FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=3/2/2009 TIME=1:31:05 PM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s 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' : AES TB9AES007
' ' : 0902260605

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	-0.002	-1.000	0.000			
FL	0.000	0.045	0.045	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	0.280	0.280	0.200	0.000	0.080

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.132	0.132	0.100	0.100	0.032

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.012	0.012	0.200	0.200	0.000
Z	0.000	0.048	0.047	0.200	0.200	0.000
D	140.000	139.997	-0.003	0.300	0.300	0.000
RN	0.000	0.000	0.000	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	561.050	560.050	0.100	0.100	559.950

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

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

⊕ MM	DIM TP NBPF BH7= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 195						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	60.094	0.094				
PA	-165.000	-166.507	-1.507				
DF	8.800	8.759	-0.041	0.300	0.300		0.000
TP	RFS		3.164	0.300		0.000	2.864
RN	0.000	0.014	0.014	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	60.135	0.135				
PA	-135.000	-136.631	-1.631				
DF	8.800	8.758	-0.042	0.300	0.300		0.000
TP	RFS		3.430	0.300		0.000	3.130
RN	0.000	0.012	0.012	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	60.093	0.093				
PA	-105.000	-106.718	-1.718				
DF	8.800	8.760	-0.040	0.300	0.300		0.000
TP	RFS		3.605	0.300		0.000	3.305
RN	0.000	0.011	0.011	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	60.004	0.004				
PA	-75.000	-76.820	-1.820				
DF	8.800	8.760	-0.040	0.300	0.300		0.000
TP	RFS		3.813	0.300		0.000	3.513
RN	0.000	0.009	0.009	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	59.861	-0.139				
PA	-45.000	-46.746	-1.746				
DF	8.800	8.760	-0.040	0.300	0.300		0.000
TP	RFS		3.662	0.300		0.000	3.362
RN	0.000	0.010	0.010	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	59.799	-0.202				
PA	-15.000	-16.747	-1.747				
DF	8.800	8.765	-0.035	0.300	0.300		0.000
TP	RFS		3.675	0.300		0.000	3.375
RN	0.000	0.008	0.008	0.300	0.000		0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

BEAM PIPE FLANGE FAR

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1247.400	1252.821	5.421	3.000	3.000	2.421
V	0.001	1.000	-0.001			
FL	0.000	0.025	0.025	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	0.150	0.150	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.070	0.070	0.100	0.100	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.046	0.046	0.200	0.200	0.000
Z	0.000	-0.041	-0.041	0.200	0.200	0.000
D	140.000	140.012	0.012	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	1.007	0.007	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	60.083	0.083				
PA	-165.000	-165.807	-0.807				
DF	8.800	8.752	-0.048	0.300	0.300		0.000
TP	RFS		1.699	0.300		0.000	1.399
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	59.972	-0.028				
PA	-135.000	-135.860	-0.860				
DF	8.800	8.751	-0.049	0.300	0.300		0.000
TP	RFS		1.802	0.300		0.000	1.502
RN	0.000	0.011	0.011	0.300	0.000		0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

⊕ MM	DIM TP FBPF BH9= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 255						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	60.106	0.106				
PA	-105.000	-105.712	-0.712				
DF	8.800	8.752	-0.048	0.300	0.300		0.000
TP	RFS		1.507	0.300		0.000	1.207
RN	0.000	0.011	0.011	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	59.995	-0.005				
PA	-75.000	-75.850	-0.850				
DF	8.800	8.756	-0.044	0.300	0.300		0.000
TP	RFS		1.779	0.300		0.000	1.479
RN	0.000	0.014	0.014	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	59.896	-0.104				
PA	-45.000	-45.802	-0.802				
DF	8.800	8.753	-0.047	0.300	0.300		0.000
TP	RFS		1.691	0.300		0.000	1.391
RN	0.000	0.011	0.011	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	59.925	-0.075				
PA	-15.000	-15.751	-0.751				
DF	8.800	8.752	-0.048	0.300	0.300		0.000
TP	RFS		1.580	0.300		0.000	1.280
RN	0.000	0.009	0.009	0.300	0.000		0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

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	92.801	-0.039	0.200	0.200	0.000
V	-0.002	-1.000	-0.001			
FL	0.000	0.081	0.081	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	0.258	0.258	0.200	0.000	0.058

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.136	0.136	0.100	0.100	0.036

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	1159.341	4.781	0.200	0.200	4.581
V	0.003	1.000	-0.000			
FL	0.000	0.098	0.098	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	0.324	0.324	0.200	0.000	0.124

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.176	0.176	0.100	0.100	0.076

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	1066.540	5.480	0.200	0.200	5.280

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	93.481	-0.019	0.200	0.200	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

PICKUP ANTENNA FLANGE NW8

MM	DIM LOC5= LOCATION OF PLANE PL NW8 ANTENNA FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-53.800	-54.162	-0.362	0.200	0.200	0.162
V	-1.000	0.010	0.028			
FL	0.000	0.003	0.003	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	0.762	0.762	0.200	0.000	0.562

DEG	DIM ANGL3= 3D ANGLE (TRUE) FROM PLANE PL NW8 ANTENNA FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	1.720	1.720	0.100	0.100	1.620

MM	DIM LOC6= LOCATION OF CIRCLE CR_NW8_ANTENNA_FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.829	0.229	0.200	0.200	0.029
Z	0.000	1.823	1.823	0.200	0.200	1.623
D	33.800	33.855	0.055	0.150	0.000	0.000
RN	0.000	0.006	0.006	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	0.569	0.069	0.050	0.000	0.019

MAIN COUPLER FLANGE NW40

MM	DIM LOC7= LOCATION OF PLANE PL NW 40 FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	88.000	87.412	-0.588	0.200	0.200	0.388
V	1.000	-0.001	0.003			
FL	0.000	0.008	0.008	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	0.180	0.180	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	0.156	0.156	0.100	0.100	0.056

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM DIM LOC8= LOCATION OF CIRCLE CR_NW_40_FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1192.273	5.473	0.200	0.200	5.273
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	76.076	0.076	0.200	0.000	0.000
RN	0.000	0.010	0.010	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	60.548	-0.052	0.200	0.200	0.000

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	0.527	0.027	0.050	0.000	0.000

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	31.637	-0.113				
PA	112.500	112.816	0.316				
DF	6.700	6.820	0.120	0.200	0.200		0.000
TP	RFS		0.416	0.300		0.000	0.116
RN	0.000	0.046	0.046	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	31.620	-0.130				
PA	-67.500	-67.180	0.320				
DF	6.700	6.837	0.137	0.200	0.200		0.000
TP	RFS		0.439	0.300		0.000	0.139
RN	0.000	0.040	0.040	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	-0.509	-0.268	-0.818			

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	15.549	0.549	0.500	0.500	0.049

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

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	28.714	0.294	0.100	0.100	0.194

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	28.817	0.397	0.100	0.100	0.297

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	0.524	0.024	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	31.928	1.928	0.500	0.500	1.428

MM	DIM LOC= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	37.268	37.268	100.000	100.000	0.000
Y	0.000	57.203	57.203	100.000	100.000	0.000
Z	0.000	-61.800	-61.800	100.000	100.000	0.000
D	33.800	33.892	0.092	0.150	0.000	0.000
RN	0.000	0.012	0.012	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	-0.549	0.285	0.786			

MM	DIM FLAT4= FLATNESS OF PLANE PL-NW12-FLANGE-HOM2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.002	0.002	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	16.556	1.556	0.500	0.500	1.056

DEG	DIM ANGL6= 2D ANGLE (TRUE) FROM PLANE PL-NW12-FLANGE-HOM2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.946	-0.054	0.500	0.500	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC9= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-71.087	-71.087	100.000	100.000	0.000
Y	0.000	1195.995	1195.995	2000.000	2000.000	0.000
Z	0.000	-10.486	-10.486	100.000	100.000	0.000
D	33.800	33.795	-0.005	0.150	0.000	0.005
RN	0.000	0.041	0.041	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	67.126	67.126	100.000	100.000	0.000
Y	60.600	60.503	-0.097	0.200	0.200	0.000
Z	0.000	-42.183	-42.183	100.000	100.000	0.000
D	44.000	43.762	-0.238	0.000	0.100	0.138
RN	0.000	0.174	0.174	0.100	0.000	0.074
V	-0.848	0.000	0.529			

DEG	DIM ANGL9= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	31.967	1.967	0.500	0.500	1.467

DEG	DIM ANGL10= 3D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	89.972	-0.028	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	58.033	-1.967	0.500	0.500	1.467

MM	DIM HOM1 POINT= LOCATION OF POINT PT-RT-HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.246	0.246	0.200	0.200	0.046

MM	DIM HOM1 PLANE= LOCATION OF PLANE PL HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	111.145	0.145	0.200	0.200	0.000
FL	0.000	0.010	0.010	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	60.541	-0.059	0.200	0.200	0.000
Z	0.000	-0.292	-0.292	0.200	0.200	0.092

HOM 2 LOCATION

MM	DIM LOC-HOM2= LOCATION OF CYLINDER CY-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-63.789	-63.789	100.000	100.000	0.000
Y	1186.800	1192.306	5.506	3.000	3.000	2.506
Z	0.000	-45.096	-45.096	100.000	100.000	0.000
D	44.000	43.769	-0.231	0.000	0.100	0.131
RN	0.000	0.138	0.138	0.100	0.000	0.038
V	0.818	-0.001	0.575			

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	60.515	-0.085	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	35.073	0.073	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	89.936	-0.064	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	54.927	-0.073	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	116.216	0.216	0.200	0.200	0.016

MM	DIM HOM2 PLANE= LOCATION OF PLANE PL HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	111.126	0.126	0.200	0.200	0.000
FL	0.000	0.013	0.013	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	1192.218	5.418	3.000	3.000	2.418
Z	0.000	-0.309	-0.309	0.200	0.200	0.109

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

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	94.743	94.743	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.836	-0.164	0.050	0.050	0.114
RN	0.000	0.073	0.073	0.050	0.000	0.023

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.059	0.059	0.200	0.200	0.000
Y	0.000	123.667	123.667	2000.000	2000.000	0.000
Z	0.000	0.034	0.034	0.200	0.200	0.000
D	191.200	191.234	0.034	0.200	0.200	0.000
RN	0.000	0.066	0.066	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	0.095	0.095	0.200	0.200	0.000
Y	0.000	158.543	158.543	2000.000	2000.000	0.000
Z	0.000	-0.060	-0.060	0.200	0.200	0.000
D	210.300	211.084	0.784	0.200	0.200	0.584
RN	0.000	0.243	0.243	0.200	0.000	0.043

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.076	0.076	0.200	0.200	0.000
Y	0.000	167.103	167.103	2000.000	2000.000	0.000
Z	0.000	-0.029	-0.029	0.200	0.200	0.000
D	210.300	211.078	0.779	0.200	0.200	0.579
RN	0.000	0.130	0.130	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	0.155	0.155	0.200	0.200	0.000
Y	0.000	274.080	274.080	2000.000	2000.000	0.000
Z	0.000	0.092	0.092	0.200	0.200	0.000
D	210.300	211.151	0.851	0.200	0.200	0.651
RN	0.000	0.161	0.161	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	0.243	0.242	0.200	0.200	0.042
Y	0.000	283.165	283.165	2000.000	2000.000	0.000
Z	0.000	0.094	0.094	0.200	0.200	0.000
D	210.300	211.161	0.861	0.200	0.200	0.661
RN	0.000	0.169	0.169	0.200	0.000	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.255	0.255	0.200	0.200	0.055
Y	0.000	390.424	390.424	2000.000	2000.000	0.000
Z	0.000	0.266	0.266	0.200	0.200	0.066
D	210.300	211.115	0.815	0.200	0.200	0.615
RN	0.000	0.178	0.178	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	0.245	0.245	0.200	0.200	0.045
Y	0.000	399.392	399.392	2000.000	2000.000	0.000
Z	0.000	0.299	0.299	0.200	0.200	0.099
D	210.300	211.052	0.752	0.200	0.200	0.552
RN	0.000	0.197	0.197	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	0.167	0.167	0.200	0.200	0.000
Y	0.000	506.051	506.051	2000.000	2000.000	0.000
Z	0.000	0.457	0.457	0.200	0.200	0.257
D	210.300	211.158	0.858	0.200	0.200	0.658
RN	0.000	0.232	0.232	0.200	0.000	0.032

MM DIM LOC-CC10= LOCATION OF CIRCLE CRC-CAV-4-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.159	0.159	0.200	0.200	0.000
Y	0.000	515.061	515.061	2000.000	2000.000	0.000
Z	0.000	0.392	0.392	0.200	0.200	0.192
D	210.300	211.143	0.843	0.200	0.200	0.643
RN	0.000	0.294	0.294	0.200	0.000	0.094

MM DIM LOC-CC11= LOCATION OF CIRCLE CRC-CAV-5-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.047	0.047	0.200	0.200	0.000
Y	0.000	622.414	622.414	2000.000	2000.000	0.000
Z	0.000	0.497	0.497	0.200	0.200	0.297
D	210.300	211.057	0.757	0.200	0.200	0.557
RN	0.000	0.163	0.163	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	0.055	0.055	0.200	0.200	0.000
Y	0.000	631.151	631.151	2000.000	2000.000	0.000
Z	0.000	0.518	0.517	0.200	0.200	0.317
D	210.300	211.019	0.719	0.200	0.200	0.519
RN	0.000	0.171	0.171	0.200	0.000	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.033	-0.033	0.200	0.200	0.000
Y	0.000	737.771	737.771	2000.000	2000.000	0.000
Z	0.000	0.572	0.572	0.200	0.200	0.372
D	210.300	211.085	0.785	0.200	0.200	0.585
RN	0.000	0.194	0.194	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.058	-0.059	0.200	0.200	0.000
Y	0.000	746.174	746.174	2000.000	2000.000	0.000
Z	0.000	0.568	0.567	0.200	0.200	0.367
D	210.300	210.981	0.681	0.200	0.200	0.481
RN	0.000	0.147	0.147	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.152	-0.152	0.200	0.200	0.000
Y	0.000	853.905	853.905	2000.000	2000.000	0.000
Z	0.000	0.464	0.464	0.200	0.200	0.264
D	210.300	211.072	0.772	0.200	0.200	0.572
RN	0.000	0.159	0.159	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	-0.126	-0.126	0.200	0.200	0.000
Y	0.000	862.760	862.760	2000.000	2000.000	0.000
Z	0.000	0.462	0.462	0.200	0.200	0.262
D	210.300	211.098	0.798	0.200	0.200	0.598
RN	0.000	0.168	0.168	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	-0.099	-0.099	0.200	0.200	0.000
Y	0.000	970.181	970.181	2000.000	2000.000	0.000
Z	0.000	0.256	0.256	0.200	0.200	0.056
D	210.300	211.109	0.809	0.200	0.200	0.609
RN	0.000	0.157	0.157	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	-0.125	-0.125	0.200	0.200	0.000
Y	0.000	978.314	978.314	2000.000	2000.000	0.000
Z	0.000	0.219	0.219	0.200	0.200	0.019
D	210.300	211.078	0.778	0.200	0.200	0.578
RN	0.000	0.200	0.200	0.200	0.000	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.099	-0.099	0.200	0.200	0.000
Y	0.000	1086.119	1086.119	2000.000	2000.000	0.000
Z	0.000	0.018	0.017	0.200	0.200	0.000
D	210.300	211.123	0.823	0.200	0.200	0.623
RN	0.000	0.192	0.192	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	-0.096	-0.096	0.200	0.200	0.000
Y	0.000	1094.710	1094.710	2000.000	2000.000	0.000
Z	0.000	0.036	0.035	0.200	0.200	0.000
D	210.300	210.929	0.629	0.200	0.200	0.429
RN	0.000	0.195	0.195	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	-0.086	-0.086	0.200	0.200	0.000
Y	0.000	1125.881	1125.881	2000.000	2000.000	0.000
Z	0.000	0.010	0.010	0.200	0.200	0.000
D	200.000	200.025	0.025	0.200	0.200	0.000
RN	0.000	0.040	0.040	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	1157.299	1157.299	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.817	-0.183	0.050	0.050	0.133
RN	0.000	0.066	0.066	0.050	0.000	0.016

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

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	0.059	0.059				
Z	0.000	0.034	0.034				
TP	RFS		0.135	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	0.095	0.095				
Z	0.000	-0.060	-0.060				
TP	RFS		0.225	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	0.076	0.076				
Z	0.000	-0.029	-0.029				
TP	RFS		0.163	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	0.155	0.155				
Z	0.000	0.092	0.092				
TP	RFS		0.361	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.243	0.242				
Z	0.000	0.094	0.094				
TP	RFS		0.520	0.400		0.000	0.120

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.255	0.255				
Z	0.000	0.266	0.266				
TP	RFS		0.737	0.400		0.000	0.337

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

⊕ MM	DIM LOC-TP-CC8= TRUE POSITION OF CIRCLE CRC-CAV-3-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	0.245	0.245					
Z	0.000	0.299	0.299					
TP	RFS		0.773	0.400		0.000	0.373	

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	0.167	0.167					
Z	0.000	0.457	0.457					
TP	RFS		0.973	0.400		0.000	0.573	

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	0.159	0.159					
Z	0.000	0.392	0.392					
TP	RFS		0.846	0.400		0.000	0.446	

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	0.047	0.047					
Z	0.000	0.497	0.497					
TP	RFS		0.997	0.400		0.000	0.597	

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	0.055	0.055					
Z	0.000	0.518	0.517					
TP	RFS		1.041	0.400		0.000	0.641	

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.033	-0.033					
Z	0.000	0.572	0.572					
TP	RFS		1.145	0.400		0.000	0.745	

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.058	-0.059					
Z	0.000	0.568	0.567					
TP	RFS		1.141	0.400		0.000	0.741	

⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.152	-0.152					
Z	0.000	0.464	0.464					
TP	RFS		0.975	0.400		0.000	0.575	

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

⊕ MM	DIM LOC-TP-CC16= TRUE POSITION OF CIRCLE CRC-CAV-7-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.126	-0.126				
Z	0.000	0.462	0.462				
TP	RFS		0.958	0.400		0.000	0.558

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.099	-0.099				
Z	0.000	0.256	0.256				
TP	RFS		0.549	0.400		0.000	0.149

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.125	-0.125				
Z	0.000	0.219	0.219				
TP	RFS		0.505	0.400		0.000	0.105

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.099	-0.099				
Z	0.000	0.018	0.017				
TP	RFS		0.200	0.400		0.000	0.000

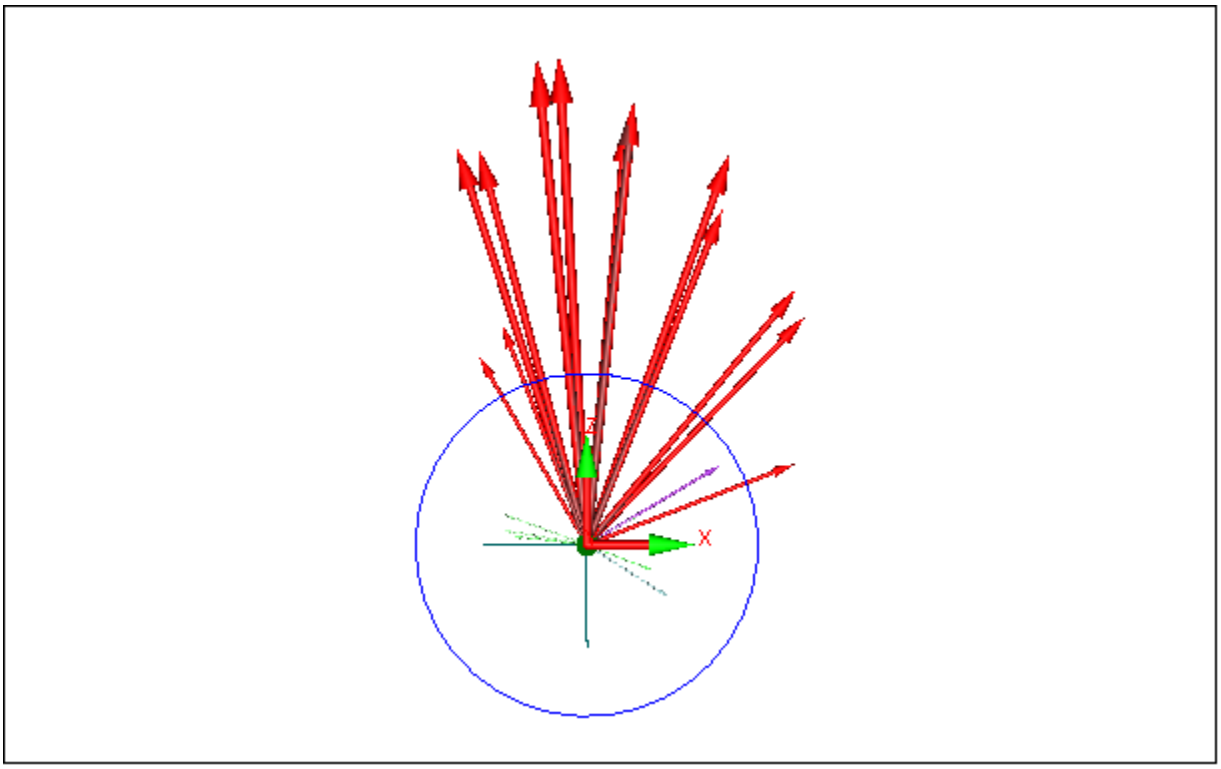
⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.096	-0.096				
Z	0.000	0.036	0.035				
TP	RFS		0.204	0.400		0.000	0.000

⊕ MM	DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.086	-0.086				
Z	0.000	0.010	0.010				
TP	RFS		0.173	0.400		0.000	0.000

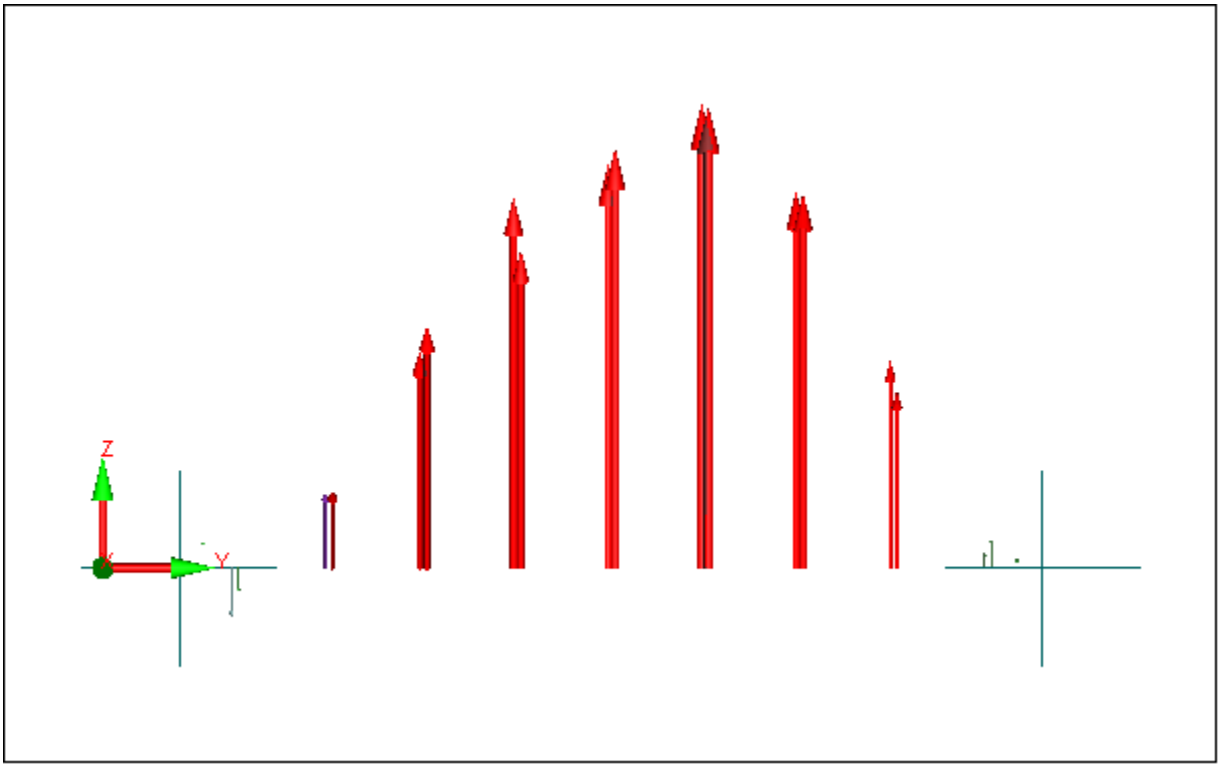
⊕ MM	DIM LOC-TP-CC22= TRUE POSITION OF CIRCLE CRC-DAT-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.000	0.000				
Z	0.000	0.000	0.000				
TP	RFS		0.000	0.400		0.000	0.000

True Position plots from 3 views
x1000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

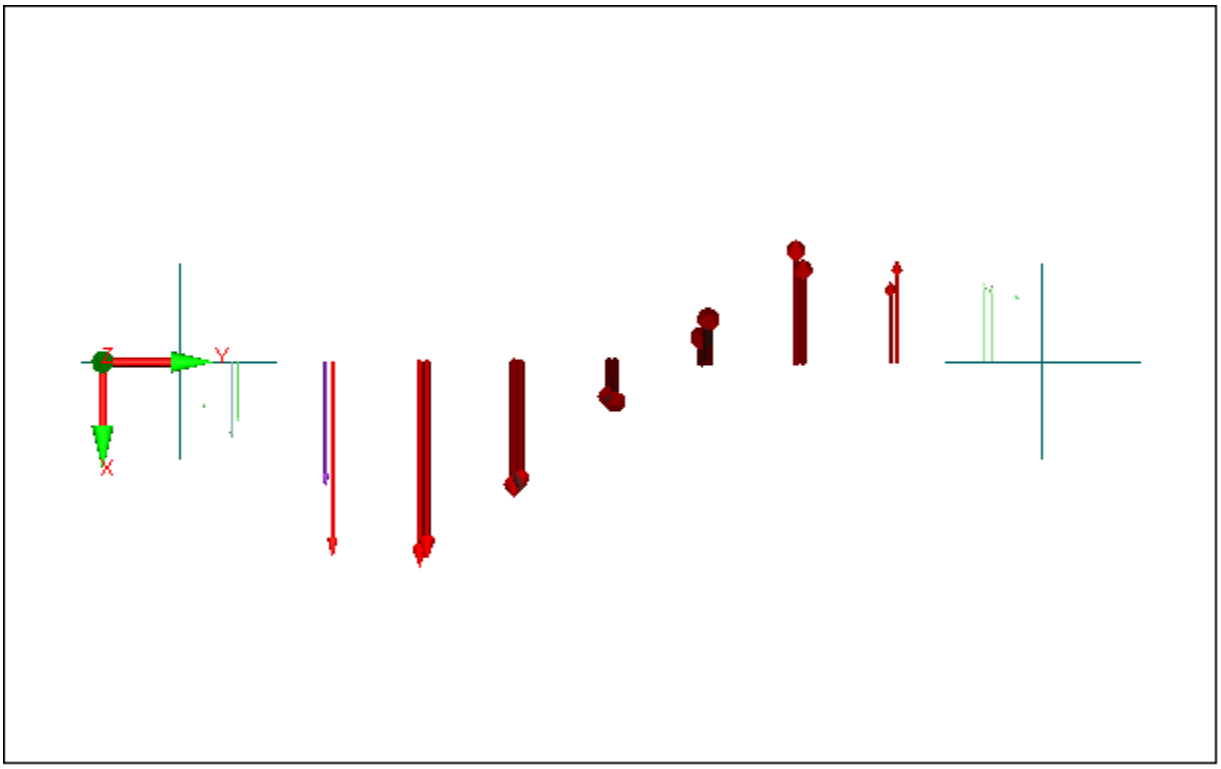


-Y View
x1000



+X View
x1000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009



+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	0.031	0.031	0.200	0.200	0.000
Y	0.000	626.314	626.314	2000.000	2000.000	0.000
Z	0.000	0.235	0.235	0.200	0.200	0.035
ST	0.000	0.630	0.630	0.200	0.000	0.430

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

SUPPORT RING CIRCLE LOCATIONS
Positive side

MM	DIM LOC-SUPPORT RING-P1= LOCATION OF CIRCLE CR-SUPPORT-RING-P12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.549	0.549	0.200	0.200	0.349
Y	0.000	220.839	220.839	2000.000	2000.000	0.000
Z	0.000	-0.159	-0.159	0.200	0.200	0.000
R	56.500	56.518	0.018	0.200	0.200	0.000
RN	0.000	0.045	0.045	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-P2= LOCATION OF CIRCLE CR-SUPPORT-RING-P23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.410	0.410	0.200	0.200	0.210
Y	0.000	336.841	336.841	2000.000	2000.000	0.000
Z	0.000	0.127	0.127	0.200	0.200	0.000
R	56.500	56.388	-0.112	0.200	0.200	0.000
RN	0.000	0.215	0.215	0.200	0.000	0.015

MM	DIM LOC-SUPPORT RING-P3= LOCATION OF CIRCLE CR-SUPPORT-RING-P34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.384	0.384	0.200	0.200	0.184
Y	0.000	452.834	452.834	2000.000	2000.000	0.000
Z	0.000	0.391	0.391	0.200	0.200	0.191
R	56.500	56.552	0.052	0.200	0.200	0.000
RN	0.000	0.085	0.085	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-P4= LOCATION OF CIRCLE CR-SUPPORT-RING-P45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.766	0.766	0.200	0.200	0.566
Y	0.000	568.839	568.839	2000.000	2000.000	0.000
Z	0.000	0.575	0.575	0.200	0.200	0.375
R	56.500	56.325	-0.175	0.200	0.200	0.000
RN	0.000	0.322	0.322	0.200	0.000	0.122

MM	DIM LOC-SUPPORT RING-P5= LOCATION OF CIRCLE CR-SUPPORT-RING-P56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.061	0.060	0.200	0.200	0.000
Y	0.000	684.836	684.836	2000.000	2000.000	0.000
Z	0.000	0.674	0.674	0.200	0.200	0.474
R	56.500	56.443	-0.057	0.200	0.200	0.000
RN	0.000	0.048	0.048	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-P6= LOCATION OF CIRCLE CR-SUPPORT-RING-P67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.097	0.096	0.200	0.200	0.000
Y	0.000	799.838	799.838	2000.000	2000.000	0.000
Z	0.000	0.568	0.568	0.200	0.200	0.368
R	56.500	56.474	-0.026	0.200	0.200	0.000
RN	0.000	0.071	0.071	0.200	0.000	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC-SUPPORT RING-P7= LOCATION OF CIRCLE CR-SUPPORT-RING-P78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.140	0.140	0.200	0.200	0.000
Y	0.000	915.838	915.838	2000.000	2000.000	0.000
Z	0.000	0.230	0.230	0.200	0.200	0.030
R	56.500	56.427	-0.073	0.200	0.200	0.000
RN	0.000	0.069	0.069	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-P8= LOCATION OF CIRCLE CR-SUPPORT-RING-P89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.394	0.394	0.200	0.200	0.194
Y	0.000	1031.833	1031.833	2000.000	2000.000	0.000
Z	0.000	0.119	0.119	0.200	0.200	0.000
R	56.500	56.437	-0.063	0.200	0.200	0.000
RN	0.000	0.183	0.183	0.200	0.000	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

SUPPORT RING POINT LOCATIONS
Positive Side

MM	DIM LOC-SUPPORT RING-PTP1= LOCATION OF POINT PT-SUPPORT-RING-P12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	57.029	0.529	0.200	0.200	0.329
Y	0.000	213.540	213.540	2000.000	2000.000	0.000
Z	0.000	0.009	0.009	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTP2= LOCATION OF POINT PT-SUPPORT-RING-P23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.882	0.382	0.200	0.200	0.182
Y	0.000	329.740	329.740	2000.000	2000.000	0.000
Z	0.000	0.010	0.010	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTP3= LOCATION OF POINT PT-SUPPORT-RING-P34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.902	0.402	0.200	0.200	0.202
Y	0.000	446.340	446.340	2000.000	2000.000	0.000
Z	0.000	0.010	0.010	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTP4= LOCATION OF POINT PT-SUPPORT-RING-P45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.935	0.435	0.200	0.200	0.235
Y	0.000	562.040	562.040	2000.000	2000.000	0.000
Z	0.000	0.010	0.010	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTP5= LOCATION OF POINT PT-SUPPORT-RING-P56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.585	0.085	0.200	0.200	0.000
Y	0.000	677.740	677.740	2000.000	2000.000	0.000
Z	0.000	0.011	0.011	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTP6= LOCATION OF POINT PT-SUPPORT-RING-P67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.598	0.098	0.200	0.200	0.000
Y	0.000	793.940	793.940	2000.000	2000.000	0.000
Z	0.000	0.011	0.011	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTP7= LOCATION OF POINT PT-SUPPORT-RING-P78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.698	0.198	0.200	0.200	0.000
Y	0.000	909.340	909.340	2000.000	2000.000	0.000
Z	0.000	0.011	0.011	0.200	0.200	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC-SUPPORT RING-PTP8= LOCATION OF POINT PT-SUPPORT-RING-P89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.701	0.201	0.200	0.200	0.001
Y	0.000	1025.440	1025.440	2000.000	2000.000	0.000
Z	0.000	0.012	0.012	0.200	0.200	0.000

SUPPORT RING CIRCLES IN Y
Positive Side

MM	DIM LOC X SUPPORT RING CIRCLES P1= LOCATION OF CIRCLE CR-SUPPORT-RING-P12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.549	0.549	0.200	0.200	0.349

MM	DIM LOC X SUPPORT RING CIRCLES P2= LOCATION OF CIRCLE CR-SUPPORT-RING-P23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.410	0.410	0.200	0.200	0.210

MM	DIM LOC X SUPPORT RING CIRCLES P3= LOCATION OF CIRCLE CR-SUPPORT-RING-P34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.384	0.384	0.200	0.200	0.184

MM	DIM LOC X SUPPORT RING CIRCLES P4= LOCATION OF CIRCLE CR-SUPPORT-RING-P45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.766	0.766	0.200	0.200	0.566

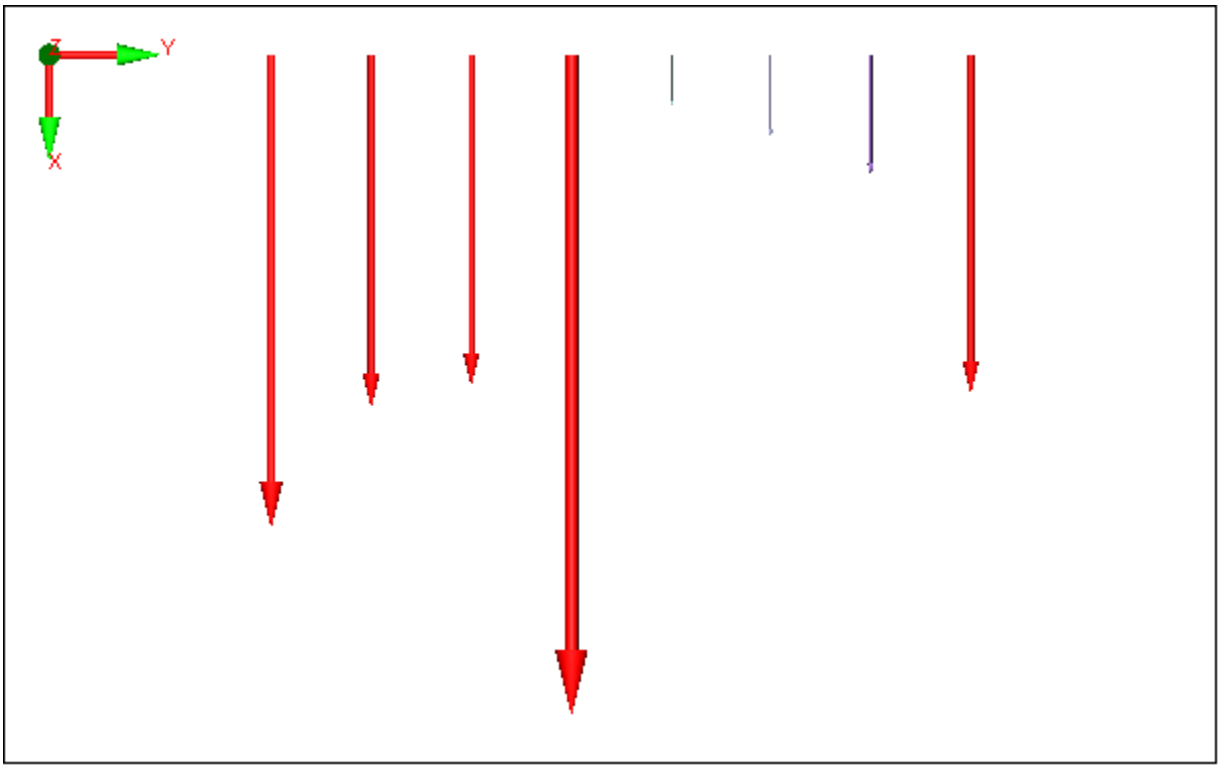
MM	DIM LOC X SUPPORT RING CIRCLES P5= LOCATION OF CIRCLE CR-SUPPORT-RING-P56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.061	0.061	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING CIRCLES P6= LOCATION OF CIRCLE CR-SUPPORT-RING-P67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.097	0.097	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING CIRCLES P7= LOCATION OF CIRCLE CR-SUPPORT-RING-P78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.140	0.140	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING CIRCLES P8= LOCATION OF CIRCLE CR-SUPPORT-RING-P89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.394	0.394	0.200	0.200	0.194

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009



SUPPORT RING CIRCLES IN X
Positive Side
x1000

SUPPORT RING POINTS IN X
Positive Side

MM	DIM LOC X SUPPORT RING POINTS P1= LOCATION OF POINT PT-SUPPORT-RING-P12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	57.029	0.529	0.200	0.200	0.329

MM	DIM LOC X SUPPORT RING POINTS P2= LOCATION OF POINT PT-SUPPORT-RING-P23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.882	0.382	0.200	0.200	0.182

MM	DIM LOC X SUPPORT RING POINTS P3= LOCATION OF POINT PT-SUPPORT-RING-P34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.902	0.402	0.200	0.200	0.202

MM	DIM LOC X SUPPORT RING POINTS P4= LOCATION OF POINT PT-SUPPORT-RING-P45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.935	0.435	0.200	0.200	0.235

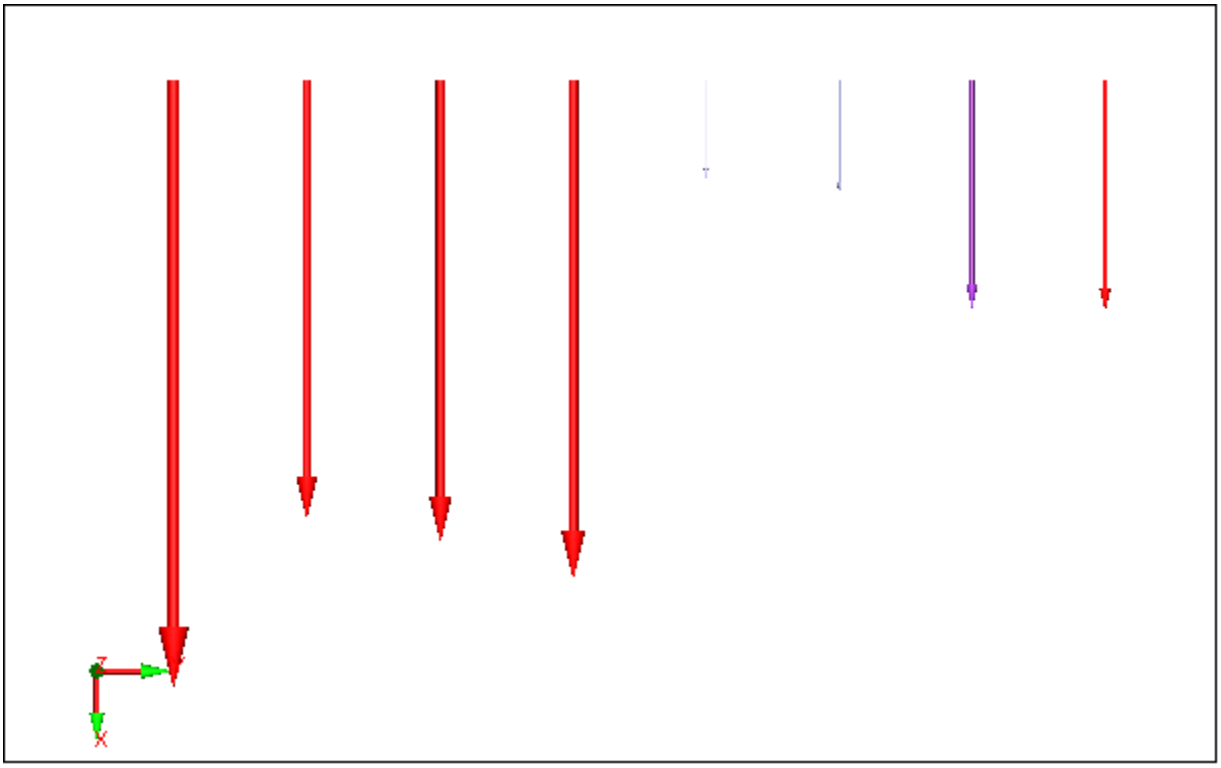
PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC X SUPPORT RING POINTS P5= LOCATION OF POINT PT-SUPPORT-RING-P56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.585	0.085	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING POINTS P6= LOCATION OF POINT PT-SUPPORT-RING-P67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.598	0.098	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING POINTS P7= LOCATION OF POINT PT-SUPPORT-RING-P78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.698	0.198	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING POINTS P8= LOCATION OF POINT PT-SUPPORT-RING-P89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.701	0.201	0.200	0.200	0.001



SUPPORT RING POINTS IN X
Positive Side
x1000

SUPPORT RING CIRCLE LOCATIONS
Negative side

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC-SUPPORT RING-N1= LOCATION OF CIRCLE CR-SUPPORT-RING-N12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.130	-0.130	0.200	0.200	0.000
Y	0.000	220.845	220.845	2000.000	2000.000	0.000
Z	0.000	-0.387	-0.387	0.200	0.200	0.187
R	56.500	56.524	0.024	0.200	0.200	0.000
RN	0.000	0.482	0.482	0.200	0.000	0.282

MM	DIM LOC-SUPPORT RING-N2= LOCATION OF CIRCLE CR-SUPPORT-RING-N23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.137	-0.137	0.200	0.200	0.000
Y	0.000	336.842	336.842	2000.000	2000.000	0.000
Z	0.000	0.132	0.132	0.200	0.200	0.000
R	56.500	56.478	-0.022	0.200	0.200	0.000
RN	0.000	0.032	0.032	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-N3= LOCATION OF CIRCLE CR-SUPPORT-RING-N34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.203	0.203	0.200	0.200	0.003
Y	0.000	452.835	452.835	2000.000	2000.000	0.000
Z	0.000	0.376	0.376	0.200	0.200	0.176
R	56.500	56.643	0.143	0.200	0.200	0.000
RN	0.000	0.003	0.003	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-N4= LOCATION OF CIRCLE CR-SUPPORT-RING-N45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.053	0.053	0.200	0.200	0.000
Y	0.000	568.835	568.835	2000.000	2000.000	0.000
Z	0.000	0.461	0.461	0.200	0.200	0.261
R	56.500	56.539	0.039	0.200	0.200	0.000
RN	0.000	0.095	0.095	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-N5= LOCATION OF CIRCLE CR-SUPPORT-RING-N56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.356	-0.356	0.200	0.200	0.156
Y	0.000	684.841	684.841	2000.000	2000.000	0.000
Z	0.000	0.699	0.699	0.200	0.200	0.499
R	56.500	56.461	-0.039	0.200	0.200	0.000
RN	0.000	0.095	0.095	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-N6= LOCATION OF CIRCLE CR-SUPPORT-RING-N67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.291	-0.291	0.200	0.200	0.091
Y	0.000	799.836	799.836	2000.000	2000.000	0.000
Z	0.000	0.631	0.631	0.200	0.200	0.431
R	56.500	56.430	-0.070	0.200	0.200	0.000
RN	0.000	0.008	0.008	0.200	0.000	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC-SUPPORT RING-N7= LOCATION OF CIRCLE CR-SUPPORT-RING-N78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.420	-0.420	0.200	0.200	0.220
Y	0.000	915.837	915.837	2000.000	2000.000	0.000
Z	0.000	0.203	0.203	0.200	0.200	0.003
R	56.500	56.456	-0.044	0.200	0.200	0.000
RN	0.000	0.033	0.033	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-N8= LOCATION OF CIRCLE CR-SUPPORT-RING-N89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.220	-0.220	0.200	0.200	0.020
Y	0.000	1031.838	1031.838	2000.000	2000.000	0.000
Z	0.000	0.054	0.054	0.200	0.200	0.000
R	56.500	56.503	0.003	0.200	0.200	0.000
RN	0.000	0.013	0.013	0.200	0.000	0.000

SUPPORT RING POINT LOCATIONS
Negative side

MM	DIM LOC-SUPPORT RING-PTN1= LOCATION OF POINT PT-SUPPORT-RING-N12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.405	0.095	0.200	0.200	0.000
Y	0.000	213.539	213.539	2000.000	2000.000	0.000
Z	0.000	0.086	0.086	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTN2= LOCATION OF POINT PT-SUPPORT-RING-N23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.698	-0.198	0.200	0.200	0.000
Y	0.000	329.739	329.739	2000.000	2000.000	0.000
Z	0.000	0.087	0.087	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTN3= LOCATION OF POINT PT-SUPPORT-RING-N34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.423	0.077	0.200	0.200	0.000
Y	0.000	446.339	446.339	2000.000	2000.000	0.000
Z	0.000	0.087	0.087	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTN4= LOCATION OF POINT PT-SUPPORT-RING-N45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.452	0.048	0.200	0.200	0.000
Y	0.000	562.039	562.039	2000.000	2000.000	0.000
Z	0.000	0.087	0.087	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTN5= LOCATION OF POINT PT-SUPPORT-RING-N56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.862	-0.362	0.200	0.200	0.162
Y	0.000	677.739	677.739	2000.000	2000.000	0.000
Z	0.000	0.088	0.087	0.200	0.200	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC-SUPPORT RING-PTN6= LOCATION OF POINT PT-SUPPORT-RING-N67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.730	-0.230	0.200	0.200	0.030
Y	0.000	793.939	793.939	2000.000	2000.000	0.000
Z	0.000	0.088	0.088	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTN7= LOCATION OF POINT PT-SUPPORT-RING-N78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.806	-0.305	0.200	0.200	0.105
Y	0.000	909.339	909.339	2000.000	2000.000	0.000
Z	0.000	0.088	0.088	0.200	0.200	0.000

MM	DIM LOC-SUPPORT RING-PTN8= LOCATION OF POINT PT-SUPPORT-RING-N89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.699	-0.199	0.200	0.200	0.000
Y	0.000	1025.439	1025.439	2000.000	2000.000	0.000
Z	0.000	0.088	0.088	0.200	0.200	0.000

SUPPORT RING CIRCLES IN Y
Negative side

MM	DIM LOC X SUPPORT RING CIRCLES N1= LOCATION OF CIRCLE CR-SUPPORT-RING-N12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.130	-0.130	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING CIRCLES N2= LOCATION OF CIRCLE CR-SUPPORT-RING-N23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.137	-0.137	0.200	0.200	0.000

MM	DIM LOC X SUPPORT RING CIRCLES N3= LOCATION OF CIRCLE CR-SUPPORT-RING-N34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.203	0.203	0.200	0.200	0.003

MM	DIM LOC X SUPPORT RING CIRCLES N4= LOCATION OF CIRCLE CR-SUPPORT-RING-N45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.053	0.053	0.200	0.200	0.000

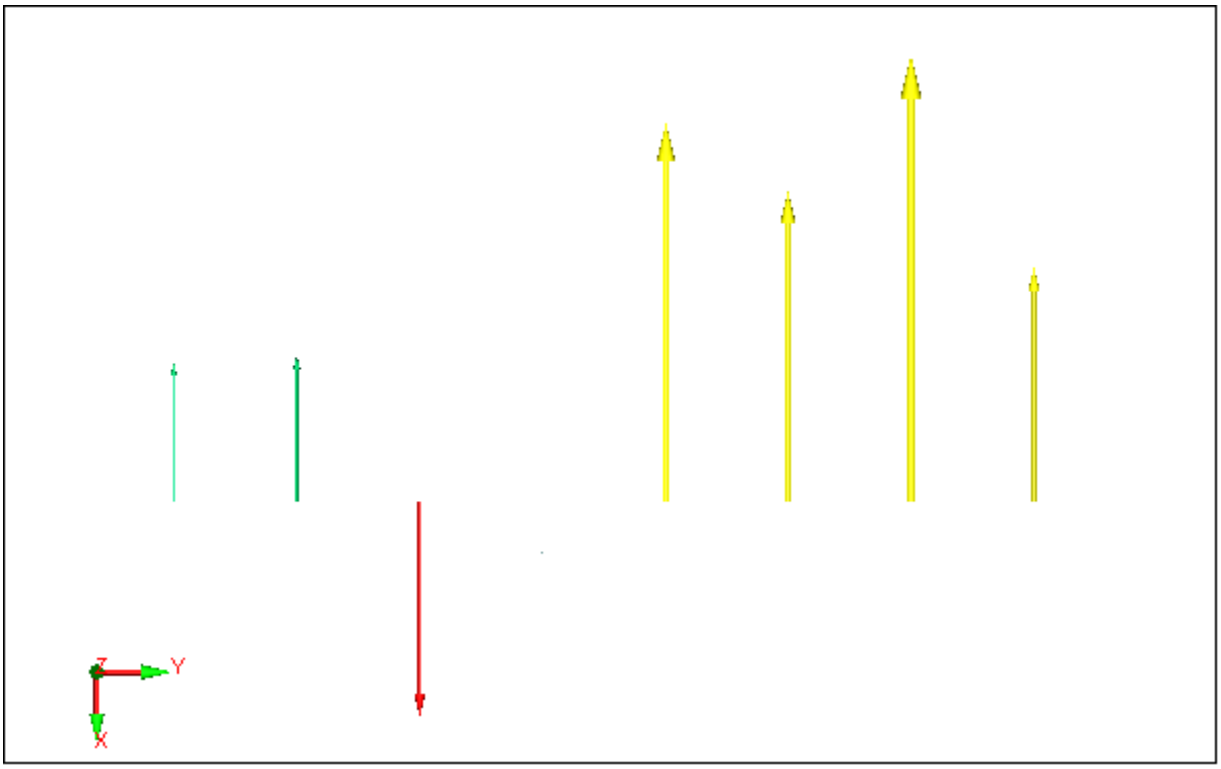
MM	DIM LOC X SUPPORT RING CIRCLES N5= LOCATION OF CIRCLE CR-SUPPORT-RING-N56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.356	-0.356	0.200	0.200	0.156

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM	DIM LOC X SUPPORT RING CIRCLES N6= LOCATION OF CIRCLE CR-SUPPORT-RING-N67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.291	-0.291	0.200	0.200	0.091

MM	DIM LOC X SUPPORT RING CIRCLES N7= LOCATION OF CIRCLE CR-SUPPORT-RING-N78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.420	-0.420	0.200	0.200	0.220

MM	DIM LOC X SUPPORT RING CIRCLES N8= LOCATION OF CIRCLE CR-SUPPORT-RING-N89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.220	-0.220	0.200	0.200	0.020



SUPPORT RING CIRCLES IN X
Negative Side
x1000

SUPPORT RING POINTS IN X
Negative side

MM	DIM LOC X SUPPORT RING POINTS N1= LOCATION OF POINT PT-SUPPORT-RING-N1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.405	0.095	0.200	0.200	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009

MM DIM LOC X SUPPORT RING POINTS N2= LOCATION OF POINT PT-SUPPORT-RING-N2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.698	-0.198	0.200	0.200	0.000

MM DIM LOC X SUPPORT RING POINTS N3= LOCATION OF POINT PT-SUPPORT-RING-N3

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.423	0.077	0.200	0.200	0.000

MM DIM LOC X SUPPORT RING POINTS N4= LOCATION OF POINT PT-SUPPORT-RING-N4

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.452	0.048	0.200	0.200	0.000

MM DIM LOC X SUPPORT RING POINTS N5= LOCATION OF POINT PT-SUPPORT-RING-N5

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.862	-0.362	0.200	0.200	0.162

MM DIM LOC X SUPPORT RING POINTS N6= LOCATION OF POINT PT-SUPPORT-RING-N6

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.730	-0.230	0.200	0.200	0.030

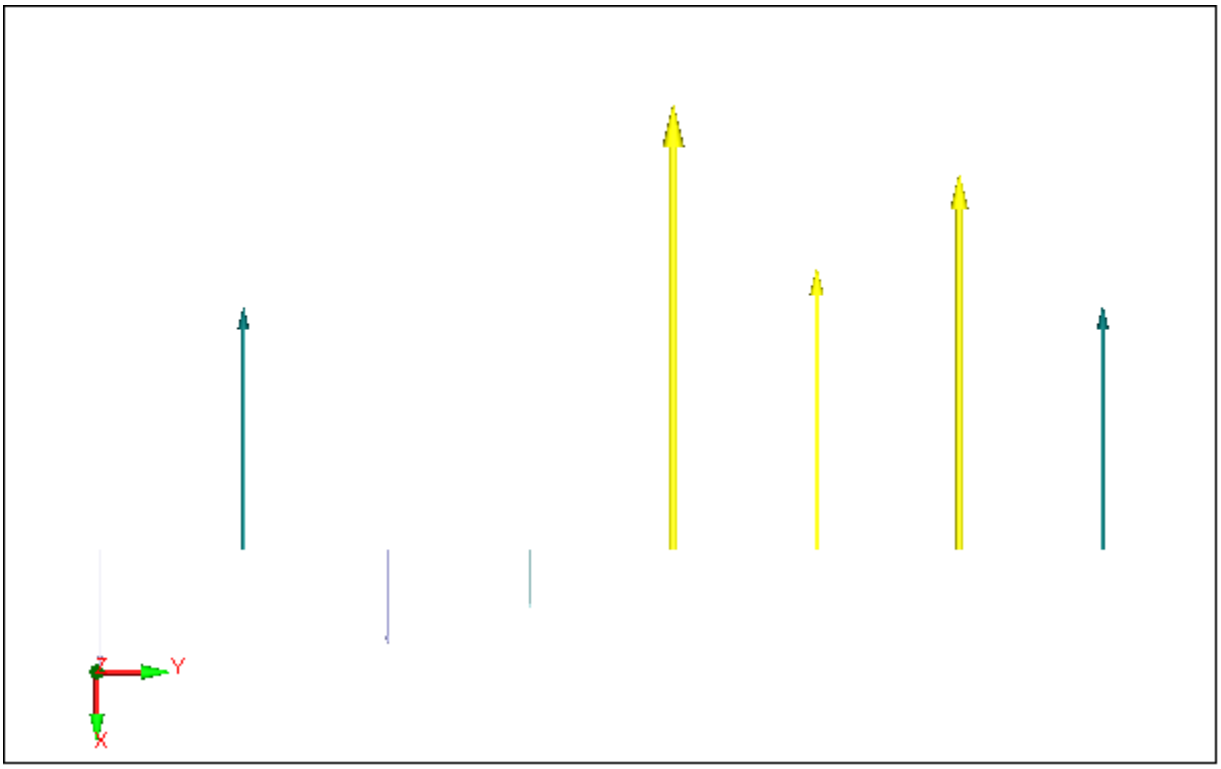
MM DIM LOC X SUPPORT RING POINTS N7= LOCATION OF POINT PT-SUPPORT-RING-N7

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.806	-0.305	0.200	0.200	0.105

MM DIM LOC X SUPPORT RING POINTS N8= LOCATION OF POINT PT-SUPPORT-RING-N8

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.699	-0.199	0.200	0.200	0.000

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR DATE=3/2/2009



SUPPORT RING POINT IN X
Negative Side
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 180 TB9AES007 v3s IR
DWG= SN=
TOTAL # OF MEAS =0 # OUT OF TOL =0