Z SUPPORT RING POINTS 4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	-56.500	-55.845	0.655	0.200	0.200	0.455

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	-56.060	0.440	0.200	0.200	0.240

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	-55.980	0.520	0.200	0.200	0.320

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	-56.111	0.389	0.200	0.200	0.189

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	-56.298	0.202	0.200	0.200	0.002



PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY v3 TB9ACC016-180 IR DATE=6/5/2008
SUPPORT RING POINTS IN Z
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY v3 TB9ACC016-180 IR D
WG= SN=
TOTAL # OF MEAS =315 # OUT OF TOL =120