FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=3/5/2009 TIME=2:36:52 PM

PART NAME : PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9AES007 v3s IR
REV NUMBER :
SER NUMBER :
STATS COUNT : 1

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

'Inspected by ' : Robert Riley
'Cavity Number' : AES-TB9AES009
' ' : 0903050945

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	0.010			
FL	0.000	0.037	0.037	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	1.159	1.159	0.200	0.000	0.959

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.552	0.552	0.100	0.100	0.452

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.158	-0.158	0.200	0.200	0.000
Z	0.000	0.881	0.881	0.200	0.200	0.681
D	140.000	139.983	-0.017	0.300	0.300	0.000
RN	0.000	0.007	0.007	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	0.975	-0.025	0.100	0.100	0.000

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

⊕ MM	DIM TP NBPF BH1= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 015						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.729	-0.271				
PA	15.000	14.551	-0.449				
DF	8.800	8.758	-0.042	0.300	0.300		0.000
TP	RFS		1.084	0.300		0.000	0.784
RN	0.000	0.015	0.015	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH2= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 045						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.922	-0.078				
PA	45.000	44.656	-0.344				
DF	8.800	8.753	-0.047	0.300	0.300		0.000
TP	RFS		0.737	0.300		0.000	0.437
RN	0.000	0.014	0.014	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH3= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 075						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.870	-0.130				
PA	75.000	74.677	-0.323				
DF	8.800	8.757	-0.043	0.300	0.300		0.000
TP	RFS		0.724	0.300		0.000	0.424
RN	0.000	0.015	0.015	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH4= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 105						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.872	-0.128				
PA	105.000	104.795	-0.205				
DF	8.800	8.751	-0.049	0.300	0.300		0.000
TP	RFS		0.501	0.300		0.000	0.201
RN	0.000	0.015	0.015	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH5= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 135						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.786	-0.214				
PA	135.000	134.741	-0.259				
DF	8.800	8.752	-0.048	0.300	0.300		0.000
TP	RFS		0.690	0.300		0.000	0.390
RN	0.000	0.016	0.016	0.300	0.000		0.000

⊕ MM	DIM TP NBPF BH6= TRUE POSITION OF CIRCLE CR-NEARFLANGE BH 165						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.845	-0.155				
PA	165.000	164.775	-0.225				
DF	8.800	8.750	-0.050	0.300	0.300		0.000
TP	RFS		0.562	0.300		0.000	0.262
RN	0.000	0.022	0.022	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	1250.885	3.485	3.000	3.000	0.485
V	0.001	1.000	0.009			
FL	0.000	0.051	0.051	0.200	0.000	0.000

// MM DIM PARL2= PARALLEL OF PLANE PL-FAR-END,RFS TO WORKPLANE YPLUS EXTEND=0.000

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	1.093	1.093	0.200	0.000	0.893

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.517	0.517	0.100	0.100	0.417

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.005	-0.005	0.200	0.200	0.000
Z	0.000	0.804	0.804	0.200	0.200	0.604
D	140.000	140.023	0.023	0.300	0.300	0.000
RN	0.000	0.011	0.011	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	0.991	-0.009	0.100	0.100	0.000

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

MM DIM TP FBPF BH1= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 015

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.827	-0.173				
PA	15.000	15.112	0.112				
DF	8.800	8.748	-0.052	0.300	0.300		0.000
TP	RFS		0.417	0.300		0.000	0.117
RN	0.000	0.017	0.017	0.300	0.000		0.000

MM DIM TP FBPF BH2= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 045

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.895	-0.105				
PA	45.000	45.111	0.111				
DF	8.800	8.747	-0.053	0.300	0.300		0.000
TP	RFS		0.313	0.300		0.000	0.013
RN	0.000	0.017	0.017	0.300	0.000		0.000

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⊕ MM	DIM TP FBPF BH3= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 075						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.494	-0.506				
PA	75.000	75.325	0.325				
DF	8.800	8.788	-0.012	0.300	0.300		0.000
TP	RFS		1.219	0.300		0.000	0.919
RN	0.000	0.054	0.054	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH4= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 105						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.873	-0.127				
PA	105.000	105.172	0.172				
DF	8.800	8.743	-0.057	0.300	0.300		0.000
TP	RFS		0.440	0.300		0.000	0.140
RN	0.000	0.014	0.014	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH5= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 135						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.767	-0.233				
PA	135.000	135.235	0.235				
DF	8.800	8.753	-0.047	0.300	0.300		0.000
TP	RFS		0.677	0.300		0.000	0.377
RN	0.000	0.017	0.017	0.300	0.000		0.000

⊕ MM	DIM TP FBPF BH6= TRUE POSITION OF CIRCLE CR-FARFLANGE BH 165						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
PR	60.000	59.990	-0.010				
PA	165.000	165.168	0.168				
DF	8.800	8.751	-0.049	0.300	0.300		0.000
TP	RFS		0.353	0.300		0.000	0.053
RN	0.000	0.012	0.012	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	92.882	0.042	0.200	0.200	0.000
V	-0.003	-1.000	0.009			
FL	0.000	0.059	0.059	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	1.000	1.000	0.200	0.000	0.800

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.555	0.555	0.100	0.100	0.455

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	1157.193	2.633	0.200	0.200	2.433
V	0.004	1.000	0.007			
FL	0.000	0.142	0.142	0.200	0.000	0.000

// MM	DIM PARL6= PARALLEL OF PLANE PLC-DAT-2,RFS TO WORKPLANE YPLUS EXTEND=0.000					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.840	0.840	0.200	0.000	0.640

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.436	0.436	0.100	0.100	0.336

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	1064.311	3.251	0.200	0.200	3.051

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	93.691	0.191	0.200	0.200	0.000

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PICKUP ANTENNA FLANGE NW8

MM	DIM LOC5= LOCATION OF PLANE PL NW8 ANTENNA FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-53.800	-54.272	-0.472	0.200	0.200	0.272
V	-1.000	0.007	-0.007			
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	0.283	0.283	0.200	0.000	0.083

DEG	DIM ANGL3= 3D ANGLE (TRUE) FROM PLANE PL NW8 ANTENNA FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.563	0.563	0.100	0.100	0.463

MM	DIM LOC6= LOCATION OF CIRCLE CR_NW8_ANTENNA_FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	60.600	60.743	0.143	0.200	0.200	0.000
Z	0.000	0.418	0.418	0.200	0.200	0.218
D	33.800	33.823	0.023	0.150	0.000	0.000
RN	0.000	0.016	0.016	0.150	0.000	0.000

MM	DIM DIST01= 2D DISTANCE FROM PLANE PL NW8 ANTENNA FLANGE ORING TO PLANE PL NW8 ANTENNA FLANGE PAR TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.527	0.027	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	88.036	0.036	0.200	0.200	0.000
V	1.000	-0.001	-0.002			
FL	0.000	0.025	0.025	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	0.122	0.122	0.200	0.000	0.000

DEG	DIM ANGL4= 3D ANGLE (COMPLEMENT) FROM PLANE PL NW 40 FLANGE TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.104	0.104	0.100	0.100	0.004

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MM DIM LOC8= LOCATION OF CIRCLE CR_NW_40_FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1186.800	1190.322	3.522	0.200	0.200	3.322
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	76.000	76.100	0.100	0.200	0.000	0.000
RN	0.000	0.014	0.014	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	60.563	-0.037	0.200	0.200	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.541	0.041	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	31.687	-0.063				
PA	112.500	112.087	-0.413				
DF	6.700	6.839	0.139	0.200	0.200		0.000
TP	RFS		0.474	0.300		0.000	0.174
RN	0.000	0.050	0.050	0.200	0.000		0.000

HOM-2 FLANGE NW12

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.000	0.004	0.004	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
V	-0.540	0.273	0.796			

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.130	-0.870	0.500	0.500	0.370

MM DIM LOC9= LOCATION OF CIRCLE CR-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-69.679	-69.679	100.000	100.000	0.000
Y	0.000	1193.687	1193.687	2000.000	2000.000	0.000
Z	0.000	-10.681	-10.681	100.000	100.000	0.000
D	33.800	33.891	0.091	0.150	0.000	0.000
RN	0.000	0.006	0.006	0.150	0.000	0.000

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MM DIM DIST FORMTEIL2 POINT= 2D DISTANCE FROM POINT PT-FORMTEIL2 TO PLANE PL-NW12-FLANGE-HOM2 PERP TO PLANE PL-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.596	0.176	0.100	0.100	0.076

MM DIM DIST FORMTEIL2 TAIL= 2D DISTANCE FROM PLANE PL-FORMTEIL2 TO PLANE PL-NW12-FLANGE-HOM2 PERP TO PLANE PL-NW12-FLANGE-HOM2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	28.420	28.597	0.177	0.100	0.100	0.077

MM DIM DIST NW12 FLANGE ORING DEPTH= 2D DISTANCE FROM PLANE PL-NW12-FLANGE-HOM2 O-RING TO PLANE PL-NW12-FLANGE-HOM2 PERP TO XAXIS

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0.500	0.532	0.032	0.050	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	15.591	0.591	0.500	0.500	0.091

HOM 1 LOCATION

MM DIM LOC-HOM1= LOCATION OF CYLINDER CY-HOM-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	69.126	69.126	100.000	100.000	0.000
Y	60.600	60.171	-0.429	0.200	0.200	0.229
Z	0.000	-39.794	-39.794	100.000	100.000	0.000
D	44.000	43.880	-0.120	0.000	0.100	0.020
RN	0.000	0.100	0.100	0.100	0.000	0.000
V	-0.869	0.005	0.496			

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	29.710	-0.290	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	89.694	-0.306	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	60.290	0.290	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	115.971	-0.029	0.200	0.200	0.000

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MM	DIM HOM1 PLANE= LOCATION OF PLANE PL HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	110.926	-0.074	0.200	0.200	0.000
FL	0.000	0.025	0.025	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	60.596	-0.004	0.200	0.200	0.000
Z	0.000	-0.348	-0.348	0.200	0.200	0.148

HOM 2 LOCATION

MM	DIM LOC-HOM2= LOCATION OF CYLINDER CY-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-65.061	-65.061	100.000	100.000	0.000
Y	1186.800	1190.785	3.985	3.000	3.000	0.985
Z	0.000	-44.897	-44.897	100.000	100.000	0.000
D	44.000	43.784	-0.216	0.000	0.100	0.116
RN	0.000	0.163	0.163	0.100	0.000	0.063
V	-0.825	0.006	-0.566			

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	60.099	-0.501	0.200	0.200	0.301

DEG	DIM ANGL12= 2D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.439	-0.561	0.500	0.500	0.061

DEG	DIM ANGL13= 3D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	90.362	0.362	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	55.561	0.561	0.500	0.500	0.061

MM	DIM HOM2 POINT= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	115.543	-0.457	0.200	0.200	0.257

MM	DIM HOM2 PLANE= LOCATION OF PLANE PL HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	111.000	110.474	-0.526	0.200	0.200	0.326
FL	0.000	0.002	0.002	0.200	0.000	0.000

INTERSECTION OF HOM2 & YZ PLANE

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MM	DIM LOC-HOM2 X PLANE= LOCATION OF POINT PTC-HOM2 X YZ PLANE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.000	0.000	0.200	0.200	0.000
Y	1186.800	1190.287	3.487	3.000	3.000	0.487
Z	0.000	-0.284	-0.284	0.200	0.200	0.084

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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	94.488	94.488	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.795	-0.205	0.050	0.050	0.155
RN	0.000	0.026	0.026	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	0.072	0.072	0.200	0.200	0.000
Y	0.000	123.568	123.568	2000.000	2000.000	0.000
Z	0.000	-0.272	-0.272	0.200	0.200	0.072
D	191.200	191.232	0.031	0.200	0.200	0.000
RN	0.000	0.050	0.050	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	0.005	0.005	0.200	0.200	0.000
Y	0.000	158.839	158.839	2000.000	2000.000	0.000
Z	0.000	-0.609	-0.609	0.200	0.200	0.409
D	210.300	211.102	0.802	0.200	0.200	0.602
RN	0.000	0.219	0.219	0.200	0.000	0.019

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.059	0.059	0.200	0.200	0.000
Y	0.000	167.412	167.412	2000.000	2000.000	0.000
Z	0.000	-0.687	-0.687	0.200	0.200	0.487
D	210.300	210.933	0.633	0.200	0.200	0.433
RN	0.000	0.167	0.167	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	0.190	0.190	0.200	0.200	0.000
Y	0.000	274.343	274.343	2000.000	2000.000	0.000
Z	0.000	-1.585	-1.585	0.200	0.200	1.385
D	210.300	211.105	0.805	0.200	0.200	0.605
RN	0.000	0.233	0.233	0.200	0.000	0.033

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.202	0.202	0.200	0.200	0.002
Y	0.000	282.991	282.991	2000.000	2000.000	0.000
Z	0.000	-1.638	-1.639	0.200	0.200	1.439
D	210.300	211.038	0.738	0.200	0.200	0.538
RN	0.000	0.199	0.199	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	0.154	0.154	0.200	0.200	0.000
Y	0.000	390.843	390.843	2000.000	2000.000	0.000
Z	0.000	-2.197	-2.197	0.200	0.200	1.997
D	210.300	211.214	0.914	0.200	0.200	0.714
RN	0.000	0.177	0.177	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	0.158	0.158	0.200	0.200	0.000
Y	0.000	398.985	398.985	2000.000	2000.000	0.000
Z	0.000	-2.194	-2.194	0.200	0.200	1.994
D	210.300	211.047	0.747	0.200	0.200	0.547
RN	0.000	0.219	0.219	0.200	0.000	0.019

MM DIM LOC-CC9= LOCATION OF CIRCLE CRC-CAV-4-1

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.073	0.073	0.200	0.200	0.000
Y	0.000	505.835	505.835	2000.000	2000.000	0.000
Z	0.000	-2.501	-2.501	0.200	0.200	2.301
D	210.300	211.160	0.860	0.200	0.200	0.660
RN	0.000	0.253	0.253	0.200	0.000	0.053

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.093	0.093	0.200	0.200	0.000
Y	0.000	514.298	514.298	2000.000	2000.000	0.000
Z	0.000	-2.488	-2.488	0.200	0.200	2.288
D	210.300	211.029	0.728	0.200	0.200	0.528
RN	0.000	0.234	0.234	0.200	0.000	0.034

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.016	-0.016	0.200	0.200	0.000
Y	0.000	622.388	622.388	2000.000	2000.000	0.000
Z	0.000	-2.598	-2.598	0.200	0.200	2.398
D	210.300	211.081	0.781	0.200	0.200	0.581
RN	0.000	0.210	0.210	0.200	0.000	0.010

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.066	-0.066	0.200	0.200	0.000
Y	0.000	631.017	631.017	2000.000	2000.000	0.000
Z	0.000	-2.568	-2.568	0.200	0.200	2.368
D	210.300	210.990	0.690	0.200	0.200	0.490
RN	0.000	0.137	0.137	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	-0.253	-0.253	0.200	0.200	0.053
Y	0.000	736.823	736.823	2000.000	2000.000	0.000
Z	0.000	-2.413	-2.413	0.200	0.200	2.213
D	210.300	211.295	0.994	0.200	0.200	0.794
RN	0.000	0.229	0.229	0.200	0.000	0.029

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.223	-0.223	0.200	0.200	0.023
Y	0.000	745.745	745.745	2000.000	2000.000	0.000
Z	0.000	-2.429	-2.429	0.200	0.200	2.229
D	210.300	211.065	0.764	0.200	0.200	0.564
RN	0.000	0.235	0.235	0.200	0.000	0.035

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.178	-0.178	0.200	0.200	0.000
Y	0.000	852.989	852.989	2000.000	2000.000	0.000
Z	0.000	-2.075	-2.075	0.200	0.200	1.875
D	210.300	211.128	0.828	0.200	0.200	0.628
RN	0.000	0.173	0.173	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	-0.266	-0.266	0.200	0.200	0.066
Y	0.000	861.458	861.458	2000.000	2000.000	0.000
Z	0.000	-2.014	-2.014	0.200	0.200	1.814
D	210.300	211.019	0.719	0.200	0.200	0.519
RN	0.000	0.206	0.206	0.200	0.000	0.006

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.176	-0.177	0.200	0.200	0.000
Y	0.000	968.697	968.697	2000.000	2000.000	0.000
Z	0.000	-1.411	-1.411	0.200	0.200	1.211
D	210.300	211.123	0.823	0.200	0.200	0.623
RN	0.000	0.197	0.197	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	-0.189	-0.189	0.200	0.200	0.000
Y	0.000	977.002	977.002	2000.000	2000.000	0.000
Z	0.000	-1.365	-1.365	0.200	0.200	1.165
D	210.300	211.038	0.738	0.200	0.200	0.538
RN	0.000	0.158	0.158	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	-0.115	-0.115	0.200	0.200	0.000
Y	0.000	1084.889	1084.889	2000.000	2000.000	0.000
Z	0.000	-0.573	-0.573	0.200	0.200	0.373
D	210.300	210.963	0.663	0.200	0.200	0.463
RN	0.000	0.224	0.224	0.200	0.000	0.024

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.110	-0.110	0.200	0.200	0.000
Y	0.000	1093.200	1093.200	2000.000	2000.000	0.000
Z	0.000	-0.549	-0.549	0.200	0.200	0.349
D	210.300	211.014	0.714	0.200	0.200	0.514
RN	0.000	0.181	0.181	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	-0.134	-0.134	0.200	0.200	0.000
Y	0.000	1123.866	1123.866	2000.000	2000.000	0.000
Z	0.000	-0.207	-0.207	0.200	0.200	0.007
D	200.000	200.020	0.020	0.200	0.200	0.000
RN	0.000	0.063	0.063	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	1155.205	1155.205	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.845	-0.155	0.050	0.050	0.105
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	0.072	0.072				
Z	0.000	-0.272	-0.272				
TP	RFS		0.564	0.400		0.000	0.164

⊕ MM	DIM LOC-TP-CC3= TRUE POSITION OF CIRCLE CRC-CAV-1-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.005	0.005				
Z	0.000	-0.609	-0.609				
TP	RFS		1.218	0.400		0.000	0.818

⊕ MM	DIM LOC-TP-CC4= TRUE POSITION OF CIRCLE CRC-CAV-1-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.059	0.059				
Z	0.000	-0.687	-0.687				
TP	RFS		1.380	0.400		0.000	0.980

⊕ MM	DIM LOC-TP-CC5= TRUE POSITION OF CIRCLE CRC-CAV-2-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.190	0.190				
Z	0.000	-1.585	-1.585				
TP	RFS		3.192	0.400		0.000	2.792

⊕ MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.202	0.202				
Z	0.000	-1.638	-1.639				
TP	RFS		3.302	0.400		0.000	2.902

⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.154	0.154				
Z	0.000	-2.197	-2.197				
TP	RFS		4.405	0.400		0.000	4.005

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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	0.158	0.158				
Z	0.000	-2.194	-2.194				
TP	RFS		4.399	0.400		0.000	3.999

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.073	0.073				
Z	0.000	-2.501	-2.501				
TP	RFS		5.003	0.400		0.000	4.603

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	0.093	0.093				
Z	0.000	-2.488	-2.488				
TP	RFS		4.980	0.400		0.000	4.580

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.016	-0.016				
Z	0.000	-2.598	-2.598				
TP	RFS		5.197	0.400		0.000	4.797

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.066	-0.066				
Z	0.000	-2.568	-2.568				
TP	RFS		5.137	0.400		0.000	4.737

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.253	-0.253				
Z	0.000	-2.413	-2.413				
TP	RFS		4.853	0.400		0.000	4.453

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.223	-0.223				
Z	0.000	-2.429	-2.429				
TP	RFS		4.878	0.400		0.000	4.478

⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.178	-0.178				
Z	0.000	-2.075	-2.075				
TP	RFS		4.166	0.400		0.000	3.766

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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	-0.266	-0.266				
Z	0.000	-2.014	-2.014				
TP	RFS		4.063	0.400		0.000	3.663

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.176	-0.177				
Z	0.000	-1.411	-1.411				
TP	RFS		2.844	0.400		0.000	2.444

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.189	-0.189				
Z	0.000	-1.365	-1.365				
TP	RFS		2.756	0.400		0.000	2.356

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.115	-0.115				
Z	0.000	-0.573	-0.573				
TP	RFS		1.168	0.400		0.000	0.768

⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.110	-0.110				
Z	0.000	-0.549	-0.549				
TP	RFS		1.119	0.400		0.000	0.719

⊕ MM	DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.134	-0.134				
Z	0.000	-0.207	-0.207				
TP	RFS		0.494	0.400		0.000	0.094

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

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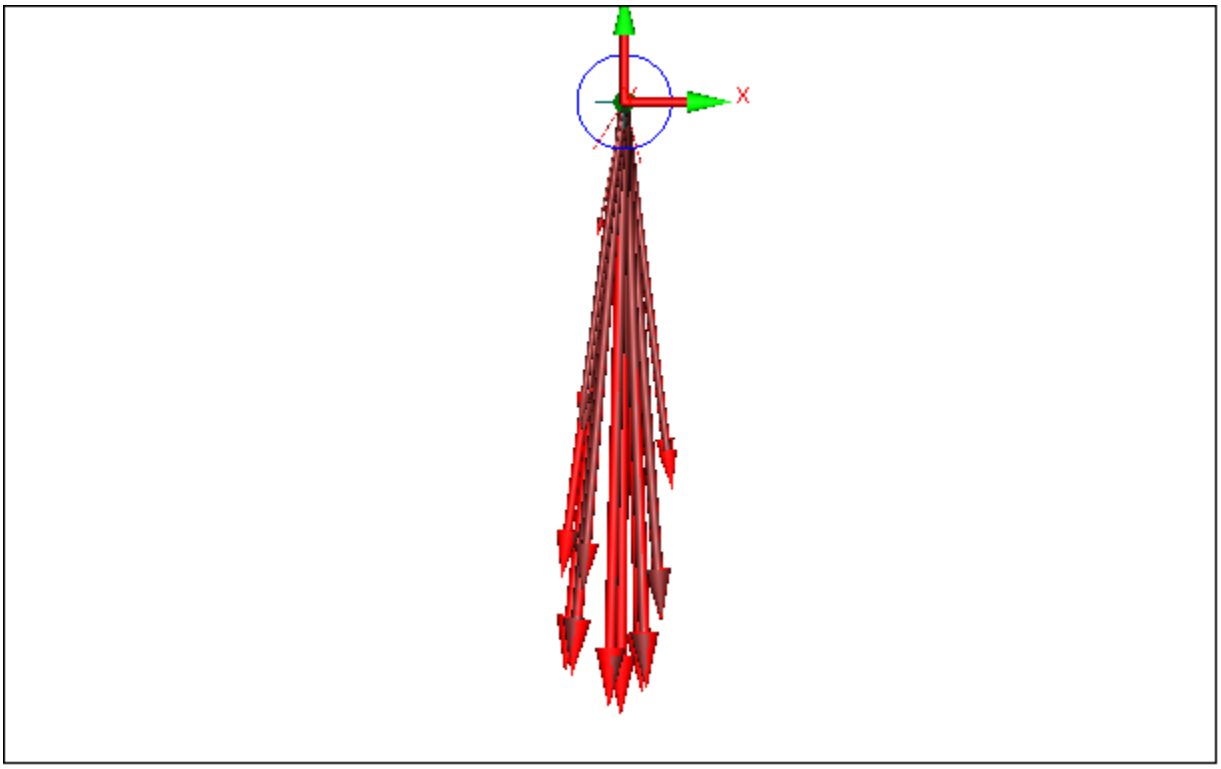
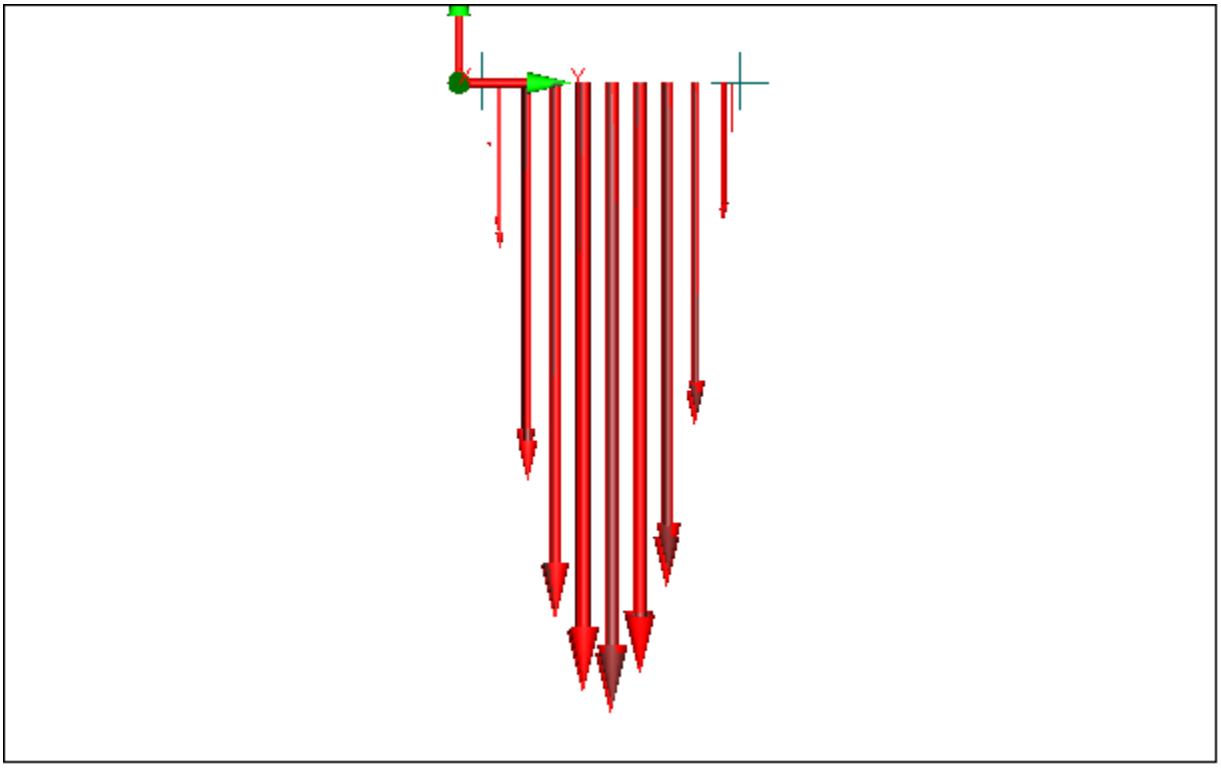
True Position plots from 3 views
x1000



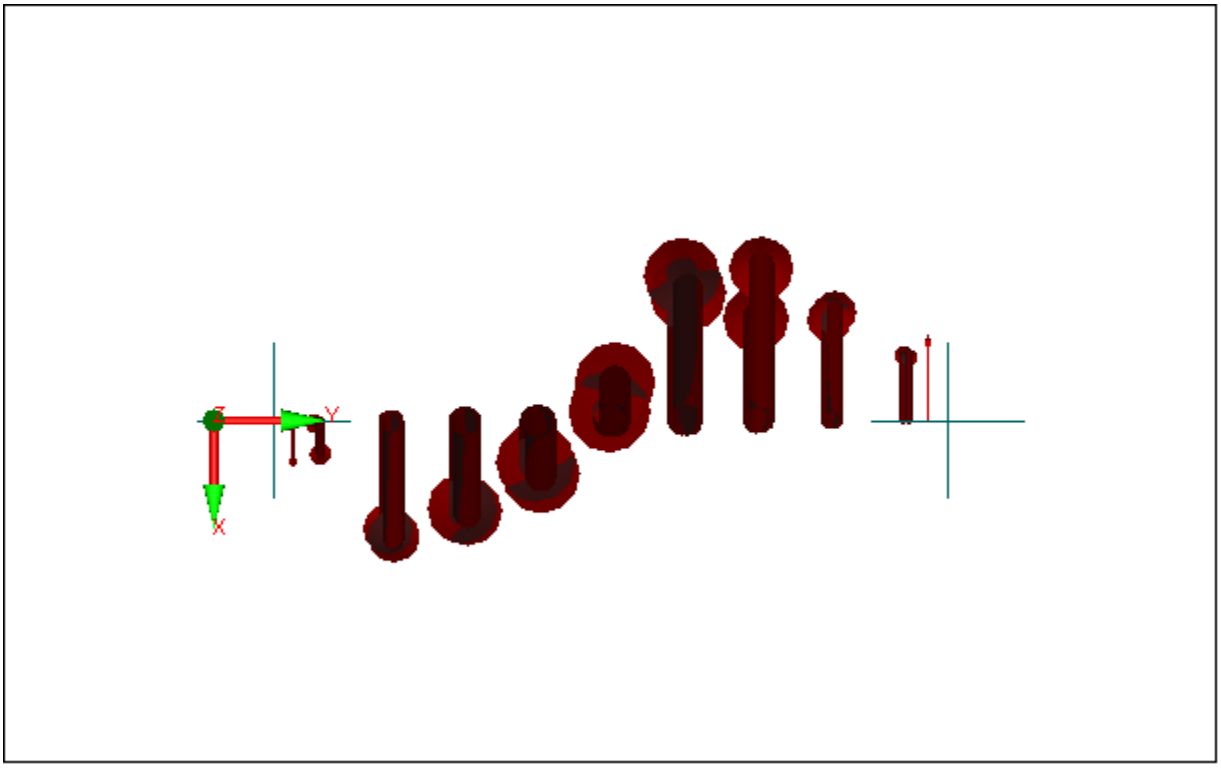
-Y View
x1000



PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9AES007 v3s IR DATE=3/5/2009

+X View

x1000



+Z View

x1000

MM	DIM LOC-BEST FIT CONSTRUCTED LINE= LOCATION OF LINE LNC-BEST-FIT					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.033	-0.033	0.200	0.200	0.000
Y	0.000	625.676	625.676	2000.000	2000.000	0.000
Z	0.000	-1.471	-1.472	0.200	0.200	1.272
ST	0.000	2.670	2.670	0.200	0.000	2.470

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	0.343	0.343	0.200	0.200	0.143
Y	0.000	221.284	221.284	2000.000	2000.000	0.000
Z	0.000	-1.065	-1.065	0.200	0.200	0.865
R	56.500	56.335	-0.165	0.200	0.200	0.000
RN	0.000	0.001	0.001	0.200	0.000	0.000

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MM DIM LOC-SUPPORT RING-P2= LOCATION OF CIRCLE CR-SUPPORT-RING-P23

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.576	0.575	0.200	0.200	0.375
Y	0.000	337.285	337.285	2000.000	2000.000	0.000
Z	0.000	-1.882	-1.882	0.200	0.200	1.682
R	56.500	56.399	-0.101	0.200	0.200	0.000
RN	0.000	0.049	0.049	0.200	0.000	0.000

MM DIM LOC-SUPPORT RING-P3= LOCATION OF CIRCLE CR-SUPPORT-RING-P34

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.379	0.379	0.200	0.200	0.179
Y	0.000	453.284	453.284	2000.000	2000.000	0.000
Z	0.000	-2.468	-2.469	0.200	0.200	2.269
R	56.500	56.450	-0.050	0.200	0.200	0.000
RN	0.000	0.054	0.054	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	0.129	0.129	0.200	0.200	0.000
Y	0.000	569.284	569.284	2000.000	2000.000	0.000
Z	0.000	-2.661	-2.662	0.200	0.200	2.462
R	56.500	56.435	-0.065	0.200	0.200	0.000
RN	0.000	0.031	0.031	0.200	0.000	0.000

MM DIM LOC-SUPPORT RING-P5= LOCATION OF CIRCLE CR-SUPPORT-RING-P56

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.099	0.099	0.200	0.200	0.000
Y	0.000	685.284	685.284	2000.000	2000.000	0.000
Z	0.000	-3.001	-3.001	0.200	0.200	2.801
R	56.500	56.825	0.325	0.200	0.200	0.125
RN	0.000	0.202	0.202	0.200	0.000	0.002

MM DIM LOC-SUPPORT RING-P6= LOCATION OF CIRCLE CR-SUPPORT-RING-P67

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.010	0.010	0.200	0.200	0.000
Y	0.000	800.285	800.285	2000.000	2000.000	0.000
Z	0.000	-2.226	-2.226	0.200	0.200	2.026
R	56.500	56.339	-0.161	0.200	0.200	0.000
RN	0.000	0.008	0.008	0.200	0.000	0.000

MM DIM LOC-SUPPORT RING-P7= LOCATION OF CIRCLE CR-SUPPORT-RING-P78

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.101	0.101	0.200	0.200	0.000
Y	0.000	916.291	916.291	2000.000	2000.000	0.000
Z	0.000	-1.722	-1.722	0.200	0.200	1.522
R	56.500	56.410	-0.090	0.200	0.200	0.000
RN	0.000	0.039	0.039	0.200	0.000	0.000

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MM	DIM LOC-SUPPORT RING-P8= LOCATION OF CIRCLE CR-SUPPORT-RING-P89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.254	0.254	0.200	0.200	0.054
Y	0.000	1032.287	1032.287	2000.000	2000.000	0.000
Z	0.000	-1.184	-1.184	0.200	0.200	0.984
R	56.500	56.375	-0.125	0.200	0.200	0.000
RN	0.000	0.114	0.114	0.200	0.000	0.000

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	56.587	0.087	0.200	0.200	0.000
Y	0.000	213.985	213.985	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	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	56.822	0.322	0.200	0.200	0.122
Y	0.000	330.185	330.185	2000.000	2000.000	0.000
Z	0.000	0.002	0.002	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	56.687	0.187	0.200	0.200	0.000
Y	0.000	446.785	446.785	2000.000	2000.000	0.000
Z	0.000	0.003	0.003	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	56.593	0.093	0.200	0.200	0.000
Y	0.000	562.485	562.485	2000.000	2000.000	0.000
Z	0.000	0.004	0.004	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	56.724	0.224	0.200	0.200	0.024
Y	0.000	678.185	678.185	2000.000	2000.000	0.000
Z	0.000	0.006	0.006	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	56.310	-0.190	0.200	0.200	0.000
Y	0.000	794.385	794.385	2000.000	2000.000	0.000
Z	0.000	0.007	0.007	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	56.399	-0.101	0.200	0.200	0.000
Y	0.000	909.785	909.785	2000.000	2000.000	0.000
Z	0.000	0.009	0.009	0.200	0.200	0.000

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MM	DIM LOC-SUPPORT RING-PTP8= LOCATION OF POINT PT-SUPPORT-RING-P89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.827	0.327	0.200	0.200	0.127
Y	0.000	1025.885	1025.885	2000.000	2000.000	0.000
Z	0.000	0.010	0.010	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	0.343	0.343	0.200	0.200	0.143

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	0.576	0.576	0.200	0.200	0.376

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	0.379	0.379	0.200	0.200	0.179

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	0.129	0.129	0.200	0.200	0.000

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	0.099	0.099	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	0.010	0.010	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	0.101	0.101	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	0.254	0.254	0.200	0.200	0.054

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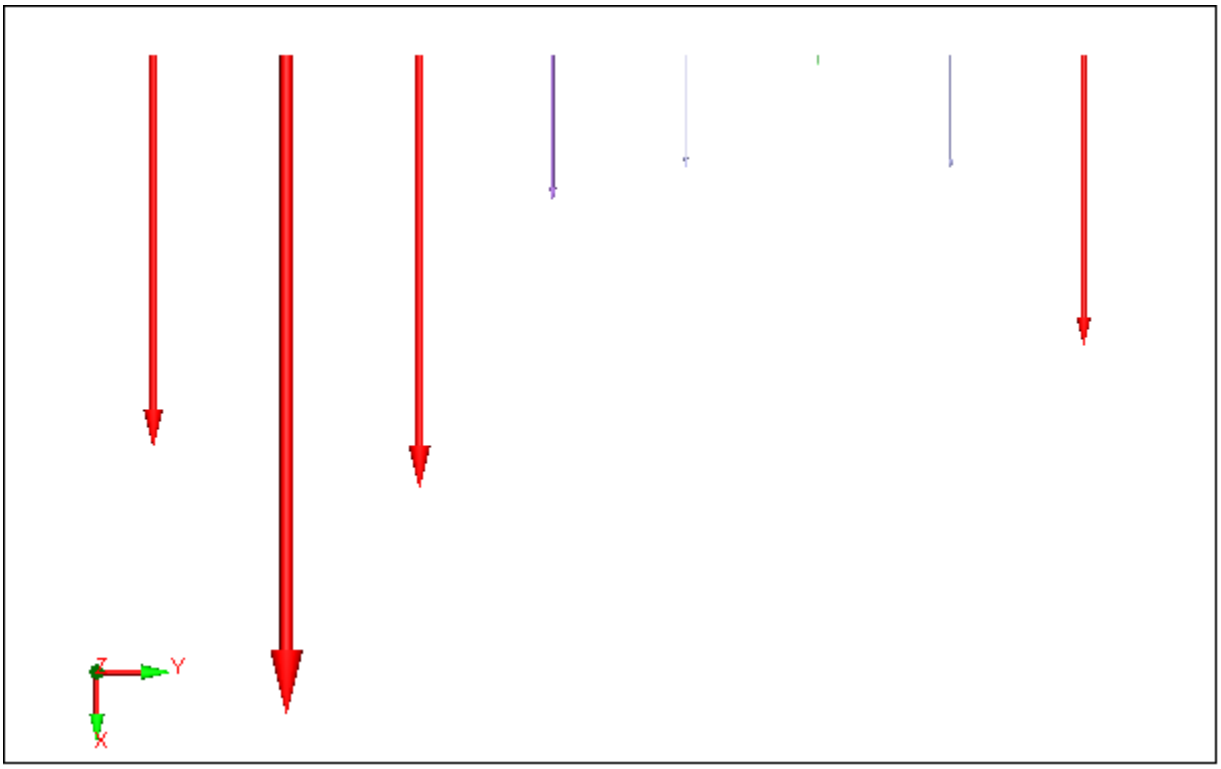

SUPPORT RING CIRCLES IN X
Positive Side
x1000

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	56.587	0.088	0.200	0.200	0.000

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	56.822	0.322	0.200	0.200	0.122

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	56.687	0.187	0.200	0.200	0.000

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	56.593	0.093	0.200	0.200	0.000

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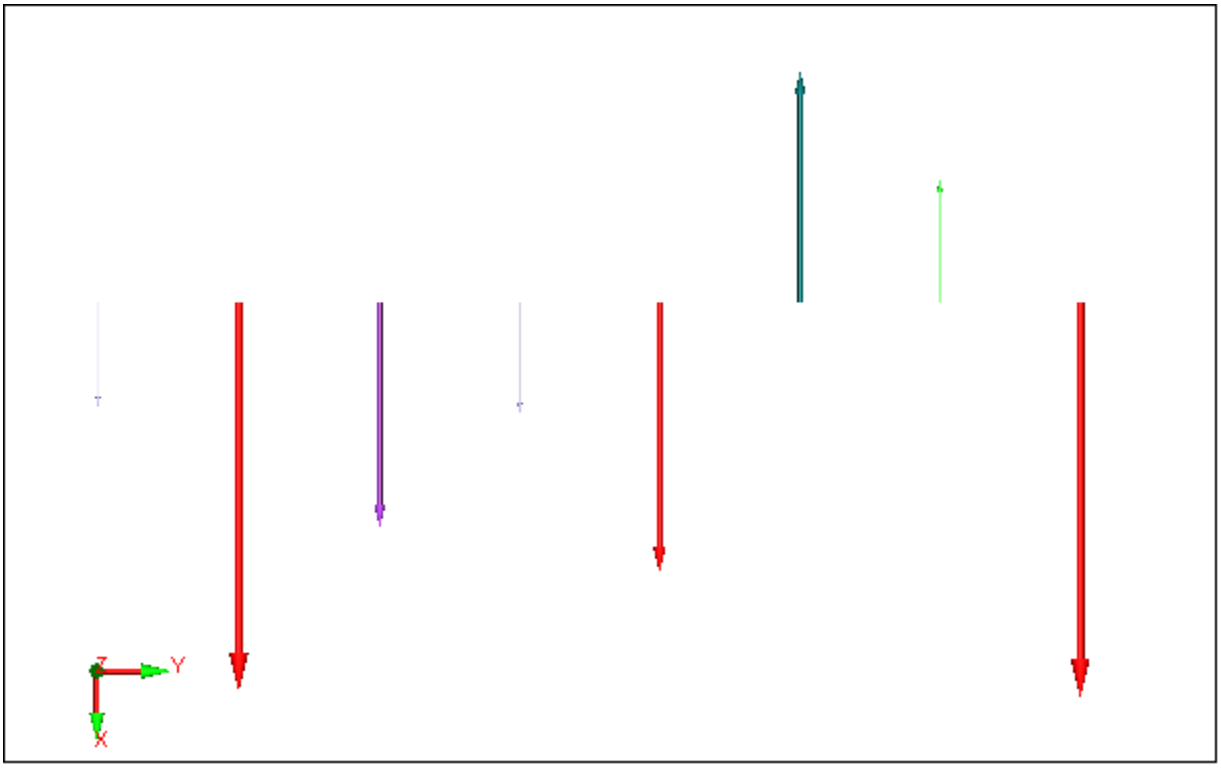
MM	DIM LOC X SUPPORT RING POINTS P5= LOCATION OF POINT PT-SUPPORT-RING-P56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	56.500	56.724	0.224	0.200	0.200	0.024

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	56.310	-0.190	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	56.399	-0.100	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	56.827	0.327	0.200	0.200	0.127



SUPPORT RING POINTS IN X
Positive Side
x1000

SUPPORT RING CIRCLE LOCATIONS
Negative side

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9AES007 v3s IR DATE=3/5/2009

MM	DIM LOC-SUPPORT RING-N1= LOCATION OF CIRCLE CR-SUPPORT-RING-N12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.186	-0.186	0.200	0.200	0.000
Y	0.000	221.278	221.278	2000.000	2000.000	0.000
Z	0.000	-1.053	-1.053	0.200	0.200	0.853
R	56.500	56.355	-0.145	0.200	0.200	0.000
RN	0.000	0.077	0.077	0.200	0.000	0.000

MM	DIM LOC-SUPPORT RING-N2= LOCATION OF CIRCLE CR-SUPPORT-RING-N23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.062	-0.062	0.200	0.200	0.000
Y	0.000	337.279	337.279	2000.000	2000.000	0.000
Z	0.000	-1.944	-1.944	0.200	0.200	1.744
R	56.500	56.442	-0.058	0.200	0.200	0.000
RN	0.000	0.057	0.057	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	0.288	0.288	0.200	0.200	0.088
Y	0.000	453.281	453.281	2000.000	2000.000	0.000
Z	0.000	-2.078	-2.078	0.200	0.200	1.878
R	56.500	56.881	0.381	0.200	0.200	0.181
RN	0.000	0.050	0.050	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	-0.139	-0.139	0.200	0.200	0.000
Y	0.000	569.280	569.280	2000.000	2000.000	0.000
Z	0.000	-2.474	-2.474	0.200	0.200	2.274
R	56.500	56.549	0.049	0.200	0.200	0.000
RN	0.000	0.192	0.192	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	-0.305	-0.305	0.200	0.200	0.105
Y	0.000	685.283	685.283	2000.000	2000.000	0.000
Z	0.000	-2.540	-2.540	0.200	0.200	2.340
R	56.500	56.394	-0.106	0.200	0.200	0.000
RN	0.000	0.119	0.119	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	-0.563	-0.563	0.200	0.200	0.363
Y	0.000	800.282	800.282	2000.000	2000.000	0.000
Z	0.000	-2.295	-2.295	0.200	0.200	2.095
R	56.500	56.444	-0.056	0.200	0.200	0.000
RN	0.000	0.054	0.054	0.200	0.000	0.000

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MM	DIM LOC-SUPPORT RING-N7= LOCATION OF CIRCLE CR-SUPPORT-RING-N78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.518	-0.518	0.200	0.200	0.318
Y	0.000	916.280	916.280	2000.000	2000.000	0.000
Z	0.000	-1.681	-1.681	0.200	0.200	1.481
R	56.500	56.327	-0.173	0.200	0.200	0.000
RN	0.000	0.002	0.002	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	-0.218	-0.218	0.200	0.200	0.018
Y	0.000	1032.286	1032.286	2000.000	2000.000	0.000
Z	0.000	-1.162	-1.162	0.200	0.200	0.962
R	56.500	56.505	0.005	0.200	0.200	0.000
RN	0.000	0.066	0.066	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	-56.435	0.065	0.200	0.200	0.000
Y	0.000	213.985	213.985	2000.000	2000.000	0.000
Z	0.000	-0.003	-0.003	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	-56.337	0.163	0.200	0.200	0.000
Y	0.000	330.185	330.185	2000.000	2000.000	0.000
Z	0.000	-0.002	-0.002	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	-56.457	0.043	0.200	0.200	0.000
Y	0.000	446.785	446.785	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	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	-56.682	-0.182	0.200	0.200	0.000
Y	0.000	562.485	562.485	2000.000	2000.000	0.000
Z	0.000	0.001	0.001	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	-56.598	-0.098	0.200	0.200	0.000
Y	0.000	678.185	678.185	2000.000	2000.000	0.000
Z	0.000	0.003	0.002	0.200	0.200	0.000

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MM	DIM LOC-SUPPORT RING-PTN6= LOCATION OF POINT PT-SUPPORT-RING-N67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-57.125	-0.625	0.200	0.200	0.425
Y	0.000	794.385	794.385	2000.000	2000.000	0.000
Z	0.000	0.004	0.004	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	-56.710	-0.210	0.200	0.200	0.010
Y	0.000	909.785	909.785	2000.000	2000.000	0.000
Z	0.000	0.006	0.005	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	-56.747	-0.247	0.200	0.200	0.047
Y	0.000	1025.885	1025.885	2000.000	2000.000	0.000
Z	0.000	0.007	0.007	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	-0.186	-0.186	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	-0.062	-0.062	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	0.288	0.288	0.200	0.200	0.088

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	-0.139	-0.139	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	-0.305	-0.305	0.200	0.200	0.105

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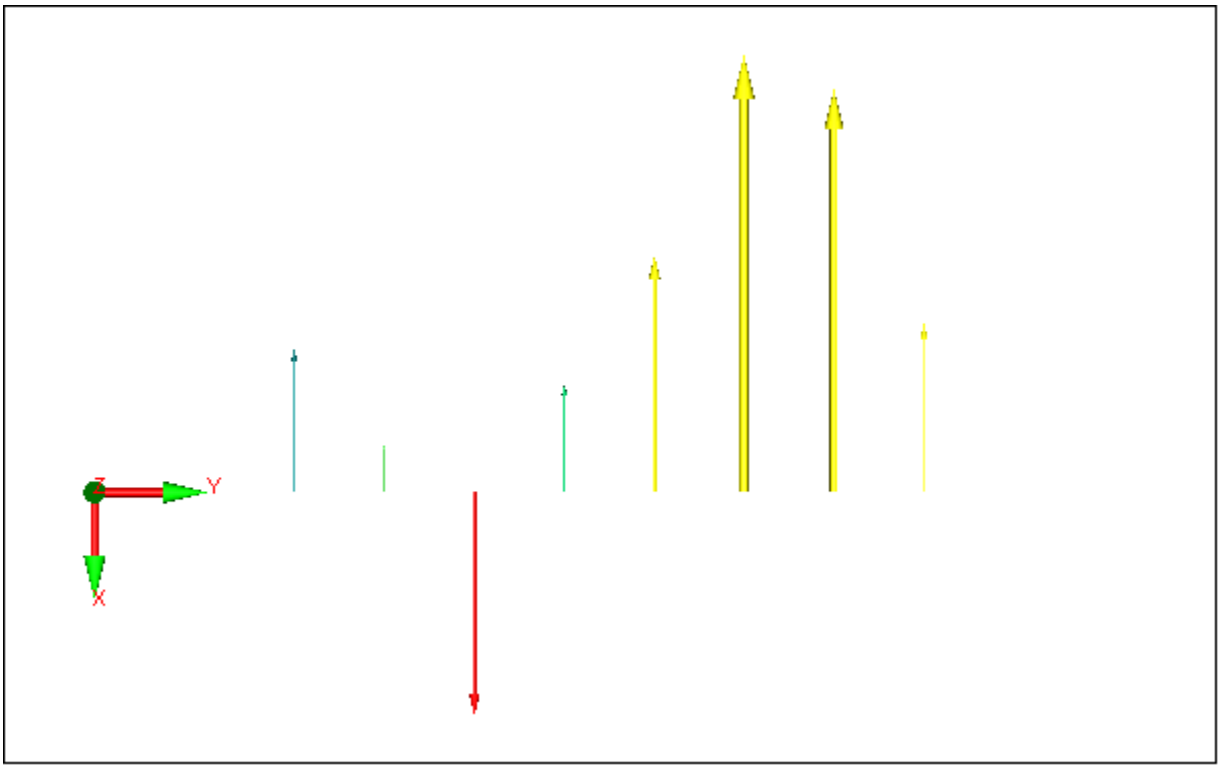
MM	DIM LOC X SUPPORT RING CIRCLES N6= LOCATION OF CIRCLE CR-SUPPORT-RING-N67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.563	-0.563	0.200	0.200	0.363

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	-0.518	-0.518	0.200	0.200	0.318

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	-0.218	-0.218	0.200	0.200	0.018



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	-56.435	0.065	0.200	0.200	0.000

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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	-56.337	0.163	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	-56.457	0.043	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	-56.682	-0.182	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	-56.598	-0.098	0.200	0.200	0.000

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	-57.125	-0.625	0.200	0.200	0.425

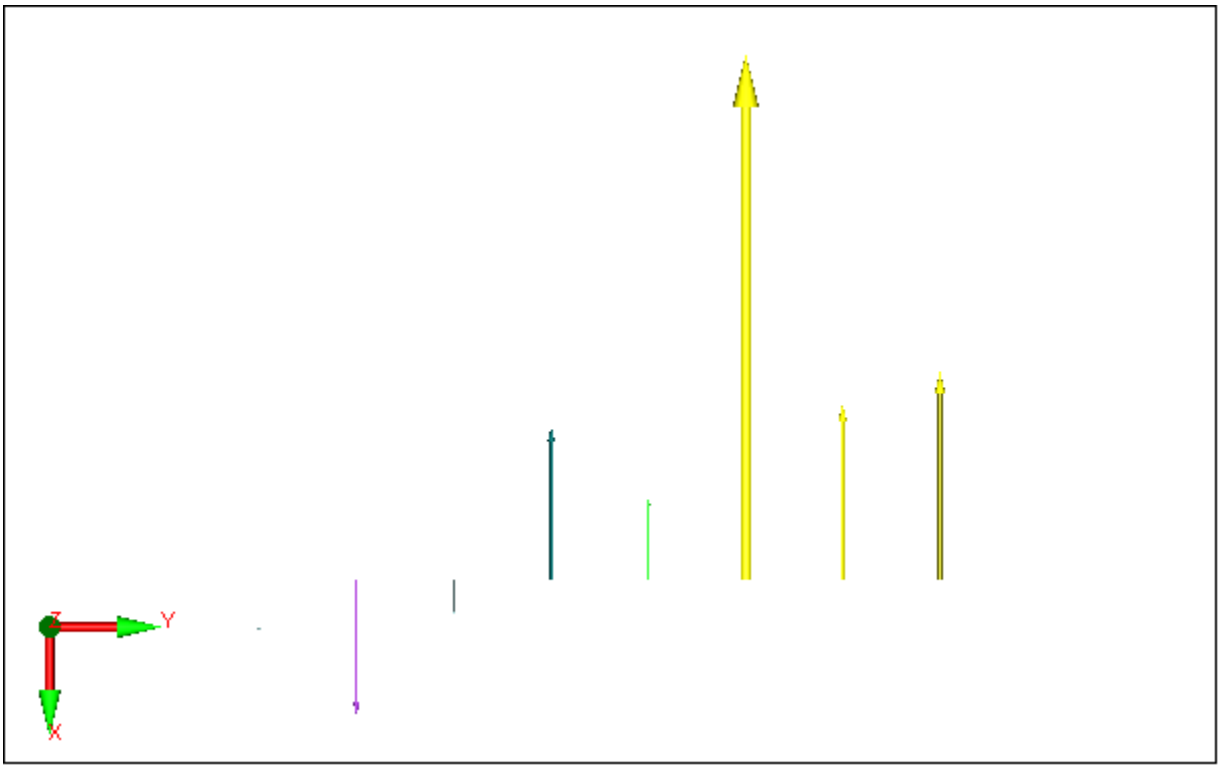
MM DIM LOC X SUPPORT RING POINTS N7= LOCATION OF POINT PT-SUPPORT-RING-N7

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.710	-0.210	0.200	0.200	0.010

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	-56.747	-0.247	0.200	0.200	0.047

PART NUMBER=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9AES007 v3s IR DATE=3/5/2009



SUPPORT RING POINT IN X
Negative Side
x1000

END OF MEASUREMENT FOR
PN=PN440004-n ILC 1p3GHZ RF CAVITY ASSEMBLY 000 TB9AES007 v3s IR
DWG= SN=
TOTAL # OF MEAS =409 # OUT OF TOL =175