FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=5/19/2008 TIME=4:26:39 PM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY v2 000000000-180 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 TB9ACC017
' ' : 0805131009

Measure a 5 point circle on Main Output Coupler
front to back
Measure a point from +Y on far flange end to set temo -Y- zero later
delete next three features after AL-DCC is modified

delete next feature after you redo dcc alighnent

MM	DIM TEMP2= FLATNESS OF PLANE PL-NW12-FLANGE O-RING					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.005	0.005	0.010	0.000	0.000

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	0.000			
FL	0.000	0.017	0.017	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	0.158	0.158	0.200	0.000	0.000

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.073	0.073	0.100	0.100	0.000

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MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END -FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.103	-0.103	0.200	0.200	0.000
Z	0.000	0.095	0.095	0.200	0.200	0.000
D	140.000	140.058	0.058	0.300	0.300	0.000
RN	0.000	0.006	0.006	0.200	0.000	0.000

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

⊕ MM	DIM TP NBPF BH7= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 195						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.965	-0.035				
PA	-165.000	-165.147	-0.147				
DF	8.800	8.836	0.036	0.300	0.300		0.000
TP	RFS		0.315	0.300		0.000	0.015
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	59.958	-0.043				
PA	-135.000	-135.114	-0.114				
DF	8.800	8.835	0.035	0.300	0.300		0.000
TP	RFS		0.253	0.300		0.000	0.000
RN	0.000	0.023	0.023	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	59.950	-0.051				
PA	-105.000	-105.139	-0.139				
DF	8.800	8.834	0.034	0.300	0.300		0.000
TP	RFS		0.308	0.300		0.000	0.008
RN	0.000	0.016	0.016	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	59.967	-0.033				
PA	-75.000	-75.135	-0.135				
DF	8.800	8.833	0.033	0.300	0.300		0.000
TP	RFS		0.291	0.300		0.000	0.000
RN	0.000	0.013	0.013	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	59.953	-0.047				
PA	-45.000	-45.123	-0.123				
DF	8.800	8.852	0.052	0.300	0.300		0.000
TP	RFS		0.274	0.300		0.000	0.000
RN	0.000	0.013	0.013	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	59.947	-0.053				
PA	-15.000	-15.136	-0.136				
DF	8.800	8.826	0.026	0.300	0.300		0.000
TP	RFS		0.304	0.300		0.000	0.004
RN	0.000	0.023	0.023	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	1242.349	-5.051	3.000	3.000	2.051
V	0.001	1.000	-0.003			
FL	0.000	0.030	0.030	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	0.360	0.360	0.200	0.000	0.160

DEG	DIM ANGL2= 3D ANGLE (COMPLEMENT) FROM PLANE PL-FAR-END TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.168	0.168	0.100	0.100	0.068

MM	DIM LOC4= LOCATION OF CIRCLE CR-FAR-END					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.020	-0.020	0.200	0.200	0.000
Z	0.000	-0.277	-0.277	0.200	0.200	0.077
D	140.000	140.076	0.076	0.300	0.300	0.000
RN	0.000	0.007	0.007	0.200	0.000	0.000

MM	DIM DIST01= 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	1.101	0.101	0.100	0.100	0.001

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	59.920	-0.080				
PA	-165.000	-165.217	-0.217				
DF	8.800	8.839	0.039	0.300	0.300		0.000
TP	RFS		0.482	0.300		0.000	0.182
RN	0.000	0.016	0.016	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	59.936	-0.064				
PA	-135.000	-135.221	-0.221				
DF	8.800	8.824	0.024	0.300	0.300		0.000
TP	RFS		0.480	0.300		0.000	0.180
RN	0.000	0.016	0.016	0.300	0.000		0.000

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MM DIM TP FBPF BH9= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 255

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.956	-0.044				
PA	-105.000	-105.242	-0.242				
DF	8.800	8.830	0.030	0.300	0.300		0.000
TP	RFS		0.514	0.300		0.000	0.214
RN	0.000	0.016	0.016	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	59.969	-0.031				
PA	-75.000	-75.199	-0.199				
DF	8.800	8.834	0.034	0.300	0.300		0.000
TP	RFS		0.420	0.300		0.000	0.120
RN	0.000	0.016	0.016	0.300	0.000		0.000

MM DIM TP FBPF BH11= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 315

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.949	-0.051				
PA	-45.000	-45.238	-0.238				
DF	8.800	8.818	0.018	0.300	0.300		0.000
TP	RFS		0.508	0.300		0.000	0.208
RN	0.000	0.014	0.014	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	59.941	-0.059				
PA	-15.000	-15.230	-0.230				
DF	8.800	8.828	0.028	0.300	0.300		0.000
TP	RFS		0.496	0.300		0.000	0.196
RN	0.000	0.018	0.018	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	93.032	0.192	0.200	0.200	0.000
V	-0.002	-1.000	-0.000			
FL	0.000	0.043	0.043	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	0.237	0.237	0.200	0.000	0.037

DEG DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.132	0.132	0.100	0.100	0.032

DATUM-2-PLANE

MM	DIM LOC-DATUM-2-PLANE= LOCATION OF PLANE PLC-DAT-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1154.600	1148.742	-5.858	0.200	0.200	5.658
V	-0.002	1.000	-0.003			
FL	0.000	0.015	0.015	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	0.366	0.366	0.200	0.000	0.166

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.203	0.203	0.100	0.100	0.103

MM	DIM DIST03= 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	1055.710	-5.350	0.200	0.200	5.150

MM	DIM DIST04= 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	93.606	0.106	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	-53.910	-0.110	0.200	0.200	0.000
V	-1.000	-0.001	-0.002			
FL	0.000	0.002	0.002	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	0.066	0.066	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	0.158	0.158	0.100	0.100	0.058

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MM	DIM LOC6= LOCATION OF CIRCLE CR-NW8-ANTENNA-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.600	0.000	0.200	0.200	0.000
Z	0.000	0.128	0.128	0.200	0.200	0.000
D	33.800	33.842	0.042	0.150	0.000	0.000
RN	0.000	0.014	0.014	0.150	0.000	0.000

MAIN COUPLER FLANGE NW40

MM	DIM LOC7= LOCATION OF PLANE PL-NW-40-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	88.000	87.736	-0.264	0.200	0.200	0.064
V	1.000	-0.000	-0.002			
FL	0.000	0.024	0.024	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	0.120	0.120	0.200	0.000	0.000

DEG	DIM ANGL4= 3D ANGLE (TRUE) FROM PLANE PL-NW-40-FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.114	0.114	0.100	0.100	0.014

MM	DIM LOC8= LOCATION OF CIRCLE CR-NW-40-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1181.792	-5.008	0.200	0.200	4.808
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	75.998	-0.002	0.200	0.000	0.002
RN	0.000	0.008	0.008	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	60.556	-0.044	0.200	0.200	0.000

HOM-1 FLANGE NW12

MM	DIM FLAT1= FLATNESS OF PLANE PL-NW12-FLANGE-HOM1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.007	0.007	0.200	0.000	0.000

DEG	DIM ANGL16= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM1 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	15.483	0.483	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	27.525	-0.895	0.100	0.100	0.795

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	27.533	-0.887	0.100	0.100	0.787

DEG	DIM ANGL17= 2D ANGLE (COMPLEMENT) FROM PLANE PL-NW12-FLANGE-HOM1 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.021	0.021	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	38.168	38.168	100.000	100.000	0.000
Y	0.000	56.620	56.620	100.000	100.000	0.000
Z	0.000	-61.923	-61.923	100.000	100.000	0.000
D	33.800	34.055	0.255	0.150	0.000	0.105
RN	0.000	0.358	0.358	0.150	0.000	0.208

HOM-2 FLANGE NW12

MM	DIM = FLATNESS OF PLANE PL-NW12-FLANGE-HOM-2					
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-HOM-2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	15.447	0.447	0.500	0.500	0.000

DEG	DIM ANGL6= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM-2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	35.207	0.207	0.500	0.500	0.000

MM	DIM LOC9= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	73.435	73.435	100.000	100.000	0.000
Y	0.000	1186.997	1186.997	2000.000	2000.000	0.000
Z	0.000	7.291	7.291	100.000	100.000	0.000
D	33.800	33.706	-0.094	0.150	0.000	0.094
RN	0.000	0.035	0.035	0.150	0.000	0.000

HOM 1 LOCATION

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MM	DIM LOC-HOM1= LOCATION OF CYLINDER CY-HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	68.563	68.563	100.000	100.000	0.000
Y	60.600	60.465	-0.135	0.200	0.200	0.000
Z	0.000	-39.974	-39.974	100.000	100.000	0.000
D	44.000	43.865	-0.135	0.000	0.100	0.035
RN	0.000	0.140	0.140	0.100	0.000	0.040
V	-0.865	0.003	0.501			

DEG	DIM ANGL9= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	30.085	0.085	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	90.169	0.169	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	59.915	-0.085	0.500	0.500	0.000

MM	DIM LOC-HOM3= LOCATION OF POINT PT-RT-HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.033	0.033	0.200	0.200	0.000

INTERSECTION OF HOM1 & YZ PLANE

MM	DIM LOC-HOM1 X PLANE= LOCATION OF POINT PTC-HOM1 X YZ PLANE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	60.600	60.698	0.098	0.200	0.200	0.000
Z	0.000	-0.253	-0.253	0.200	0.200	0.053

HOM 2 LOCATION

MM	DIM LOC-HOM2= LOCATION OF CYLINDER CY-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-64.751	-64.751	100.000	100.000	0.000
Y	1186.800	1182.523	-4.277	3.000	3.000	1.277
Z	0.000	-45.574	-45.574	100.000	100.000	0.000
D	44.000	43.830	-0.170	0.000	0.100	0.070
RN	0.000	0.094	0.094	0.100	0.000	0.000
V	-0.820	-0.002	-0.572			

MM	DIM DIST2= 2D DISTANCE FROM POINT PT-HOM-2 TO PLANE PL-FAR-END PAR TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	60.600	59.389	-1.211	0.200	0.200	1.011

DEG	DIM ANGL12= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.871	-0.129	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	90.089	0.089	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	55.129	0.129	0.500	0.500	0.000

MM	DIM LOC-HOM4= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.277	0.277	0.200	0.200	0.077

INTERSECTION OF HOM2 & YZ PLANE

MM	DIM LOC-HOM2 X PLANE= LOCATION OF POINT PTC-HOM2 X YZ PLANE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	1186.800	1182.645	-4.155	3.000	3.000	1.155
Z	0.000	-0.451	-0.451	0.200	0.200	0.251

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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	95.074	95.074	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.893	-0.107	0.050	0.050	0.057
RN	0.000	0.021	0.021	0.050	0.000	0.000

MM DIM LOC-CC2= LOCATION OF CIRCLE CRC-VAC-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.042	0.042	0.200	0.200	0.000
Y	0.000	123.227	123.227	2000.000	2000.000	0.000
Z	0.000	-0.013	-0.013	0.200	0.200	0.000
D	191.200	191.221	0.021	0.200	0.200	0.000
RN	0.000	0.061	0.061	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	0.072	0.072	0.200	0.200	0.000
Y	0.000	156.579	156.579	2000.000	2000.000	0.000
Z	0.000	0.128	0.128	0.200	0.200	0.000
D	210.300	210.702	0.402	0.200	0.200	0.202
RN	0.000	0.218	0.218	0.200	0.000	0.018

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.083	0.083	0.200	0.200	0.000
Y	0.000	167.556	167.556	2000.000	2000.000	0.000
Z	0.000	0.151	0.151	0.200	0.200	0.000
D	210.300	210.638	0.338	0.200	0.200	0.138
RN	0.000	0.159	0.159	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	0.109	0.109	0.200	0.200	0.000
Y	0.000	270.825	270.825	2000.000	2000.000	0.000
Z	0.000	0.318	0.318	0.200	0.200	0.118
D	210.300	210.660	0.360	0.200	0.200	0.160
RN	0.000	0.125	0.125	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	0.108	0.108	0.200	0.200	0.000
Y	0.000	281.768	281.768	2000.000	2000.000	0.000
Z	0.000	0.324	0.324	0.200	0.200	0.124
D	210.300	210.583	0.283	0.200	0.200	0.083
RN	0.000	0.083	0.083	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	0.111	0.111	0.200	0.200	0.000
Y	0.000	385.669	385.669	2000.000	2000.000	0.000
Z	0.000	0.488	0.488	0.200	0.200	0.288
D	210.300	210.626	0.326	0.200	0.200	0.126
RN	0.000	0.151	0.151	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	0.111	0.111	0.200	0.200	0.000
Y	0.000	397.074	397.074	2000.000	2000.000	0.000
Z	0.000	0.527	0.527	0.200	0.200	0.327
D	210.300	210.588	0.288	0.200	0.200	0.088
RN	0.000	0.128	0.128	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	0.201	0.201	0.200	0.200	0.001
Y	0.000	500.106	500.106	2000.000	2000.000	0.000
Z	0.000	0.635	0.635	0.200	0.200	0.435
D	210.300	210.714	0.414	0.200	0.200	0.214
RN	0.000	0.183	0.183	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	0.195	0.195	0.200	0.200	0.000
Y	0.000	511.181	511.181	2000.000	2000.000	0.000
Z	0.000	0.627	0.627	0.200	0.200	0.427
D	210.300	210.548	0.248	0.200	0.200	0.048
RN	0.000	0.199	0.199	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	0.225	0.225	0.200	0.200	0.025
Y	0.000	615.780	615.780	2000.000	2000.000	0.000
Z	0.000	0.649	0.649	0.200	0.200	0.449
D	210.300	210.602	0.302	0.200	0.200	0.102
RN	0.000	0.162	0.162	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	0.249	0.248	0.200	0.200	0.048
Y	0.000	626.504	626.504	2000.000	2000.000	0.000
Z	0.000	0.655	0.655	0.200	0.200	0.455
D	210.300	210.554	0.254	0.200	0.200	0.054
RN	0.000	0.193	0.193	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	0.232	0.231	0.200	0.200	0.031
Y	0.000	730.254	730.254	2000.000	2000.000	0.000
Z	0.000	0.621	0.621	0.200	0.200	0.421
D	210.300	210.666	0.366	0.200	0.200	0.166
RN	0.000	0.145	0.145	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	0.233	0.232	0.200	0.200	0.032
Y	0.000	741.079	741.079	2000.000	2000.000	0.000
Z	0.000	0.629	0.629	0.200	0.200	0.429
D	210.300	210.602	0.302	0.200	0.200	0.102
RN	0.000	0.204	0.204	0.200	0.000	0.004

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.234	0.234	0.200	0.200	0.034
Y	0.000	845.388	845.388	2000.000	2000.000	0.000
Z	0.000	0.515	0.515	0.200	0.200	0.315
D	210.300	210.624	0.324	0.200	0.200	0.124
RN	0.000	0.206	0.206	0.200	0.000	0.006

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.228	0.228	0.200	0.200	0.028
Y	0.000	856.492	856.492	2000.000	2000.000	0.000
Z	0.000	0.471	0.471	0.200	0.200	0.271
D	210.300	210.627	0.327	0.200	0.200	0.127
RN	0.000	0.230	0.230	0.200	0.000	0.030

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.207	0.207	0.200	0.200	0.007
Y	0.000	960.211	960.211	2000.000	2000.000	0.000
Z	0.000	0.296	0.295	0.200	0.200	0.095
D	210.300	210.611	0.311	0.200	0.200	0.111
RN	0.000	0.104	0.104	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	0.199	0.199	0.200	0.200	0.000
Y	0.000	971.330	971.330	2000.000	2000.000	0.000
Z	0.000	0.312	0.311	0.200	0.200	0.111
D	210.300	210.573	0.273	0.200	0.200	0.073
RN	0.000	0.154	0.154	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	0.156	0.156	0.200	0.200	0.000
Y	0.000	1074.965	1074.965	2000.000	2000.000	0.000
Z	0.000	0.066	0.066	0.200	0.200	0.000
D	210.300	210.592	0.292	0.200	0.200	0.092
RN	0.000	0.262	0.262	0.200	0.000	0.062

MM DIM LOC-CC20= LOCATION OF CIRCLE CRC-CAV-9-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.156	0.156	0.200	0.200	0.000
Y	0.000	1085.975	1085.975	2000.000	2000.000	0.000
Z	0.000	0.062	0.062	0.200	0.200	0.000
D	210.300	210.729	0.429	0.200	0.200	0.229
RN	0.000	0.166	0.166	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	0.067	0.067	0.200	0.200	0.000
Y	0.000	1115.770	1115.770	2000.000	2000.000	0.000
Z	0.000	0.091	0.091	0.200	0.200	0.000
D	200.000	200.002	0.002	0.200	0.200	0.000
RN	0.000	0.027	0.027	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	1146.466	1146.466	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	0.018	0.018	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	0.042	0.042				
Z	0.000	-0.013	-0.013				
TP	RFS		0.088	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	0.072	0.072				
Z	0.000	0.128	0.128				
TP	RFS		0.294	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	0.083	0.083				
Z	0.000	0.151	0.151				
TP	RFS		0.344	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	0.109	0.109				
Z	0.000	0.318	0.318				
TP	RFS		0.672	0.400		0.000	0.272

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.108	0.108				
Z	0.000	0.324	0.324				
TP	RFS		0.683	0.400		0.000	0.283

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.111	0.111				
Z	0.000	0.488	0.488				
TP	RFS		1.000	0.400		0.000	0.600

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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	0.111	0.111				
Z	0.000	0.527	0.527				
TP	RFS		1.076	0.400		0.000	0.676

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.201	0.201				
Z	0.000	0.635	0.635				
TP	RFS		1.333	0.400		0.000	0.933

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.195	0.195				
Z	0.000	0.627	0.627				
TP	RFS		1.313	0.400		0.000	0.913

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.225	0.225				
Z	0.000	0.649	0.649				
TP	RFS		1.374	0.400		0.000	0.974

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.249	0.248				
Z	0.000	0.655	0.655				
TP	RFS		1.401	0.400		0.000	1.001

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.232	0.231				
Z	0.000	0.621	0.621				
TP	RFS		1.325	0.400		0.000	0.925

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.233	0.232				
Z	0.000	0.629	0.629				
TP	RFS		1.341	0.400		0.000	0.941

⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.234	0.234				
Z	0.000	0.515	0.515				
TP	RFS		1.132	0.400		0.000	0.732

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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	0.228	0.228				
Z	0.000	0.471	0.471				
TP	RFS		1.046	0.400		0.000	0.646

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.207	0.207				
Z	0.000	0.296	0.295				
TP	RFS		0.721	0.400		0.000	0.321

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.199	0.199				
Z	0.000	0.312	0.311				
TP	RFS		0.739	0.400		0.000	0.339

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.156	0.156				
Z	0.000	0.066	0.066				
TP	RFS		0.339	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.156	0.156				
Z	0.000	0.062	0.062				
TP	RFS		0.336	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.067	0.067				
Z	0.000	0.091	0.091				
TP	RFS		0.226	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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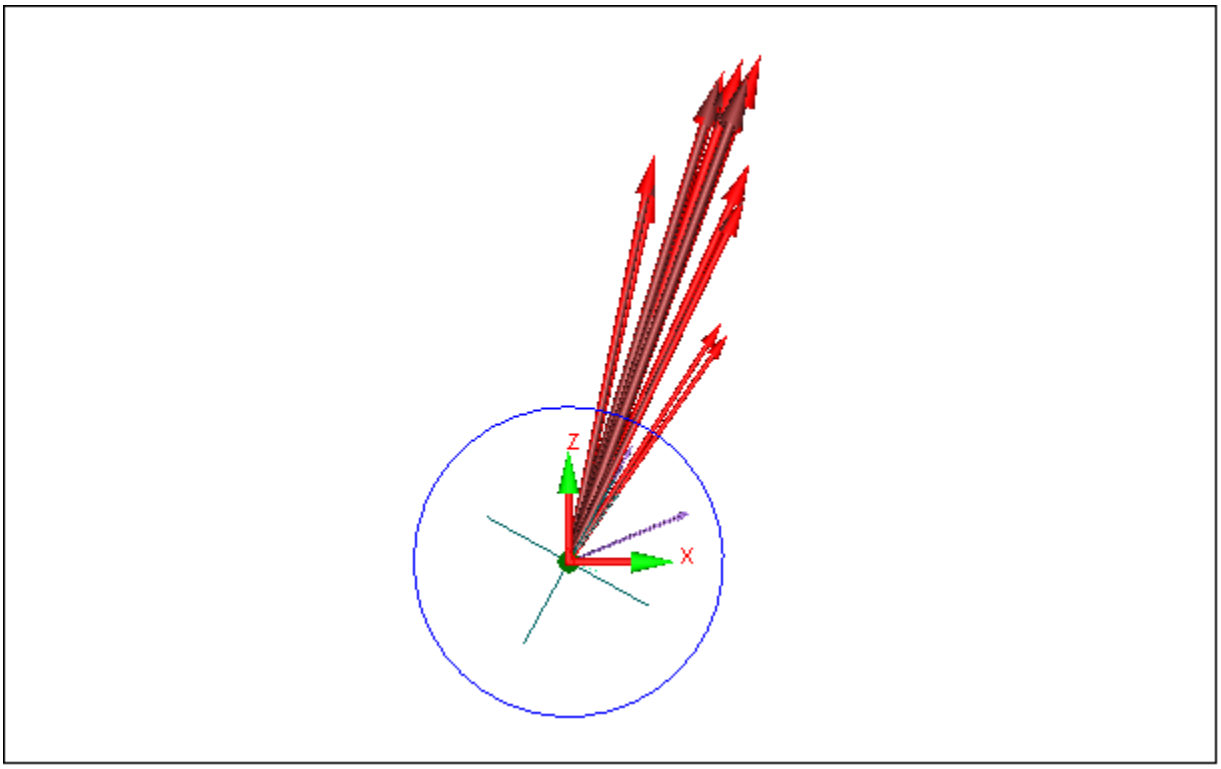
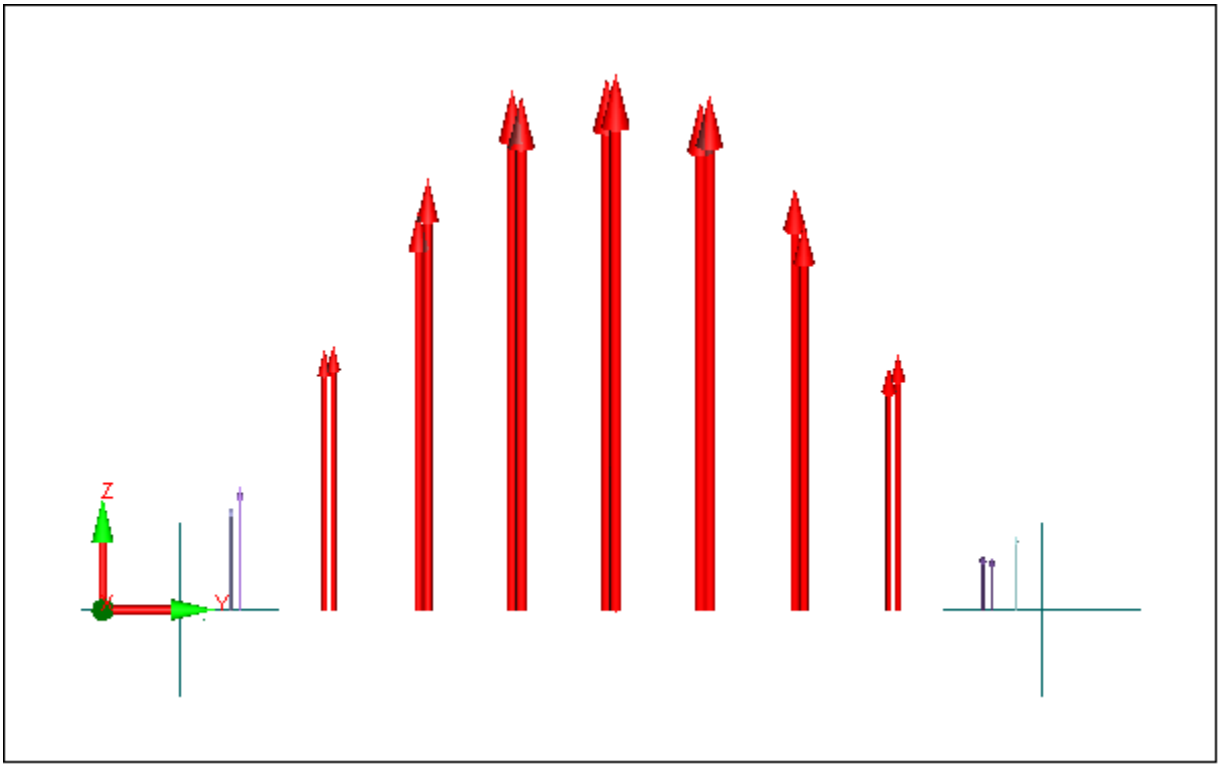
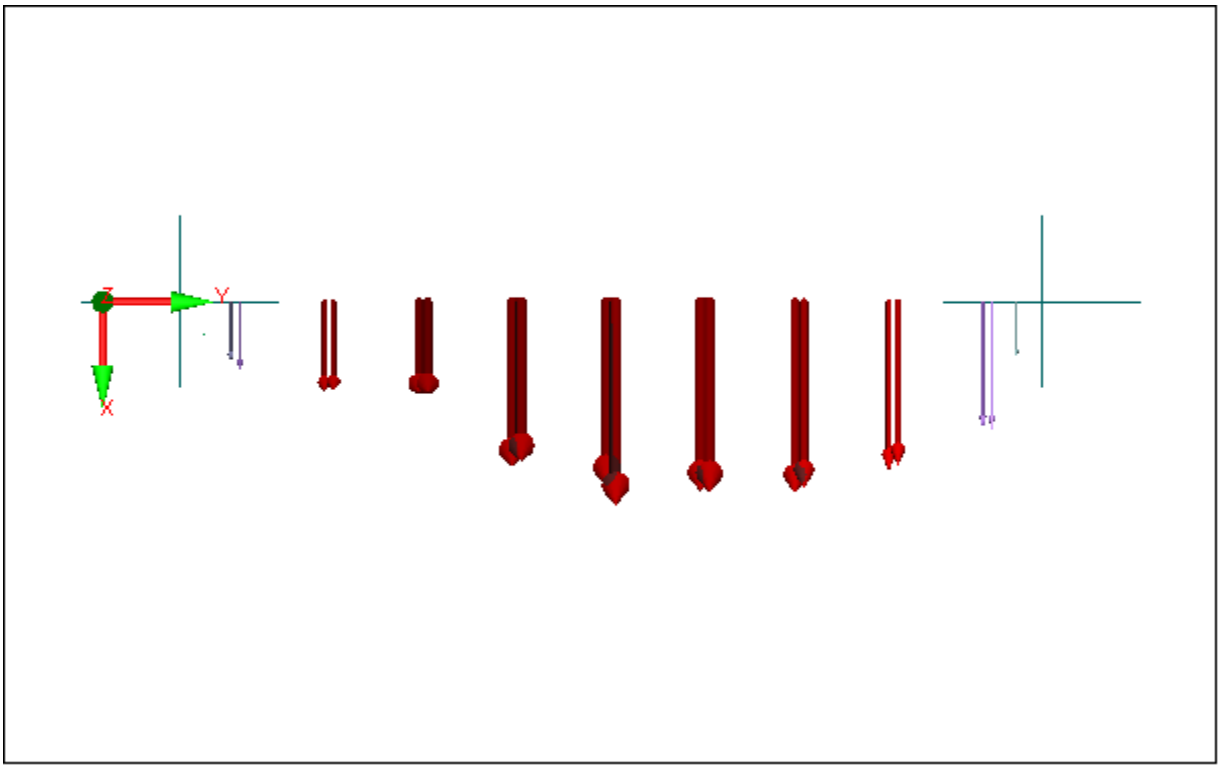


-Y View
x1000



+X View
x1000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY v2 000000000-180 IR DATE=5/19/2008



+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	0.146	0.146	0.200	0.200	0.000
Y	0.000	620.876	620.876	2000.000	2000.000	0.000
Z	0.000	0.343	0.343	0.200	0.200	0.143
ST	0.000	0.710	0.710	0.200	0.000	0.510

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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	0.116	0.116	0.200	0.200	0.000
Y	0.000	218.062	218.062	2000.000	2000.000	0.000
Z	0.000	0.156	0.156	0.200	0.200	0.000
R	56.500	56.350	-0.150	0.200	0.200	0.000
RN	0.000	0.024	0.024	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	0.102	0.102	0.200	0.200	0.000
Y	0.000	333.195	333.195	2000.000	2000.000	0.000
Z	0.000	0.374	0.374	0.200	0.200	0.174
R	56.500	56.402	-0.098	0.200	0.200	0.000
RN	0.000	0.032	0.032	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	0.139	0.139	0.200	0.200	0.000
Y	0.000	448.528	448.528	2000.000	2000.000	0.000
Z	0.000	0.572	0.572	0.200	0.200	0.372
R	56.500	56.324	-0.176	0.200	0.200	0.000
RN	0.000	0.018	0.018	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	0.203	0.203	0.200	0.200	0.003
Y	0.000	563.864	563.864	2000.000	2000.000	0.000
Z	0.000	0.565	0.565	0.200	0.200	0.365
R	56.500	56.358	-0.142	0.200	0.200	0.000
RN	0.000	0.018	0.018	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	0.263	0.263	0.200	0.200	0.063
Y	0.000	678.963	678.963	2000.000	2000.000	0.000
Z	0.000	0.630	0.630	0.200	0.200	0.430
R	56.500	56.329	-0.171	0.200	0.200	0.000
RN	0.000	0.014	0.014	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	0.240	0.240	0.200	0.200	0.040
Y	0.000	794.164	794.164	2000.000	2000.000	0.000
Z	0.000	0.518	0.518	0.200	0.200	0.318
R	56.500	56.425	-0.075	0.200	0.200	0.000
RN	0.000	0.013	0.013	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	0.236	0.236	0.200	0.200	0.036
Y	0.000	909.060	909.060	2000.000	2000.000	0.000
Z	0.000	0.436	0.436	0.200	0.200	0.236
R	56.500	56.414	-0.086	0.200	0.200	0.000
RN	0.000	0.031	0.031	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	0.195	0.195	0.200	0.200	0.000
Y	0.000	1024.364	1024.364	2000.000	2000.000	0.000
Z	0.000	0.109	0.109	0.200	0.200	0.000
R	56.500	56.349	-0.151	0.200	0.200	0.000
RN	0.000	0.032	0.032	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	0.156	0.156	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	0.374	0.374	0.200	0.200	0.174

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	0.572	0.572	0.200	0.200	0.372

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	0.565	0.565	0.200	0.200	0.365

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	0.630	0.630	0.200	0.200	0.430

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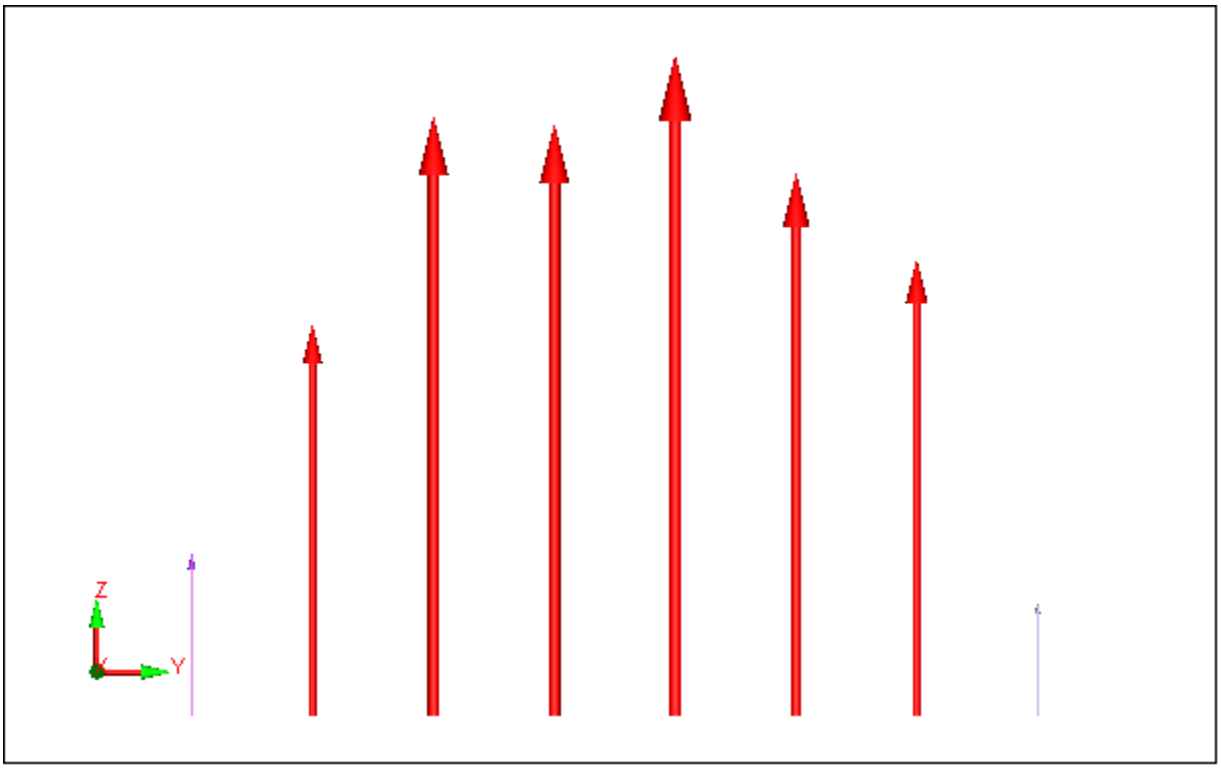
MM	DIM LOC Z SUPPORT RING CIRCLES 6= LOCATION OF CIRCLE CR-SUPPORT-RING-T6					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	0.518	0.518	0.200	0.200	0.318

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	0.436	0.436	0.200	0.200	0.236

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	0.109	0.109	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	-56.193	0.307	0.200	0.200	0.107

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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	-56.005	0.495	0.200	0.200	0.295

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	-55.767	0.733	0.200	0.200	0.533

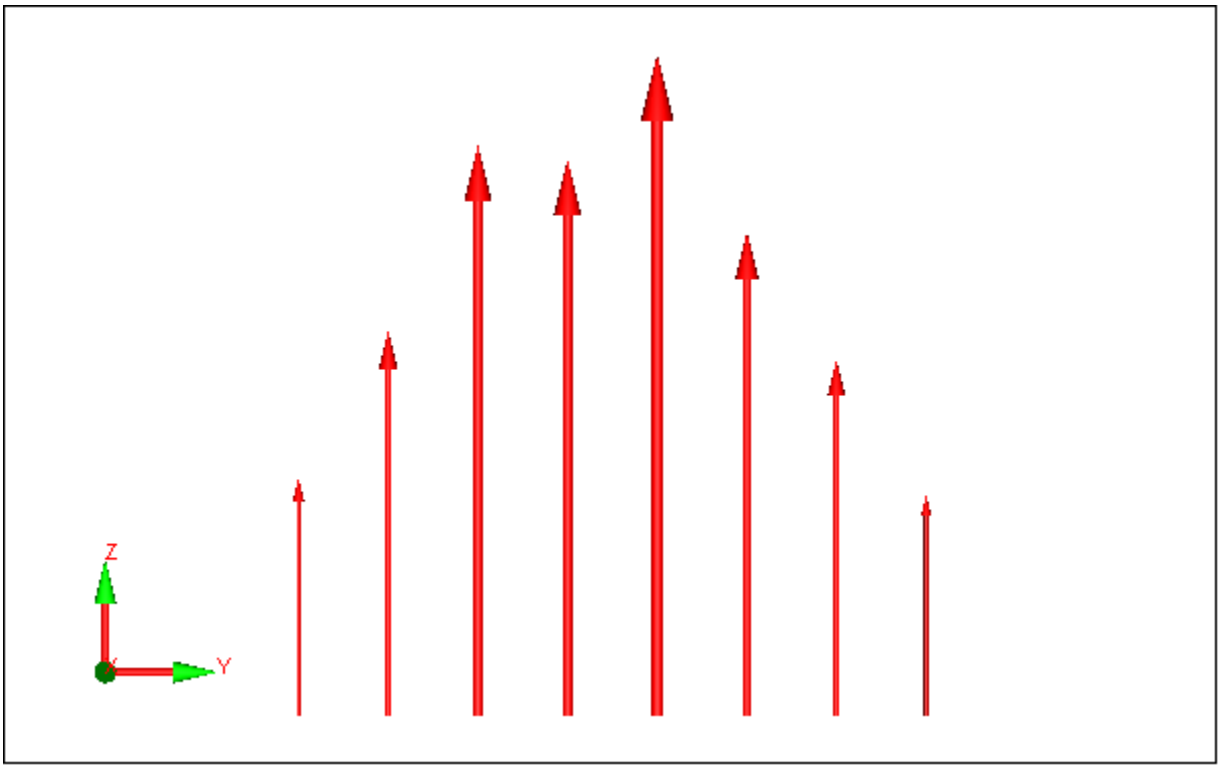
MM	DIM LOC Z SUPPORT RING POINTS 4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	-56.500	-55.785	0.715	0.200	0.200	0.515

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	-55.651	0.849	0.200	0.200	0.649

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	-55.878	0.622	0.200	0.200	0.422

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	-56.042	0.458	0.200	0.200	0.258

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	-56.215	0.285	0.200	0.200	0.085



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SUPPORT RING POINTS IN Z
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY v2 000000000-180 IR D
WG= SN=
TOTAL # OF MEAS =303 # OUT OF TOL =126