FERMILAB Technical Division

QUALITY CONTROL REPORT

DATE=3/26/2007 TIME=9:42:46 AM

PART NAME : ILC AES 1.3GHZ RF CAVITY ASSEMBLY
REV NUMBER :
SER NUMBER :
STATS COUNT : 1

'Inspected by' : Robert Riley
'Cavity Number' : AES004 000 RUN 1

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	0.005			
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	0.583	0.583	0.200	0.000	0.383

DEG	DIM ANGL1= 3D ANGLE (COMPLEMENT) FROM PLANE PL-NEAR-END-FLANGE TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.280	0.280	0.100	0.100	0.180

MM	DIM LOC2= LOCATION OF CIRCLE CR-NEAR-END -FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.077	-0.078	0.200	0.200	0.000
Z	0.000	0.636	0.636	0.200	0.200	0.436
D	140.000	140.000	0.000	0.300	0.300	0.000
RN	0.000	0.005	0.005	0.200	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	1283.400	1275.355	-8.045	3.000	3.000	5.045
V	-0.002	1.000	0.003			
FL	0.000	0.040	0.040	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	0.467	0.467	0.200	0.000	0.267

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DEG	DIM ANGL2= 3D ANGLE (COMPLEMENT) FROM PLANE PL-FAR-END TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.229	0.229	0.100	0.100	0.129

MM	DIM LOC4= LOCATION OF CIRCLE CR-FAR-END					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.216	-0.217	0.200	0.200	0.017
Z	0.000	0.297	0.297	0.200	0.200	0.097
D	140.000	140.022	0.022	0.300	0.300	0.000
RN	0.000	0.029	0.029	0.200	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	128.800	127.191	-1.609	0.200	0.200	1.409
V	0.001	-1.000	0.002			
FL	0.000	0.073	0.073	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	0.323	0.323	0.200	0.000	0.123

DEG	DIM ANGL7= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.153	0.153	0.100	0.100	0.053

DATUM-2-PLANE

MM	DIM LOC-DATUM-2-PLANE= LOCATION OF PLANE PLC-DAT-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1190.000	1183.891	-6.109	0.200	0.200	5.909
V	0.001	1.000	0.002			
FL	0.000	0.076	0.076	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	0.264	0.264	0.200	0.000	0.064

DEG	DIM ANGL8= 3D ANGLE (TRUE) FROM PLANE PLC-DAT-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.124	0.124	0.100	0.100	0.024

PICKUP ANTENNA FLANGE NW8

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MM DIM LOC5= LOCATION OF PLANE PL-NW8-ANTENNA-FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-53.800	-54.230	-0.430	0.200	0.200	0.230
V	-1.000	0.003	-0.005			
FL	0.000	0.005	0.005	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	0.148	0.148	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	0.330	0.330	0.100	0.100	0.230

MM DIM LOC6= LOCATION OF CIRCLE CR-NW8-ANTENNA-FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	96.600	96.764	0.164	0.200	0.200	0.000
Z	0.000	-0.684	-0.684	0.200	0.200	0.484
D	33.800	33.816	0.016	0.150	0.000	0.000
RN	0.000	0.009	0.009	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	88.054	0.054	0.200	0.200	0.000
V	1.000	0.003	-0.010			
FL	0.000	0.016	0.016	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	0.621	0.621	0.200	0.000	0.421

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	0.000	0.578	0.578	0.100	0.100	0.478

MM DIM LOC8= LOCATION OF CIRCLE CR-NW-40-FLANGE

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Y	1222.800	1216.459	-6.341	0.200	0.200	6.141
Z	0.000	-0.751	-0.751	0.200	0.200	0.551
D	76.000	76.021	0.021	0.200	0.000	0.000
RN	0.000	0.012	0.012	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	58.896	-1.704	0.200	0.200	1.504

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HOM-2 FLANGE NW12

MM	DIM FLAT4= FLATNESS OF PLANE PL-NW12-HOM-FLANGE					
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-HOM-FLANGE TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	17.761	2.761	0.500	0.500	2.261

DEG	DIM ANGL6= 2D ANGLE (TRUE) FROM PLANE PL-NW12-HOM-FLANGE TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.166	-0.834	0.500	0.500	0.334

MM	DIM LOC9= LOCATION OF CIRCLE CR-NW12-HOM-FLANGE					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-72.454	-72.454	100.000	100.000	0.000
Y	0.000	1219.694	1219.694	2000.000	2000.000	0.000
Z	0.000	-7.870	-7.870	100.000	100.000	0.000
D	33.800	33.846	0.046	0.150	0.000	0.000
RN	0.000	0.002	0.002	0.150	0.000	0.000

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HOM 1 LOCATION

MM	DIM LOC-HOM1= LOCATION OF CYLINDER CY-HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	69.820	69.820	100.000	100.000	0.000
Y	96.600	96.365	-0.235	0.200	0.200	0.035
Z	0.000	-38.516	-38.516	100.000	100.000	0.000
D	44.000	43.732	-0.268	0.000	0.100	0.168
RN	0.000	0.213	0.213	0.100	0.000	0.113
V	-0.873	0.004	0.487			

DEG	DIM ANGL9= 3D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-1 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	30.000	29.160	-0.840	0.500	0.500	0.340

DEG	DIM ANGL10= 3D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	89.770	-0.230	0.500	0.500	0.000

DEG	DIM ANGL11= 3D ANGLE (TRUE) FROM CYLINDER CY-HOM-1 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	60.000	60.842	0.842	0.500	0.500	0.342

MM	DIM LOC-HOM3= LOCATION OF POINT PT-RT-HOM-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.250	0.250	0.200	0.200	0.050

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	96.600	96.686	0.086	0.200	0.200	0.000
Z	0.000	0.439	0.439	0.200	0.200	0.239

HOM 2 LOCATION

MM	DIM LOC-HOM2= LOCATION OF CYLINDER CY-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-65.212	-65.212	100.000	100.000	0.000
Y	1222.800	1216.387	-6.413	3.000	3.000	3.413
Z	0.000	-44.390	-44.390	100.000	100.000	0.000
D	44.000	43.829	-0.171	0.000	0.100	0.071
RN	0.000	0.150	0.150	0.100	0.000	0.050
V	-0.826	-0.000	-0.563			

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	57.871	-2.729	0.200	0.200	2.529

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DEG	DIM ANGL12= 3D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO XAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	35.000	34.280	-0.720	0.500	0.500	0.220

DEG	DIM ANGL13= 3D ANGLE (COMPLEMENT) FROM CYLINDER CY-HOM-2 TO YAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	90.000	90.012	0.012	0.500	0.500	0.000

DEG	DIM ANGL14= 3D ANGLE (TRUE) FROM CYLINDER CY-HOM-2 TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	55.000	55.720	0.720	0.500	0.500	0.220

MM	DIM LOC-HOM4= LOCATION OF POINT PT-HOM-2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
PR	116.000	116.260	0.260	0.200	0.200	0.060

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	1222.800	1216.404	-6.396	3.000	3.000	3.396
Z	0.000	0.061	0.061	0.200	0.200	0.000

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	129.085	129.085	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.678	-0.322	0.200	0.200	0.122
RN	0.000	0.065	0.065	0.200	0.000	0.000

MM	DIM LOC-CC2= LOCATION OF CIRCLE CRC-VAC-1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.027	-0.027	0.200	0.200	0.000
Y	0.000	157.090	157.090	2000.000	2000.000	0.000
Z	0.000	-0.049	-0.049	0.200	0.200	0.000
D	191.200	191.284	0.084	0.200	0.200	0.000
RN	0.000	0.064	0.064	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	-0.155	-0.155	0.200	0.200	0.000
Y	0.000	192.042	192.042	2000.000	2000.000	0.000
Z	0.000	-0.101	-0.101	0.200	0.200	0.000
D	210.300	211.071	0.770	0.200	0.200	0.570
RN	0.000	0.156	0.156	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.122	-0.122	0.200	0.200	0.000
Y	0.000	200.398	200.398	2000.000	2000.000	0.000
Z	0.000	-0.124	-0.124	0.200	0.200	0.000
D	210.300	211.024	0.724	0.200	0.200	0.524
RN	0.000	0.157	0.157	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	-0.150	-0.150	0.200	0.200	0.000
Y	0.000	307.665	307.665	2000.000	2000.000	0.000
Z	0.000	-0.421	-0.421	0.200	0.200	0.221
D	210.300	211.482	1.182	0.200	0.200	0.982
RN	0.000	0.228	0.228	0.200	0.000	0.028

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.127	-0.127	0.200	0.200	0.000
Y	0.000	315.815	315.815	2000.000	2000.000	0.000
Z	0.000	-0.405	-0.405	0.200	0.200	0.205
D	210.300	211.400	1.099	0.200	0.200	0.899
RN	0.000	0.172	0.172	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.186	-0.187	0.200	0.200	0.000
Y	0.000	422.359	422.359	2000.000	2000.000	0.000
Z	0.000	-0.645	-0.645	0.200	0.200	0.445
D	210.300	211.386	1.086	0.200	0.200	0.886
RN	0.000	0.260	0.260	0.200	0.000	0.060

MM DIM LOC-CC8= LOCATION OF CIRCLE CRC-CAV-3-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.126	-0.126	0.200	0.200	0.000
Y	0.000	430.983	430.983	2000.000	2000.000	0.000
Z	0.000	-0.569	-0.569	0.200	0.200	0.369
D	210.300	211.259	0.959	0.200	0.200	0.759
RN	0.000	0.183	0.183	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	-0.219	-0.219	0.200	0.200	0.019
Y	0.000	537.356	537.356	2000.000	2000.000	0.000
Z	0.000	-0.650	-0.650	0.200	0.200	0.450
D	210.300	211.372	1.071	0.200	0.200	0.871
RN	0.000	0.202	0.202	0.200	0.000	0.002

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.221	-0.221	0.200	0.200	0.021
Y	0.000	545.967	545.967	2000.000	2000.000	0.000
Z	0.000	-0.668	-0.668	0.200	0.200	0.468
D	210.300	211.340	1.040	0.200	0.200	0.840
RN	0.000	0.144	0.144	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.246	-0.246	0.200	0.200	0.046
Y	0.000	652.576	652.576	2000.000	2000.000	0.000
Z	0.000	-0.693	-0.693	0.200	0.200	0.493
D	210.300	211.561	1.260	0.200	0.200	1.060
RN	0.000	0.157	0.157	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	-0.163	-0.163	0.200	0.200	0.000
Y	0.000	660.906	660.906	2000.000	2000.000	0.000
Z	0.000	-0.706	-0.706	0.200	0.200	0.506
D	210.300	211.554	1.254	0.200	0.200	1.054
RN	0.000	0.234	0.234	0.200	0.000	0.034

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.194	-0.194	0.200	0.200	0.000
Y	0.000	768.081	768.081	2000.000	2000.000	0.000
Z	0.000	-0.669	-0.669	0.200	0.200	0.469
D	210.300	211.508	1.208	0.200	0.200	1.008
RN	0.000	0.177	0.177	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	-0.243	-0.243	0.200	0.200	0.043
Y	0.000	776.330	776.330	2000.000	2000.000	0.000
Z	0.000	-0.693	-0.693	0.200	0.200	0.493
D	210.300	211.433	1.133	0.200	0.200	0.933
RN	0.000	0.181	0.181	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	-0.202	-0.202	0.200	0.200	0.002
Y	0.000	882.737	882.737	2000.000	2000.000	0.000
Z	0.000	-0.617	-0.618	0.200	0.200	0.418
D	210.300	211.415	1.114	0.200	0.200	0.914
RN	0.000	0.282	0.282	0.200	0.000	0.082

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.173	-0.173	0.200	0.200	0.000
Y	0.000	890.809	890.809	2000.000	2000.000	0.000
Z	0.000	-0.540	-0.540	0.200	0.200	0.340
D	210.300	211.405	1.105	0.200	0.200	0.905
RN	0.000	0.226	0.226	0.200	0.000	0.026

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.204	-0.204	0.200	0.200	0.004
Y	0.000	997.636	997.636	2000.000	2000.000	0.000
Z	0.000	-0.366	-0.366	0.200	0.200	0.166
D	210.300	211.340	1.039	0.200	0.200	0.839
RN	0.000	0.222	0.222	0.200	0.000	0.022

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.168	-0.168	0.200	0.200	0.000
Y	0.000	1005.995	1005.995	2000.000	2000.000	0.000
Z	0.000	-0.364	-0.364	0.200	0.200	0.164
D	210.300	211.438	1.137	0.200	0.200	0.937
RN	0.000	0.193	0.193	0.200	0.000	0.000

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

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.247	-0.247	0.200	0.200	0.047
Y	0.000	1112.648	1112.648	2000.000	2000.000	0.000
Z	0.000	-0.093	-0.093	0.200	0.200	0.000
D	210.300	211.031	0.731	0.200	0.200	0.531
RN	0.000	0.121	0.121	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	-0.125	-0.125	0.200	0.200	0.000
Y	0.000	1120.384	1120.384	2000.000	2000.000	0.000
Z	0.000	-0.136	-0.136	0.200	0.200	0.000
D	210.300	210.925	0.624	0.200	0.200	0.424
RN	0.000	0.222	0.222	0.200	0.000	0.022

MM DIM LOC-CC21= LOCATION OF CIRCLE CRC-VAC-2

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.045	-0.045	0.200	0.200	0.000
Y	0.000	1150.964	1150.964	2000.000	2000.000	0.000
Z	0.000	-0.067	-0.067	0.200	0.200	0.000
D	200.000	200.081	0.081	0.200	0.200	0.000
RN	0.000	0.068	0.068	0.200	0.000	0.000

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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	1181.909	1181.909	2000.000	2000.000	0.000
Z	0.000	0.000	0.000	0.200	0.200	0.000
D	111.000	110.766	-0.234	0.200	0.200	0.034
RN	0.000	0.073	0.073	0.200	0.000	0.000

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	0.200		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	-0.027	-0.027				
Z	0.000	-0.049	-0.049				
TP	RFS		0.111	0.200		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	-0.155	-0.155				
Z	0.000	-0.101	-0.101				
TP	RFS		0.371	0.200		0.000	0.171

MM	DIM LOC-TP-CC4= TRUE POSITION OF CIRCLE CRC-CAV-1-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.122	-0.122				
Z	0.000	-0.124	-0.124				
TP	RFS		0.348	0.200		0.000	0.148

MM	DIM LOC-TP-CC5= TRUE POSITION OF CIRCLE CRC-CAV-2-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.150	-0.150				
Z	0.000	-0.421	-0.421				
TP	RFS		0.894	0.200		0.000	0.694

MM	DIM LOC-TP-CC6= TRUE POSITION OF CIRCLE CRC-CAV-2-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.127	-0.127				
Z	0.000	-0.405	-0.405				
TP	RFS		0.850	0.200		0.000	0.650

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⊕ MM	DIM LOC-TP-CC7= TRUE POSITION OF CIRCLE CRC-CAV-3-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.186	-0.187					
Z	0.000	-0.645	-0.645					
TP	RFS		1.343	0.200		0.000	1.143	

⊕ MM	DIM LOC-TP-CC8= TRUE POSITION OF CIRCLE CRC-CAV-3-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.126	-0.126					
Z	0.000	-0.569	-0.569					
TP	RFS		1.165	0.200		0.000	0.965	

⊕ MM	DIM LOC-TP-CC9= TRUE POSITION OF CIRCLE CRC-CAV-4-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.219	-0.219					
Z	0.000	-0.650	-0.650					
TP	RFS		1.373	0.200		0.000	1.173	

⊕ MM	DIM LOC-TP-CC10= TRUE POSITION OF CIRCLE CRC-CAV-4-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.221	-0.221					
Z	0.000	-0.668	-0.668					
TP	RFS		1.408	0.200		0.000	1.208	

⊕ MM	DIM LOC-TP-CC11= TRUE POSITION OF CIRCLE CRC-CAV-5-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.246	-0.246					
Z	0.000	-0.693	-0.693					
TP	RFS		1.471	0.200		0.000	1.271	

⊕ MM	DIM LOC-TP-CC12= TRUE POSITION OF CIRCLE CRC-CAV-5-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.163	-0.163					
Z	0.000	-0.706	-0.706					
TP	RFS		1.449	0.200		0.000	1.249	

⊕ MM	DIM LOC-TP-CC13= TRUE POSITION OF CIRCLE CRC-CAV-6-1							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.194	-0.194					
Z	0.000	-0.669	-0.669					
TP	RFS		1.393	0.200		0.000	1.193	

⊕ MM	DIM LOC-TP-CC14= TRUE POSITION OF CIRCLE CRC-CAV-6-2							
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL	
X	0.000	-0.243	-0.243					
Z	0.000	-0.693	-0.693					
TP	RFS		1.470	0.200		0.000	1.270	

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⊕ MM	DIM LOC-TP-CC15= TRUE POSITION OF CIRCLE CRC-CAV-7-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.202	-0.202				
Z	0.000	-0.617	-0.618				
TP	RFS		1.300	0.200		0.000	1.100

⊕ MM	DIM LOC-TP-CC16= TRUE POSITION OF CIRCLE CRC-CAV-7-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.173	-0.173				
Z	0.000	-0.540	-0.540				
TP	RFS		1.135	0.200		0.000	0.935

⊕ MM	DIM LOC-TP-CC17= TRUE POSITION OF CIRCLE CRC-CAV-8-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.204	-0.204				
Z	0.000	-0.366	-0.366				
TP	RFS		0.838	0.200		0.000	0.638

⊕ MM	DIM LOC-TP-CC18= TRUE POSITION OF CIRCLE CRC-CAV-8-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.168	-0.168				
Z	0.000	-0.364	-0.364				
TP	RFS		0.802	0.200		0.000	0.602

⊕ MM	DIM LOC-TP-CC19= TRUE POSITION OF CIRCLE CRC-CAV-9-1						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.247	-0.247				
Z	0.000	-0.093	-0.093				
TP	RFS		0.528	0.200		0.000	0.328

⊕ MM	DIM LOC-TP-CC20= TRUE POSITION OF CIRCLE CRC-CAV-9-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.125	-0.125				
Z	0.000	-0.136	-0.136				
TP	RFS		0.370	0.200		0.000	0.170

⊕ MM	DIM LOC-TP-CC21= TRUE POSITION OF CIRCLE CRC-VAC-2						
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	BONUS	OUTTOL
X	0.000	-0.045	-0.045				
Z	0.000	-0.067	-0.067				
TP	RFS		0.162	0.200		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	0.200		0.000	0.000

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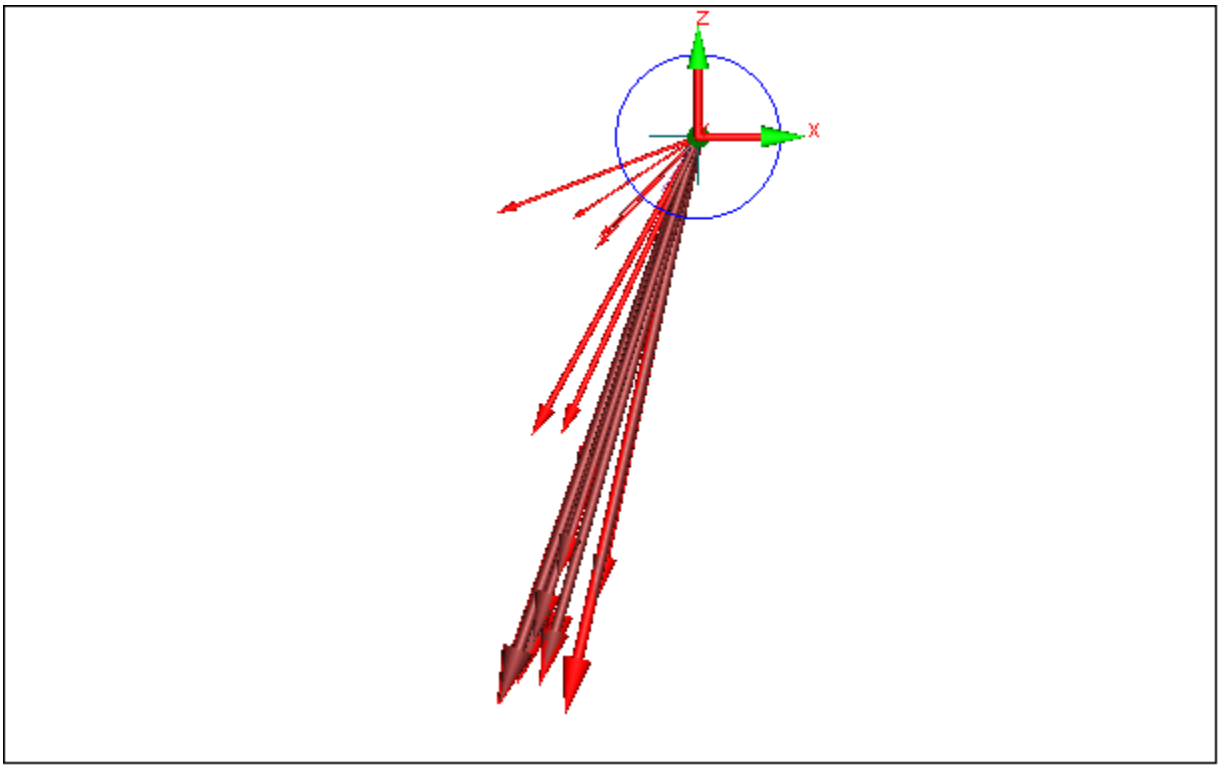
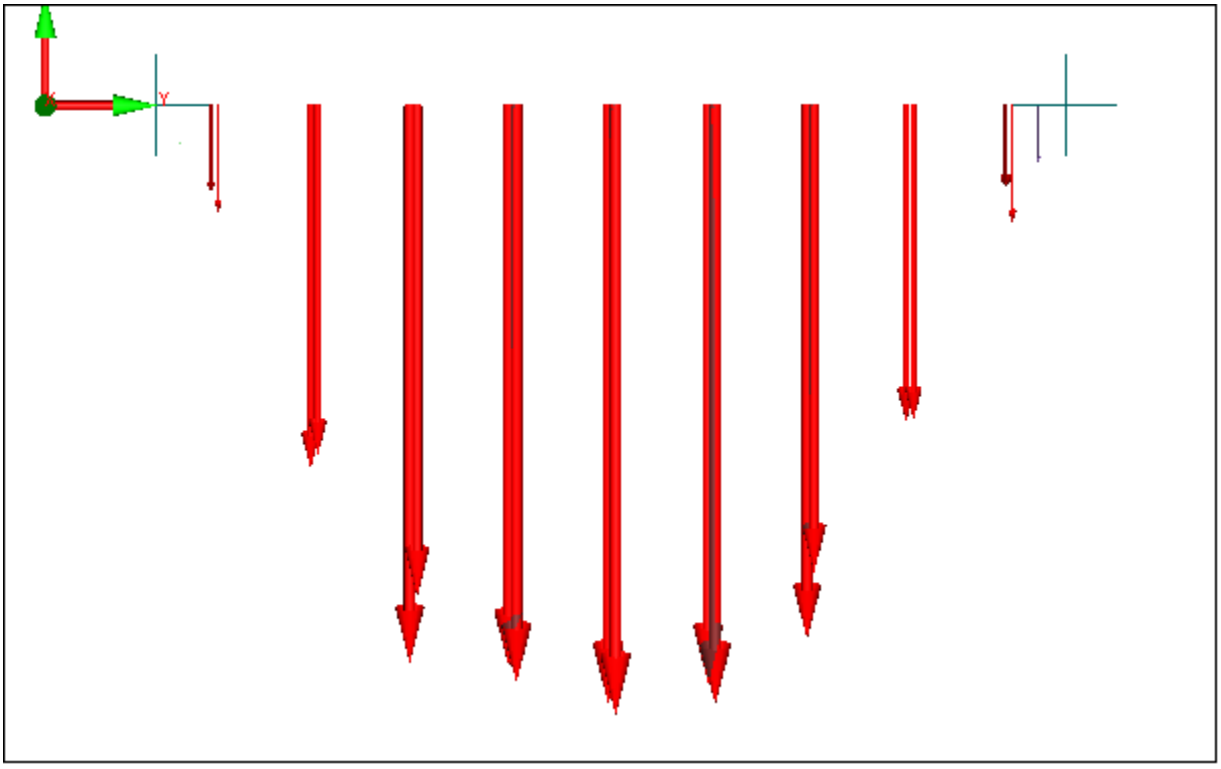
True Position plots from 3 views
x1000



-Y View
x1000



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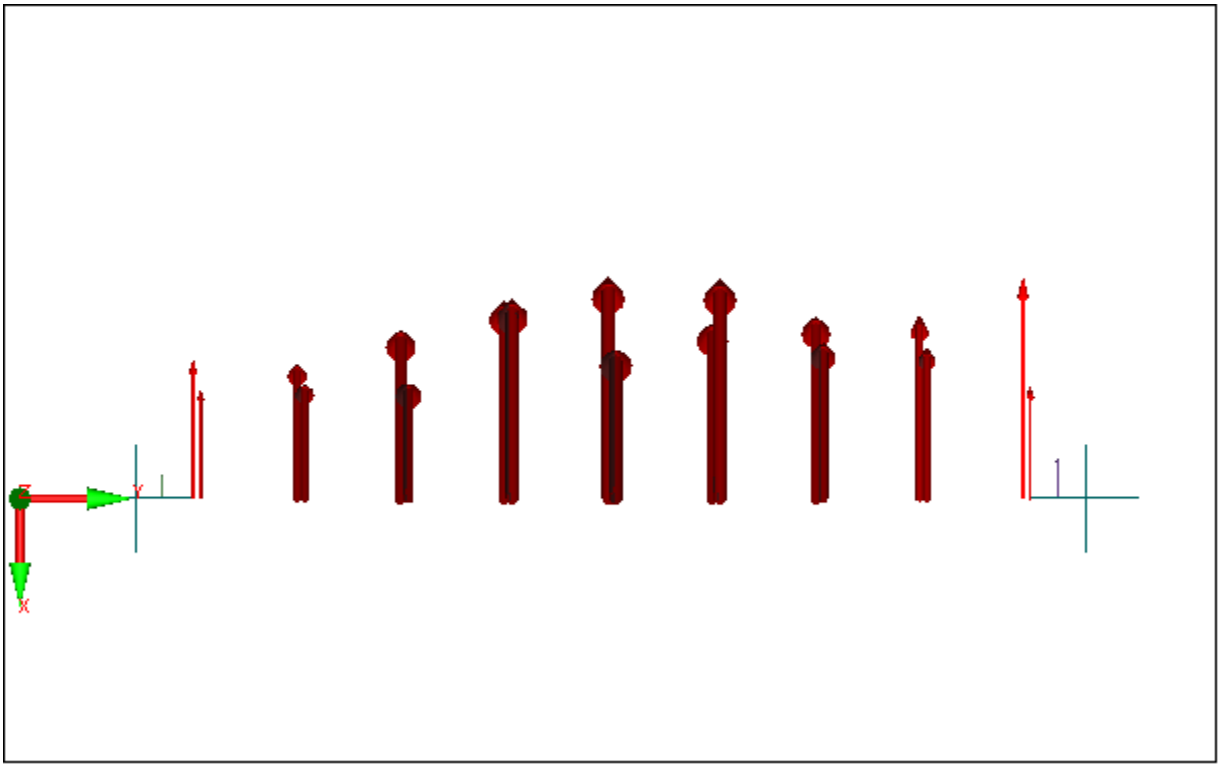
+X View

x1000



+Z View

x1000

MM	DIM LOC-BEST FIT CONSTRUCTED LINE= LOCATION OF LINE LNC-BEST-FIT					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	-0.152	-0.152	0.200	0.200	0.000
Y	0.000	656.352	656.352	2000.000	2000.000	0.000
Z	0.000	-0.390	-0.390	0.200	0.200	0.190
ST	0.000	0.737	0.737	0.200	0.000	0.537

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	0.108	0.108	0.200	0.200	0.000
Y	0.000	254.555	254.555	2000.000	2000.000	0.000
Z	0.000	-0.222	-0.222	0.200	0.200	0.022
R	56.500	56.791	0.291	0.200	0.200	0.091
RN	0.000	0.082	0.082	0.200	0.000	0.000

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MM DIM LOC-SUPPORT RING-2= LOCATION OF CIRCLE CR-SUPPORT-RING-T23

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.760	0.760	0.200	0.200	0.560
Y	0.000	369.882	369.882	2000.000	2000.000	0.000
Z	0.000	-0.212	-0.212	0.200	0.200	0.012
R	56.500	57.456	0.956	0.200	0.200	0.756
RN	0.000	0.046	0.046	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	-0.224	-0.224	0.200	0.200	0.024
Y	0.000	485.214	485.214	2000.000	2000.000	0.000
Z	0.000	-0.603	-0.603	0.200	0.200	0.403
R	56.500	56.465	-0.035	0.200	0.200	0.000
RN	0.000	0.011	0.011	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	-0.183	-0.183	0.200	0.200	0.000
Y	0.000	600.543	600.543	2000.000	2000.000	0.000
Z	0.000	-0.574	-0.574	0.200	0.200	0.374
R	56.500	56.702	0.202	0.200	0.200	0.002
RN	0.000	0.050	0.050	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	-0.801	-0.801	0.200	0.200	0.601
Y	0.000	715.649	715.649	2000.000	2000.000	0.000
Z	0.000	-0.680	-0.680	0.200	0.200	0.480
R	56.500	56.522	0.022	0.200	0.200	0.000
RN	0.000	0.015	0.015	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	0.754	0.754	0.200	0.200	0.554
Y	0.000	830.849	830.849	2000.000	2000.000	0.000
Z	0.000	-0.482	-0.482	0.200	0.200	0.282
R	56.500	57.520	1.020	0.200	0.200	0.820
RN	0.000	0.121	0.121	0.200	0.000	0.000

MM DIM LOC-SUPPORT RING-7= LOCATION OF CIRCLE CR-SUPPORT-RING-T78

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.636	0.636	0.200	0.200	0.436
Y	0.000	946.250	946.250	2000.000	2000.000	0.000
Z	0.000	-0.634	-0.634	0.200	0.200	0.434
R	56.500	57.398	0.898	0.200	0.200	0.698
RN	0.000	0.078	0.078	0.200	0.000	0.000

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MM	DIM LOC-SUPPORT RING-8= LOCATION OF CIRCLE CR-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	0.000	0.031	0.031	0.200	0.200	0.000
Y	0.000	1061.549	1061.549	2000.000	2000.000	0.000
Z	0.000	-0.365	-0.365	0.200	0.200	0.165
R	56.500	56.770	0.270	0.200	0.200	0.070
RN	0.000	0.042	0.042	0.200	0.000	0.000

SUPPORT RING POINT LOCATIONS

MM	DIM LOC-SUPPORT RING-PT1= LOCATION OF POINT PT-SUPPORT-RING-T12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.803	-0.303	0.200	0.200	0.103
Y	0.000	247.854	247.854	2000.000	2000.000	0.000
Z	0.000	0.601	0.601	0.200	0.200	0.401

MM	DIM LOC-SUPPORT RING-PT2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.809	-0.309	0.200	0.200	0.109
Y	0.000	362.054	362.054	2000.000	2000.000	0.000
Z	0.000	0.570	0.570	0.200	0.200	0.370

MM	DIM LOC-SUPPORT RING-PT3= LOCATION OF POINT PT-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.779	-0.279	0.200	0.200	0.079
Y	0.000	476.454	476.454	2000.000	2000.000	0.000
Z	0.000	0.540	0.540	0.200	0.200	0.340

MM	DIM LOC-SUPPORT RING-PT4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-57.043	-0.543	0.200	0.200	0.343
Y	0.000	591.754	591.754	2000.000	2000.000	0.000
Z	0.000	0.509	0.509	0.200	0.200	0.309

MM	DIM LOC-SUPPORT RING-PT5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-57.689	-1.189	0.200	0.200	0.989
Y	0.000	706.754	706.754	2000.000	2000.000	0.000
Z	0.000	0.478	0.478	0.200	0.200	0.278

MM	DIM LOC-SUPPORT RING-PT6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-57.006	-0.506	0.200	0.200	0.306
Y	0.000	822.054	822.054	2000.000	2000.000	0.000
Z	0.000	0.447	0.447	0.200	0.200	0.247

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MM	DIM LOC-SUPPORT RING-PT7= LOCATION OF POINT PT-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.895	-0.395	0.200	0.200	0.195
Y	0.000	937.354	937.354	2000.000	2000.000	0.000
Z	0.000	0.416	0.416	0.200	0.200	0.216

MM	DIM LOC-SUPPORT RING-PT8= LOCATION OF POINT PT-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.777	-0.277	0.200	0.200	0.077
Y	0.000	1052.754	1052.754	2000.000	2000.000	0.000
Z	0.000	0.385	0.385	0.200	0.200	0.185

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	-0.222	-0.222	0.200	0.200	0.022

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	-0.212	-0.212	0.200	0.200	0.012

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	-0.603	-0.603	0.200	0.200	0.403

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	-0.574	-0.574	0.200	0.200	0.374

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	-0.680	-0.680	0.200	0.200	0.480

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	-0.482	-0.482	0.200	0.200	0.282

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	-0.634	-0.634	0.200	0.200	0.434

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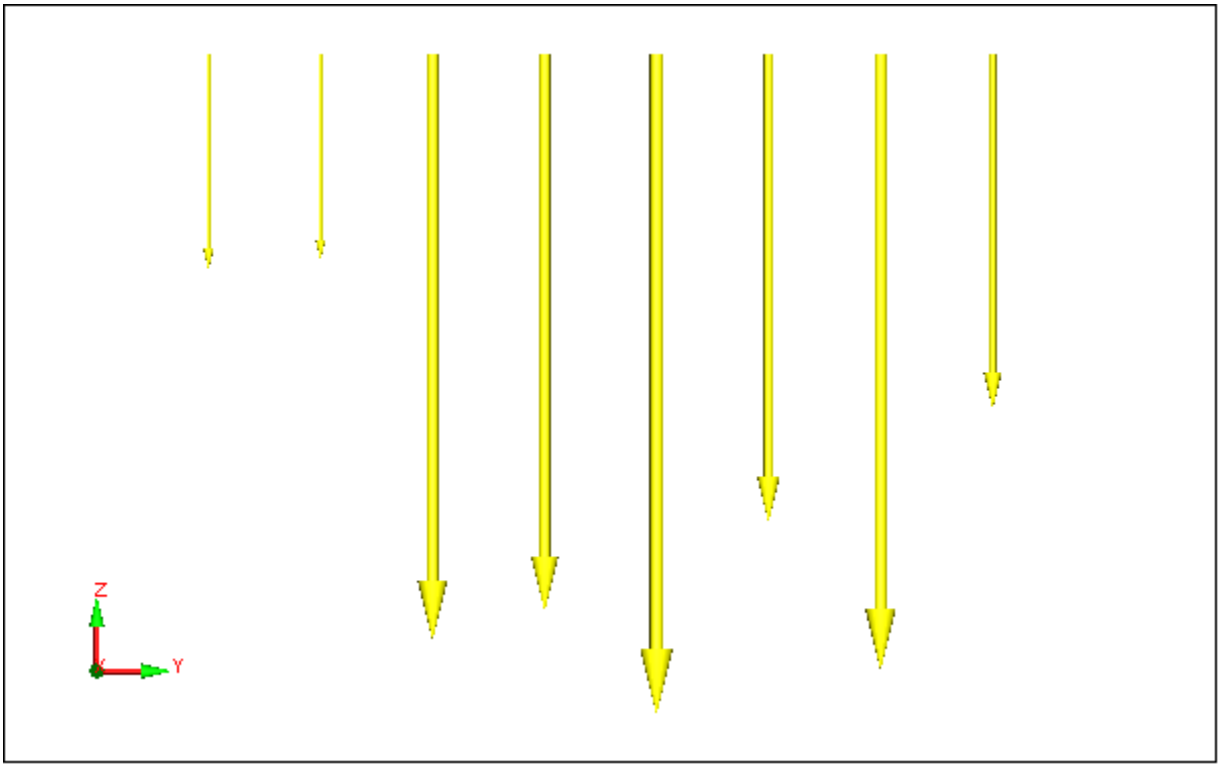
MM	DIM LOC Z SUPPORT RING CIRCLES 8= LOCATION OF CIRCLE CR-SUPPORT-RING-T8					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
Z	0.000	-0.365	-0.365	0.200	0.200	0.165



SUPPORT RING CIRCLES IN Z
x1000

SUPPORT RING POINTS IN X

MM	DIM LOC Z SUPPORT RING POINTS 1= LOCATION OF POINT PT-SUPPORT-RING-T12					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.803	-0.303	0.200	0.200	0.103

MM	DIM LOC Z SUPPORT RING POINTS 2= LOCATION OF POINT PT-SUPPORT-RING-T23					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.809	-0.310	0.200	0.200	0.110

MM	DIM LOC Z SUPPORT RING POINTS 3= LOCATION OF POINT PT-SUPPORT-RING-T34					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.779	-0.279	0.200	0.200	0.079

MM	DIM LOC Z SUPPORT RING POINTS 4= LOCATION OF POINT PT-SUPPORT-RING-T45					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-57.043	-0.543	0.200	0.200	0.343

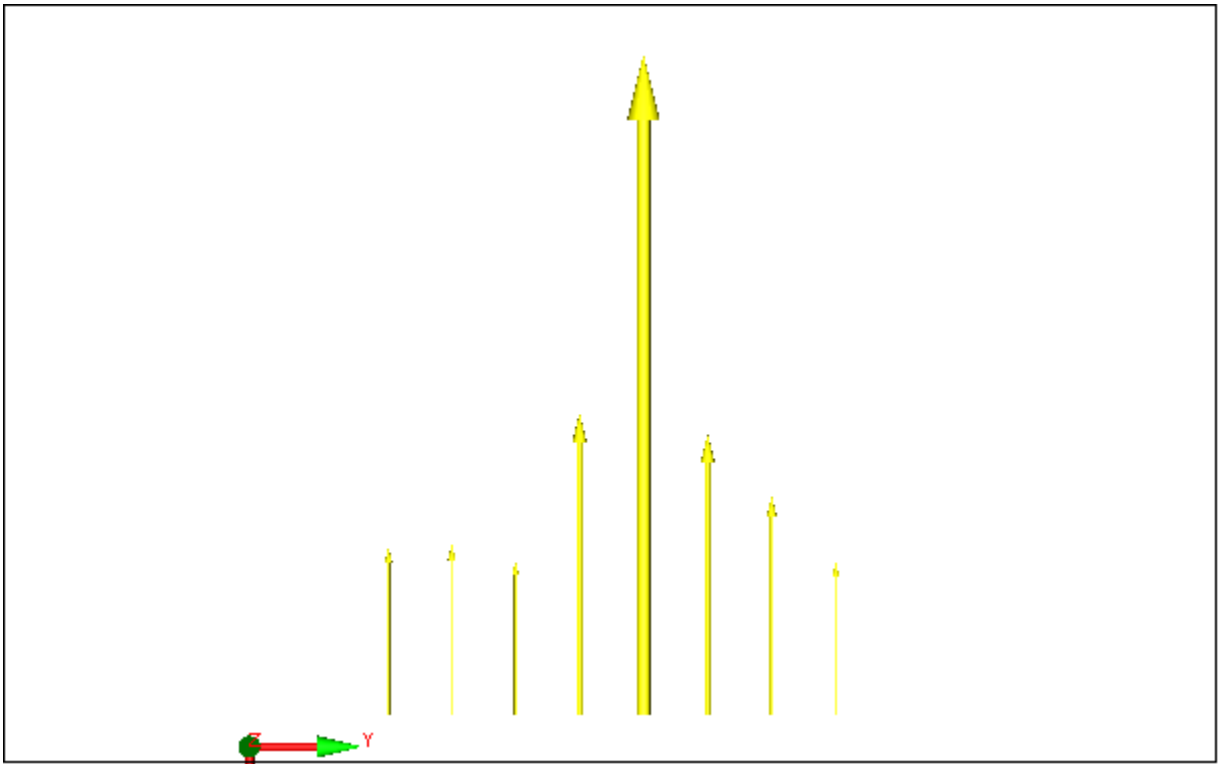
PART NUMBER=ILC AES 1.3GHZ RF CAVITY ASSEMBLY DATE=3/26/2007 TIME=9:42:47 AM

MM	DIM LOC Z SUPPORT RING POINTS 5= LOCATION OF POINT PT-SUPPORT-RING-T56					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-57.689	-1.189	0.200	0.200	0.989

MM	DIM LOC Z SUPPORT RING POINTS 6= LOCATION OF POINT PT-SUPPORT-RING-T67					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-57.006	-0.506	0.200	0.200	0.306

MM	DIM LOC Z SUPPORT RING POINTS 7= LOCATION OF POINT PT-SUPPORT-RING-T78					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.895	-0.395	0.200	0.200	0.195

MM	DIM LOC Z SUPPORT RING POINTS 8= LOCATION OF POINT PT-SUPPORT-RING-T89					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-56.500	-56.777	-0.277	0.200	0.200	0.077



SUPPORT RING POINTS IN X
x1000

DEG	DIM ANGL15= 2D ANGLE (TRUE) FROM LINE LNC-FOR 180 OFFSET TO ZAXIS					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
A	15.000	15.029	0.030	0.500	0.500	0.000

POINTDATA	HIT#	MEAS X	Y	Z	VEC I	J	K	DEVIATION
LNC-FOR 180 OFFSET								
	0	-0.077	-0.017	0.638	0.259	-0.000	0.966	0.643
AX	0	0.000	0.000	0.000	0.000	0.000	1.000	0.000

PART NUMBER=ILC AES 1.3GHZ RF CAVITY ASSEMBLY DATE=3/26/2007 TIME=9:42:47 AM

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(4)  ANGLE I:  0.2593126  -  15.02927818
     ANGLE K:  0.9657934
(9)  ANGLE I:  0.2631146  -  15.25495207
     ANGLE K:  0.9647646
(7)  ANGLE I:  0.2588121  -  14.99958804
     ANGLE K:  0.9659277
(6)  ANGLE I:  0.2439225  -  14.11816578
     ANGLE K:  0.9697947
                          END OF MEASUREMENT FOR
       PN=ILC AES 1.3GHZ RF CAVITY ASSEMBLY            DWG=             SN=
     TOTAL # OF MEAS =291     # OUT OF TOL =159     # OF HOURS =00:00:08
```