pc-dmis	PART NAME : 481343_A		May 14, 2012	14:46
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

SRF - 650MHZ
CAVITY, BETA = 0.9
SINGLE CELL ASSEMBLY
SERIAL NUMBER: B9AS-AES-001
RF#94363
INSPECTOR: O. LIRA

⌗	MM	LOC1 - DATUM_C				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.000	0.500	0.500	0.000	0.000
FL	0.000	0.008	0.400	0.000	0.008	0.000

⌗	MM	LOC2 - LEFT_FLANGE_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	567.500	565.174	0.500	0.500	-2.326	-1.826
FL	0.000	0.030	0.400	0.000	0.030	0.000

⌗	MM	LOC3 - RIGHT_FLANGE_SEAL_SURF				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	1.000	0.993	0.500	0.500	-0.007	0.000
FL	0.000	0.005	0.250	0.000	0.005	0.000

FCFPERP1	MM	⊥ 0.4 B				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
DATUM_C	0.000	0.029	0.400	0.000	0.029	0.000

FCFPERP2	MM	⊥ 0.4 A				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_...	0.000	0.050	0.400	0.000	0.050	0.000

FCFPARL1	MM	// 0.5 C				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_...	0.000	0.309	0.500	0.000	0.309	0.000

⌗	MM	LOC4 - DATUM_C				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		0.000		-1.000		0.000

⌗	MM	LOC5 - LEFT_FLANGE_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		0.000		1.000		0.001

⌗	MM	LOC6 - RIGHT_FLANGE_SEAL_SURF				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		0.000		-1.000		0.001

⌗	MM	LOC7 - LEFT_FLANGE_SEAL_SURF				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		0.000		1.000		0.001

	MM	LOC8 - RIGHT_FLANGE_BEAM_TUBE_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		0.000		-1.000		0.001

	MM	LOC9 - LEFT_FLANGE_BEAM_TUBE_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		0.000		1.000		0.001

	MM	DIST1 - LEFT_FLANGE_PLN TO LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	1.000	0.985	0.200	0.200	-0.015	0.000

	MM	FLAT1 - LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.000	0.009	0.250	0.000	0.009	0.000

	MM	LOC10 - DATUM_B

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.282	0.200	0.200	0.282	0.082
RN	0.000	0.289	0.050	0.000	0.289	0.239

	MM	LOC11 - DATUM_A_CYL1

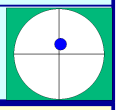
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.296	0.200	0.200	0.296	0.096
RN	0.000	0.231	0.050	0.000	0.231	0.181

	MM	LOC12 - DAT_B_DAT_A_CYL1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.289	0.050	0.050	0.289	0.239
RN	0.000	0.426	0.050	0.000	0.426	0.376

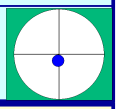
	MM	LOC13 - DATUM_B_END1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
X	0.000	0.008			0.008		
Y	0.000	0.000			0.000		
Z	0.000	0.053			0.053		
TP	RFS	0.108	0.500		0.108	0.000	0.000



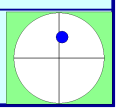
	MM	LOC14 - DATUM_B_END2

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.005			-0.005	
Y	170.000	170.000			0.000	
Z	0.000	-0.035			-0.035	
TP	RFS	0.072	0.500		0.072	0.000



	MM	LOC17 - DATUM_A_END1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.017			0.017	
Y	567.500	567.500			0.000	
Z	0.000	0.117			0.117	
TP	RFS	0.236	0.500		0.236	0.000

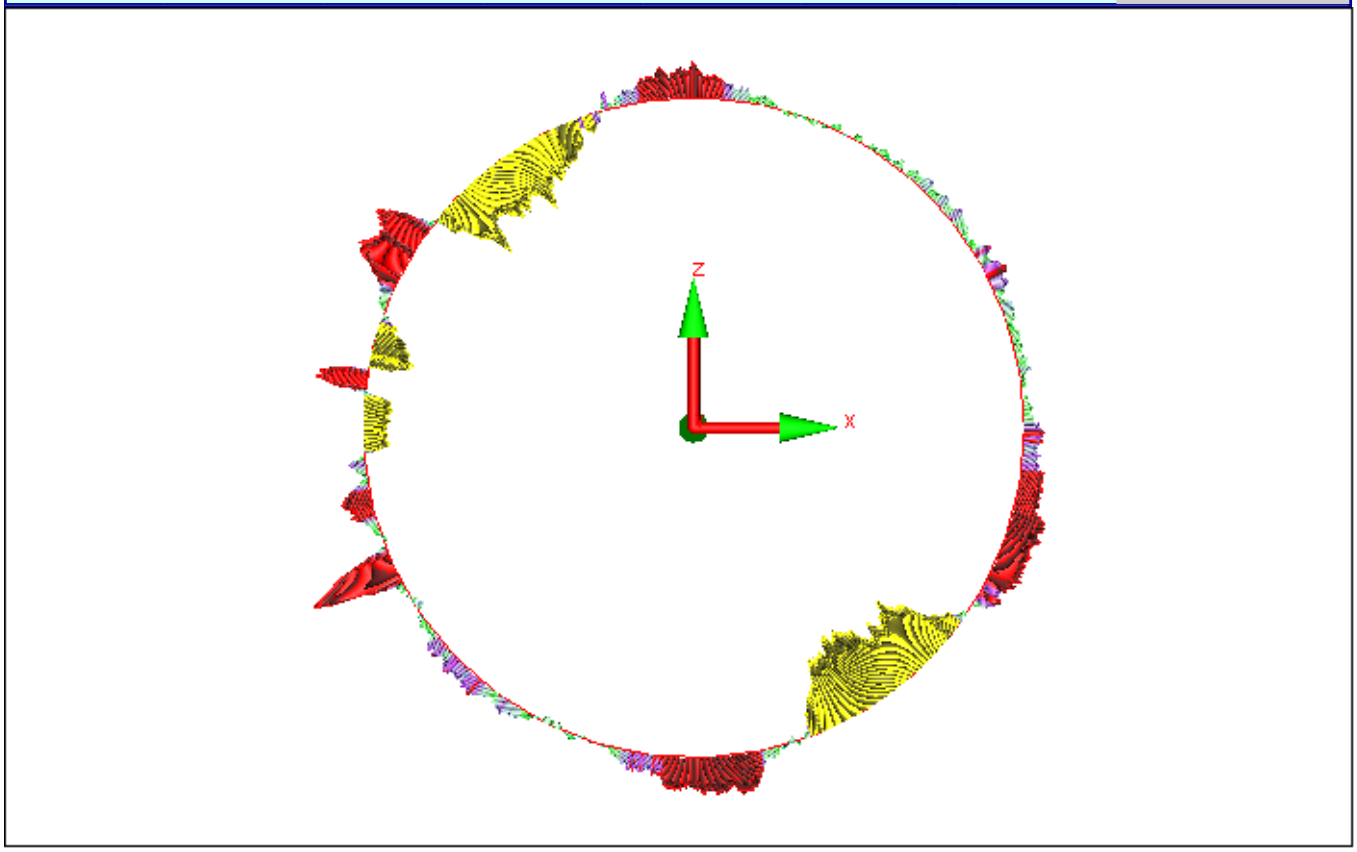


	MM	LOC18 - DATUM_A_END2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.020			-0.020	
Y	397.500	397.500			0.000	
Z	0.000	-0.139			-0.139	
TP	RFS	0.280	0.500		0.280	0.000

	MM	LOC19 - FLANGE_RIGHT_OD				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.001	0.050	0.050	0.001	0.000
Z	0.000	0.043	0.050	0.050	0.043	0.000
D	170.000	169.942	0.200	0.200	-0.058	0.000
RN	0.000	0.059	0.100	0.000	0.059	0.000

	MM	LOC20 - FLANGE_LEFT_OD				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.001	0.050	0.050	0.001	0.000
Z	0.000	0.112	0.050	0.050	0.112	0.062
D	170.000	169.954	0.200	0.200	-0.046	0.000
RN	0.000	0.023	0.100	0.000	0.023	0.000

⌗	MM	LOC21 - MID_WELD_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.052	0.500	0.500	0.052	0.000
Y	283.750	282.588	0.500	0.500	-1.162	-0.662
Z	0.000	0.057	0.500	0.500	0.057	0.000
D	404.550	405.092	0.050	0.000	0.542	0.492
RN	0.000	1.103	0.200	0.000	1.103	0.903



PROFILE OF TWO HALF CELLS CENTER WELD CIRCLE

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****************** NOTE ***************

  FOR THE FOLLOWING BOLT CIRCLE POSITIONS
TWO SECONDARY DATUM'S WERE CREATED AS FOLLOW:

1) RIGHT FLANGE SEALING SURFACE DATUM= RF

2) LEFT FLANGE SEALING SURFACE DATUM= LF

3) RIGHT FLANGE OUTSIDE DIAMETER DATUM= RO

4) LEFT FLANGE OUTSIDE DIAMETER DATUM= LO

  (SEE DRAWING 481600 FLANGE, HEX-SEAL)

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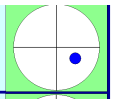
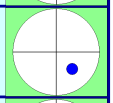
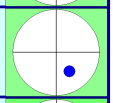
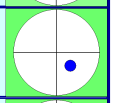
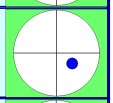
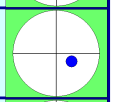
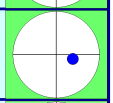
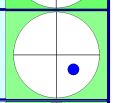
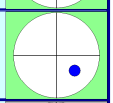
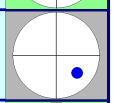
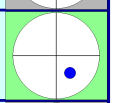
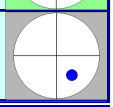
FCFLOC1 Size	MM	18XØ8.5 0.13/0.13					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_RIG...	8.500	8.508	0.130	0.130	0.008	0.000	0.138
FLANGE_RIG...	8.500	8.494	0.130	0.130	-0.006	0.000	0.124
FLANGE_RIG...	8.500	8.514	0.130	0.130	0.014	0.000	0.144
FLANGE_RIG...	8.500	8.535	0.130	0.130	0.035	0.000	0.165
FLANGE_RIG...	8.500	8.506	0.130	0.130	0.006	0.000	0.136
FLANGE_RIG...	8.500	8.509	0.130	0.130	0.009	0.000	0.139
FLANGE_RIG...	8.500	8.503	0.130	0.130	0.003	0.000	0.133
FLANGE_RIG...	8.500	8.509	0.130	0.130	0.009	0.000	0.139
FLANGE_RIG...	8.500	8.510	0.130	0.130	0.010	0.000	0.140
FLANGE_RIG...	8.500	8.492	0.130	0.130	-0.008	0.000	0.122
FLANGE_RIG...	8.500	8.510	0.130	0.130	0.010	0.000	0.140
FLANGE_RIG...	8.500	8.518	0.130	0.130	0.018	0.000	0.148
FLANGE_RIG...	8.500	8.516	0.130	0.130	0.016	0.000	0.146
FLANGE_RIG...	8.500	8.510	0.130	0.130	0.010	0.000	0.140
FLANGE_RIG...	8.500	8.502	0.130	0.130	0.002	0.000	0.132
FLANGE_RIG...	8.500	8.509	0.130	0.130	0.009	0.000	0.139
FLANGE_RIG...	8.500	8.494	0.130	0.130	-0.006	0.000	0.124
FLANGE_RIG...	8.500	8.509	0.130	0.130	0.009	0.000	0.139

FCFLOC1 Position	MM	⌖ Ø0.2 Ⓜ RF RO					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_RIGH...	0.000	0.221	0.200		0.221	0.000	0.138
FLANGE_RIGH...	0.000	0.186	0.200		0.186	0.000	0.124
FLANGE_RIGH...	0.000	0.169	0.200		0.169	0.000	0.144
FLANGE_RIGH...	0.000	0.156	0.200		0.156	0.000	0.165
FLANGE_RIGH...	0.000	0.214	0.200		0.214	0.000	0.136
FLANGE_RIGH...	0.000	0.223	0.200		0.223	0.000	0.139

FLANGE_RIGHT_CIR7	0.170	0.133	
FLANGE_RIGHT_CIR8	0.182	0.139	
FLANGE_RIGHT_CIR9	0.181	0.140	
FLANGE_RIGHT_CIR10	0.143	0.122	
FLANGE_RIGHT_CIR11	0.149	0.140	
FLANGE_RIGHT_CIR12	0.141	0.148	
FLANGE_RIGHT_CIR13	0.137	0.146	
FLANGE_RIGHT_CIR14	0.175	0.140	
FLANGE_RIGHT_CIR15	0.182	0.132	
FLANGE_RIGHT_CIR16	0.213	0.139	
FLANGE_RIGHT_CIR17	0.165	0.124	
FLANGE_RIGHT_CIR18	0.196	0.139	

FCFLOC1 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	-0.001	0.000	0.001	0.000	0.050	0.000

FCFLOC1 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON

Feature	AX	NOMINAL	MEAS	DEV
Set	PR	0.000	0.086	0.086
	PA	208.425	315.894	107.469
FLANGE_RIGHT_TOP_CIR1	PR	75.800	75.711	-0.089
	PA	90.000	89.950	-0.050
FLANGE_RIGHT_CIR2	PR	75.800	75.713	-0.087
	PA	110.000	109.975	-0.025
FLANGE_RIGHT_CIR3	PR	75.800	75.717	-0.083
	PA	130.000	129.986	-0.014
FLANGE_RIGHT_CIR4	PR	75.800	75.727	-0.073
	PA	150.000	150.019	0.019
FLANGE_RIGHT_CIR5	PR	75.800	75.725	-0.075
	PA	170.000	170.057	0.057
FLANGE_RIGHT_CIR6	PR	75.800	75.728	-0.072
	PA	190.000	190.064	0.064
FLANGE_RIGHT_CIR7	PR	75.800	75.759	-0.041
	PA	210.000	210.056	0.056
FLANGE_RIGHT_CIR8	PR	75.800	75.811	0.011
	PA	230.000	230.068	0.068

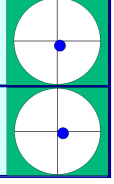
FLANGE_RIGHT_CIR9	PR	75.800	75.852	0.052
	PA	250.000	250.056	0.056
FLANGE_RIGHT_CIR10	PR	75.800	75.849	0.049
	PA	270.000	270.039	0.039
FLANGE_RIGHT_CIR11	PR	75.800	75.860	0.060
	PA	290.000	290.033	0.033
FLANGE_RIGHT_CIR12	PR	75.800	75.865	0.065
	PA	310.000	310.020	0.020
FLANGE_RIGHT_CIR13	PR	75.800	75.866	0.066
	PA	330.000	330.013	0.013
FLANGE_RIGHT_CIR14	PR	75.800	75.875	0.075
	PA	350.000	349.966	-0.034
FLANGE_RIGHT_CIR15	PR	75.800	75.859	0.059
	PA	10.000	9.948	-0.052
FLANGE_RIGHT_CIR16	PR	75.800	75.837	0.037
	PA	30.000	29.924	-0.076
FLANGE_RIGHT_CIR17	PR	75.800	75.784	-0.016
	PA	50.000	49.939	-0.061
FLANGE_RIGHT_CIR18	PR	75.800	75.749	-0.051
	PA	70.000	69.937	-0.063

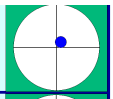
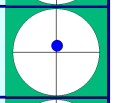
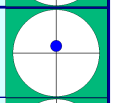
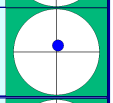
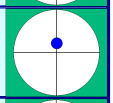
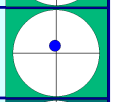
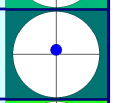
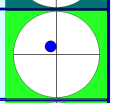
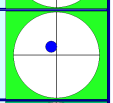
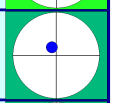
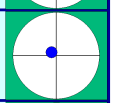
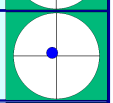
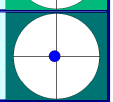
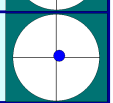
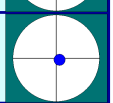
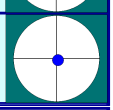
FCFLOC2 Size	MM	18XØ8.5 0.13/0.13

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_LEF...	8.500	8.477	0.130	0.130	-0.023	0.000	0.107
FLANGE_LEF...	8.500	8.492	0.130	0.130	-0.008	0.000	0.122
FLANGE_LEF...	8.500	8.494	0.130	0.130	-0.006	0.000	0.124
FLANGE_LEF...	8.500	8.489	0.130	0.130	-0.011	0.000	0.119
FLANGE_LEF...	8.500	8.508	0.130	0.130	0.008	0.000	0.138
FLANGE_LEF...	8.500	8.513	0.130	0.130	0.013	0.000	0.143
FLANGE_LEF...	8.500	8.507	0.130	0.130	0.007	0.000	0.137
FLANGE_LEF...	8.500	8.497	0.130	0.130	-0.003	0.000	0.127
FLANGE_LEF...	8.500	8.486	0.130	0.130	-0.014	0.000	0.116
FLANGE_LEF...	8.500	8.499	0.130	0.130	-0.001	0.000	0.129
FLANGE_LEF...	8.500	8.494	0.130	0.130	-0.006	0.000	0.124
FLANGE_LEF...	8.500	8.487	0.130	0.130	-0.013	0.000	0.117
FLANGE_LEF...	8.500	8.503	0.130	0.130	0.003	0.000	0.133
FLANGE_LEF...	8.500	8.502	0.130	0.130	0.002	0.000	0.132
FLANGE_LEF...	8.500	8.487	0.130	0.130	-0.013	0.000	0.117
FLANGE_LEF...	8.500	8.487	0.130	0.130	-0.013	0.000	0.117
FLANGE_LEF...	8.500	8.486	0.130	0.130	-0.014	0.000	0.116
FLANGE_LEF...	8.500	8.481	0.130	0.130	-0.019	0.000	0.111

FCFLOC2 Position	MM	⌖ Ø0.2 Ⓜ LF LO

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_LEFT...	0.000	0.039	0.200		0.039	0.000	0.107
FLANGE_LEFT...	0.000	0.043	0.200		0.043	0.000	0.122



FLANGE_LEFT_CIR3	0.051	0.124	
FLANGE_LEFT_CIR4	0.048	0.119	
FLANGE_LEFT_CIR5	0.056	0.138	
FLANGE_LEFT_CIR6	0.055	0.143	
FLANGE_LEFT_CIR7	0.072	0.137	
FLANGE_LEFT_CIR8	0.056	0.127	
FLANGE_LEFT_CIR9	0.031	0.116	
FLANGE_LEFT_CIR10	0.074	0.129	
FLANGE_LEFT_CIR11	0.074	0.124	
FLANGE_LEFT_CIR12	0.067	0.117	
FLANGE_LEFT_CIR13	0.046	0.133	
FLANGE_LEFT_CIR14	0.040	0.132	
FLANGE_LEFT_CIR15	0.014	0.117	
FLANGE_LEFT_CIR16	0.028	0.117	
FLANGE_LEFT_CIR17	0.026	0.116	
FLANGE_LEFT_CIR18	0.015	0.111	

FCFLOC2 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	0.001	0.000	0.001	0.000	0.111	0.000

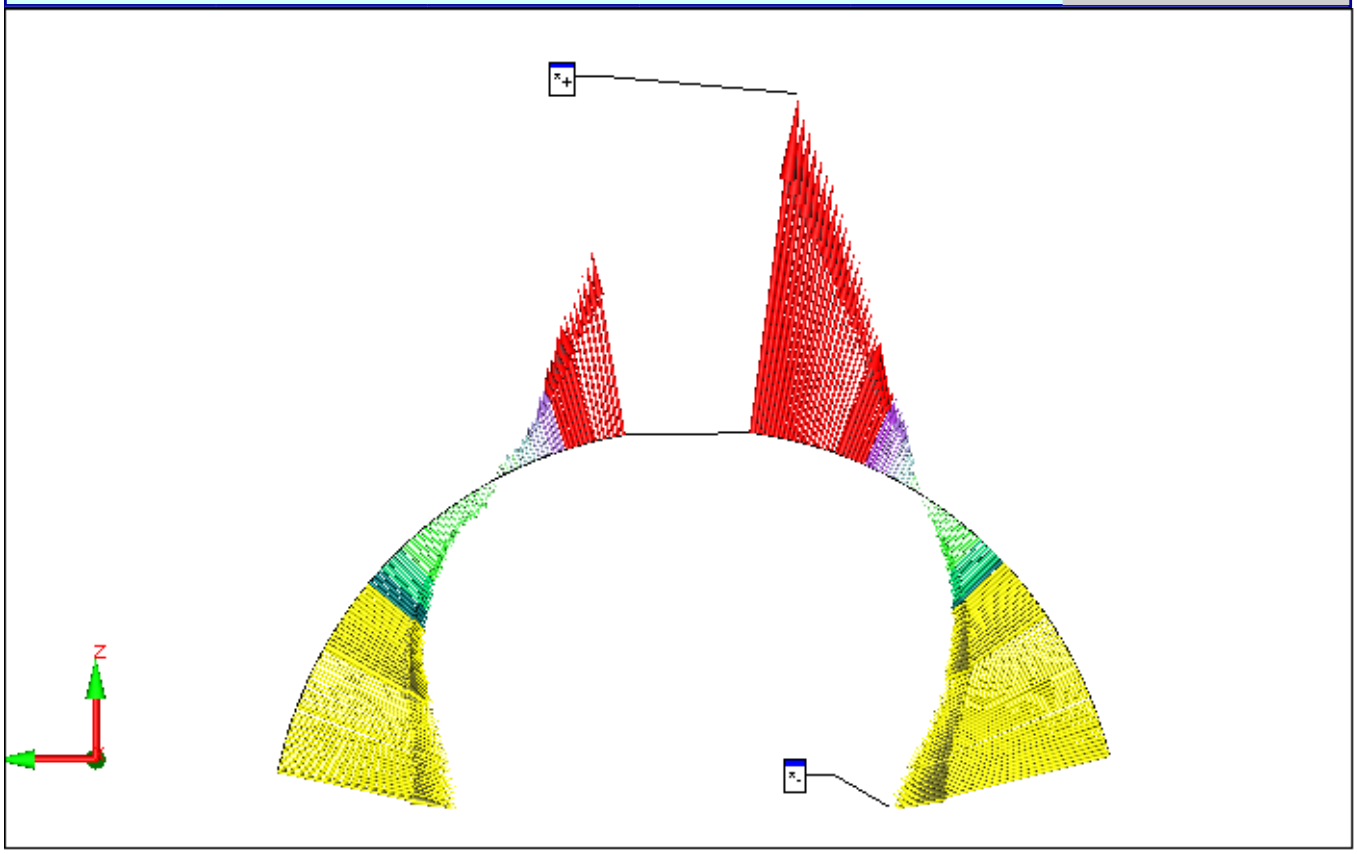
FCFLOC2 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON

Feature	AX	NOMINAL	MEAS	DEV
Set	PR	0.000	0.014	0.014
	PA	359.690	103.920	-255.770
FLANGE_LEFT_CIR1	PR	75.800	75.783	-0.017
	PA	90.000	89.992	-0.008
FLANGE_LEFT_CIR2	PR	75.800	75.787	-0.013
	PA	110.000	109.987	-0.013
FLANGE_LEFT_CIR3	PR	75.800	75.804	0.004
	PA	130.000	129.981	-0.019
FLANGE_LEFT_CIR4	PR	75.800	75.808	0.008
	PA	150.000	149.983	-0.017

FLANGE_LEFT_CIR5	PR	75.800	75.805	0.005
	PA	170.000	169.979	-0.021
FLANGE_LEFT_CIR6	PR	75.800	75.789	-0.011
	PA	190.000	189.981	-0.019
FLANGE_LEFT_CIR7	PR	75.800	75.781	-0.019
	PA	210.000	209.977	-0.023
FLANGE_LEFT_CIR8	PR	75.800	75.782	-0.018
	PA	230.000	229.984	-0.016
FLANGE_LEFT_CIR9	PR	75.800	75.786	-0.014
	PA	250.000	249.996	-0.004
FLANGE_LEFT_CIR10	PR	75.800	75.770	-0.030
	PA	270.000	269.983	-0.017
FLANGE_LEFT_CIR11	PR	75.800	75.764	-0.036
	PA	290.000	289.994	-0.006
FLANGE_LEFT_CIR12	PR	75.800	75.767	-0.033
	PA	310.000	310.006	0.006
FLANGE_LEFT_CIR13	PR	75.800	75.777	-0.023
	PA	330.000	330.002	0.002
FLANGE_LEFT_CIR14	PR	75.800	75.782	-0.018
	PA	350.000	350.007	0.007
FLANGE_LEFT_CIR15	PR	75.800	75.793	-0.007
	PA	10.000	10.002	0.002
FLANGE_LEFT_CIR16	PR	75.800	75.814	0.014
	PA	30.000	30.000	0.000
FLANGE_LEFT_CIR17	PR	75.800	75.803	0.003
	PA	50.000	49.991	-0.009
FLANGE_LEFT_CIR18	PR	75.800	75.797	-0.003
	PA	70.000	69.995	-0.005

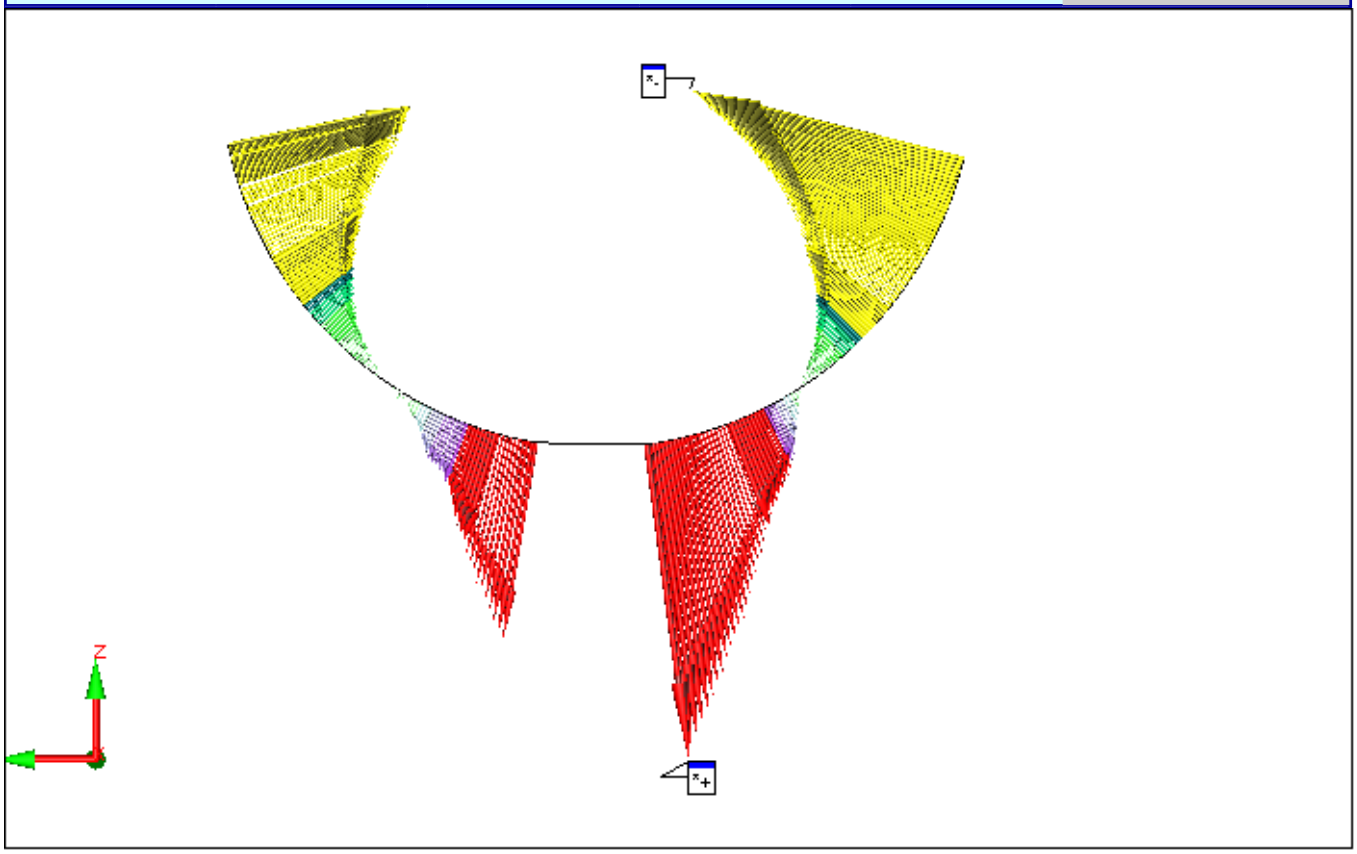
FCFPROF1	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS

Feature	MEAS	MAX	MIN	BONUS
Set	1.146	0.689	-0.457	



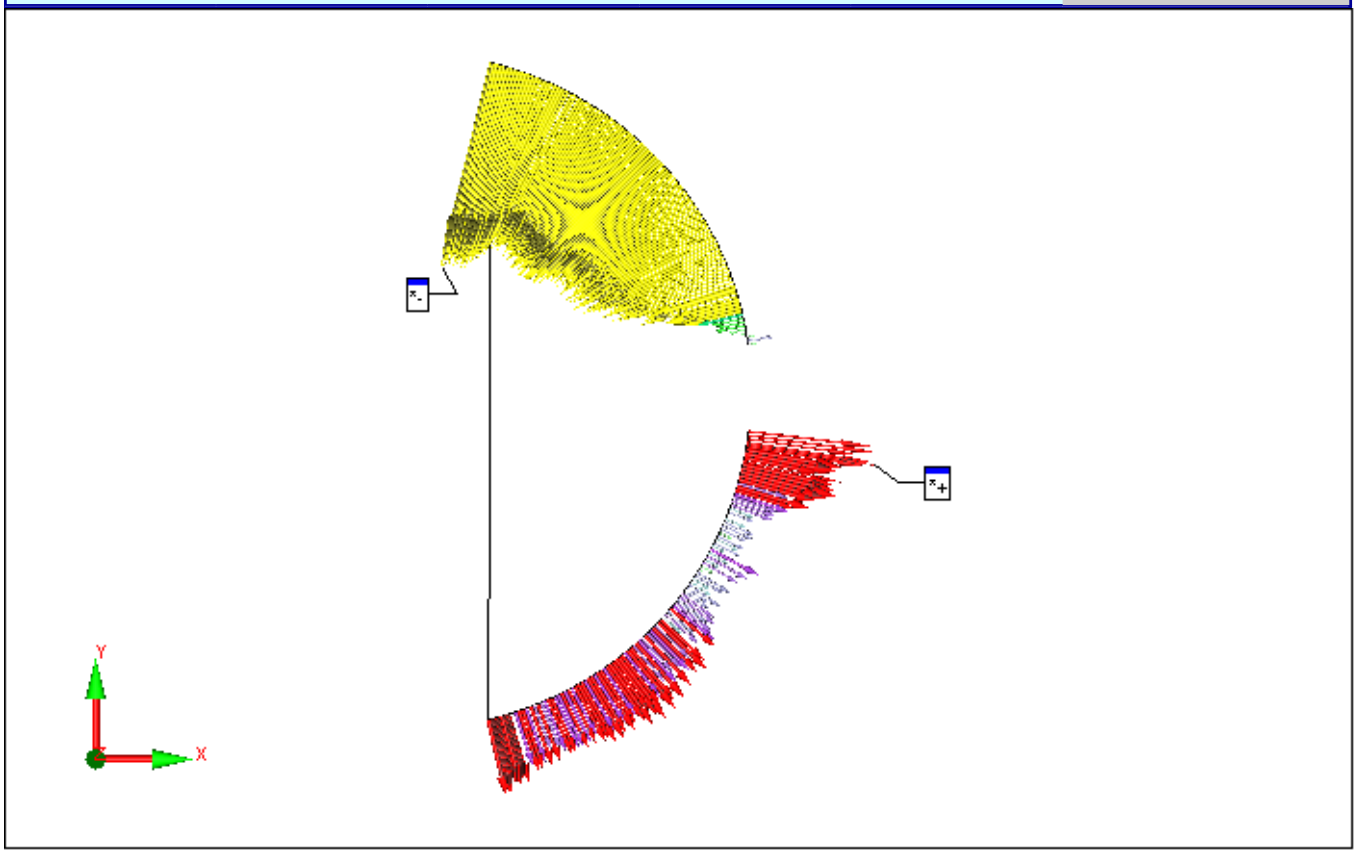
PROFILE OF RIGHT AND LEFT HALF CELLS 12 'O' CLOCK -X100

FCFPROF2	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS	
Feature	MEAS	MAX	MIN	BONUS
Set	1.382	0.735	-0.646	



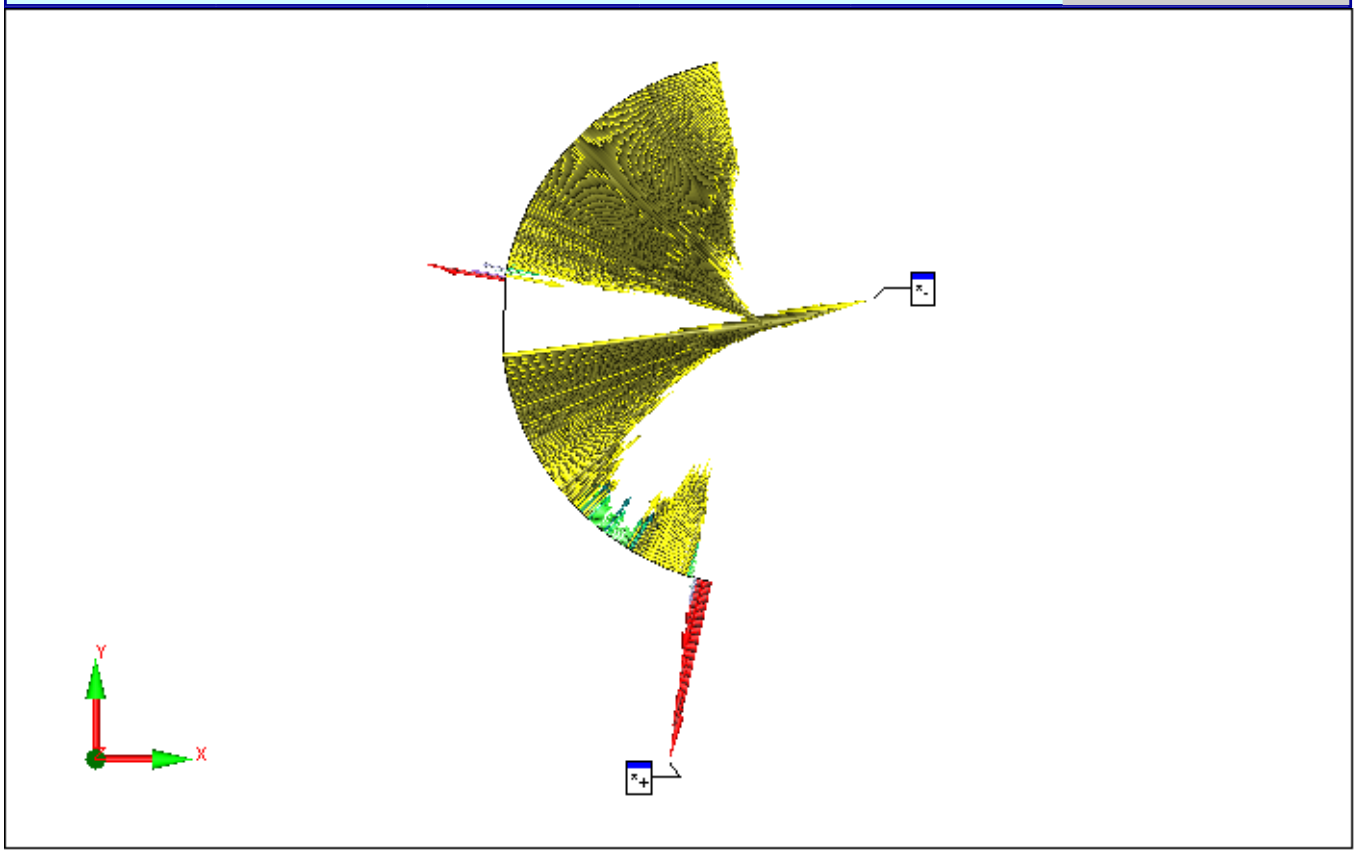
PROFILE OF RIGHT AND LEFT HALF CELLS 6 'O' CLOCK -X100

FCFPROF3	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS	
Feature	MEAS	MAX	MIN	BONUS
Set	0.873	0.331	-0.542	

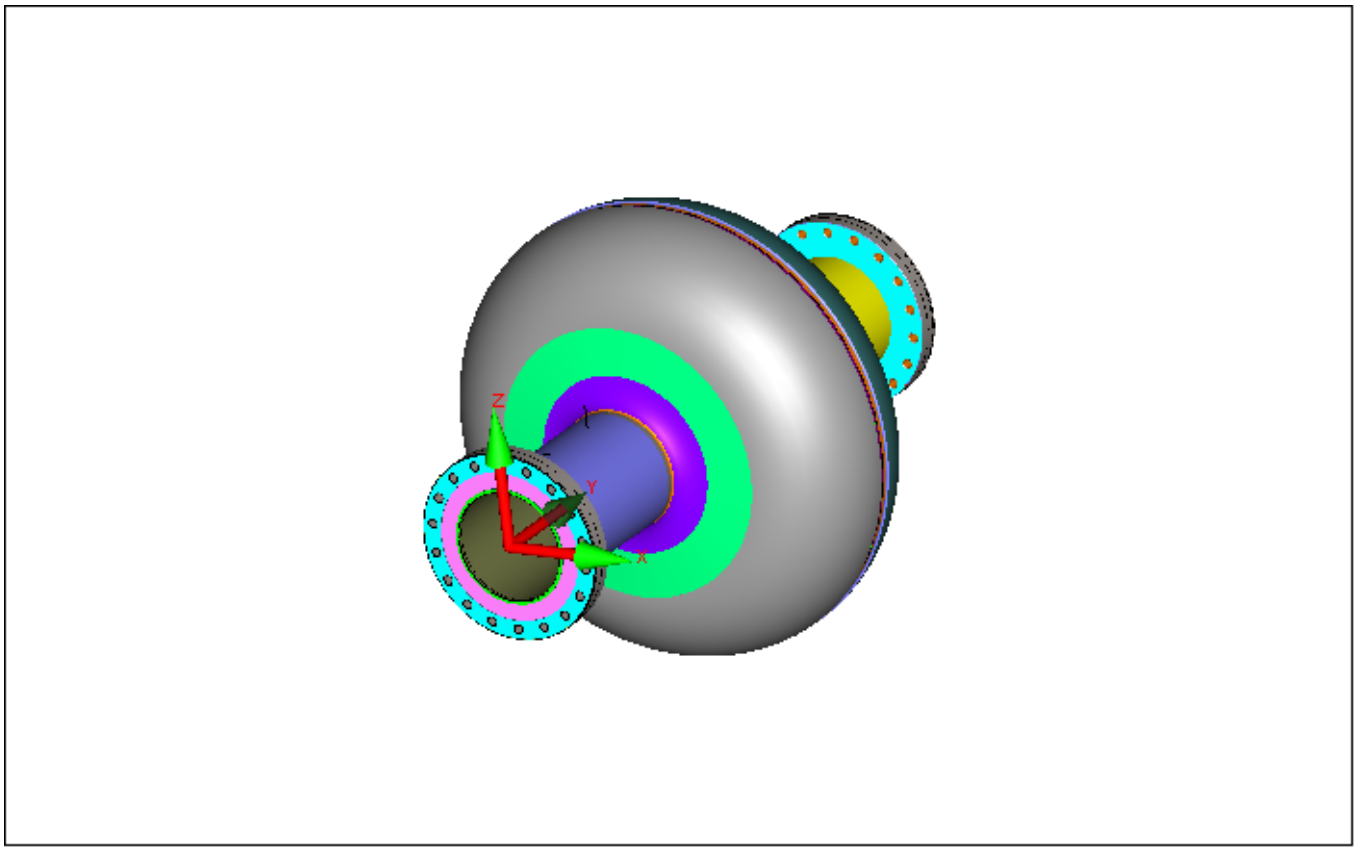


PROFILE OF RIGHT AND LEFT HALF CELLS 3 'O' CLOCK -X100

FCFPROF4	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS	
Feature	MEAS	MAX	MIN	BONUS
Set	1.811	0.599	-1.212	

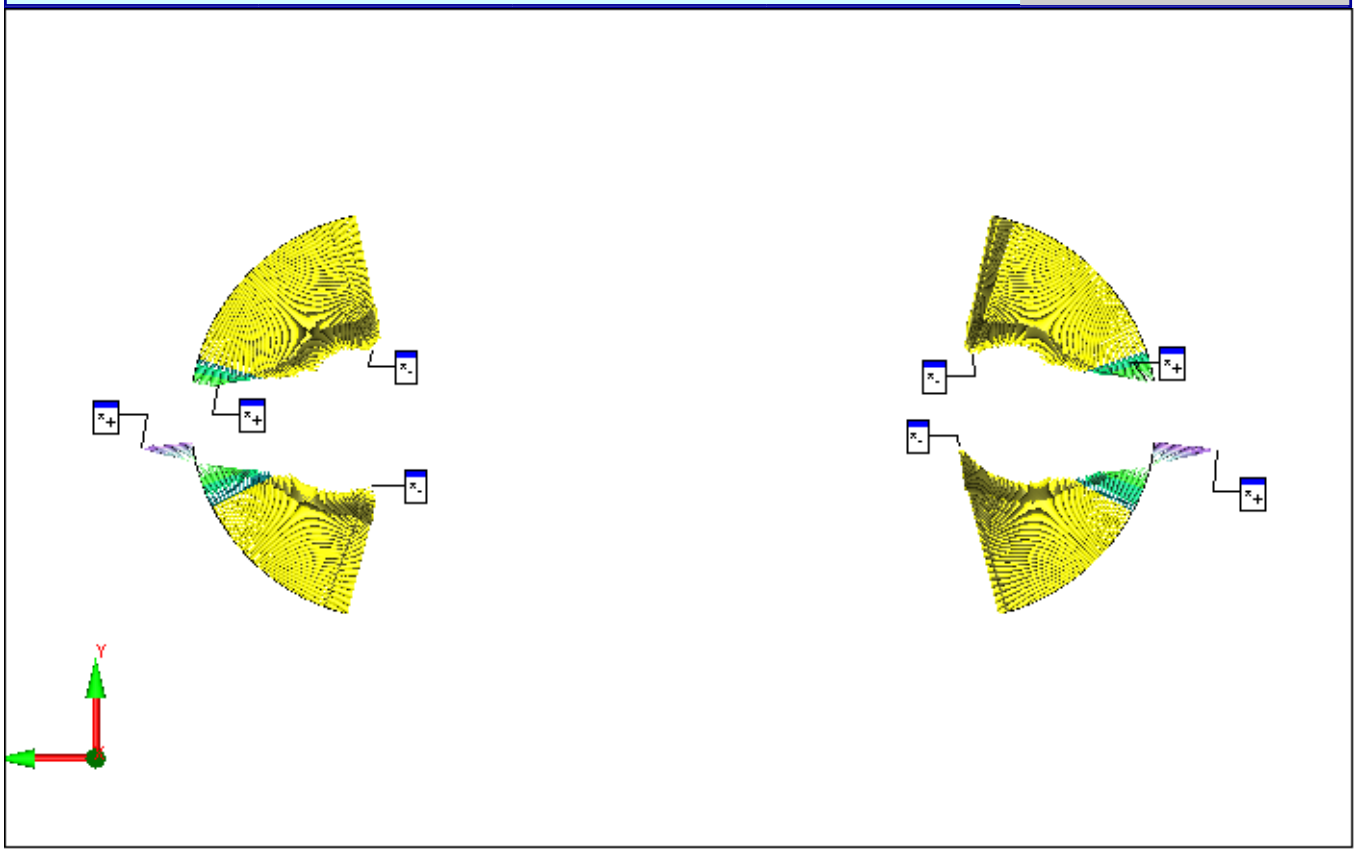


PROFILE OF RIGHT AND LEFT HALF CELLS 9 'O' CLOCK -X100



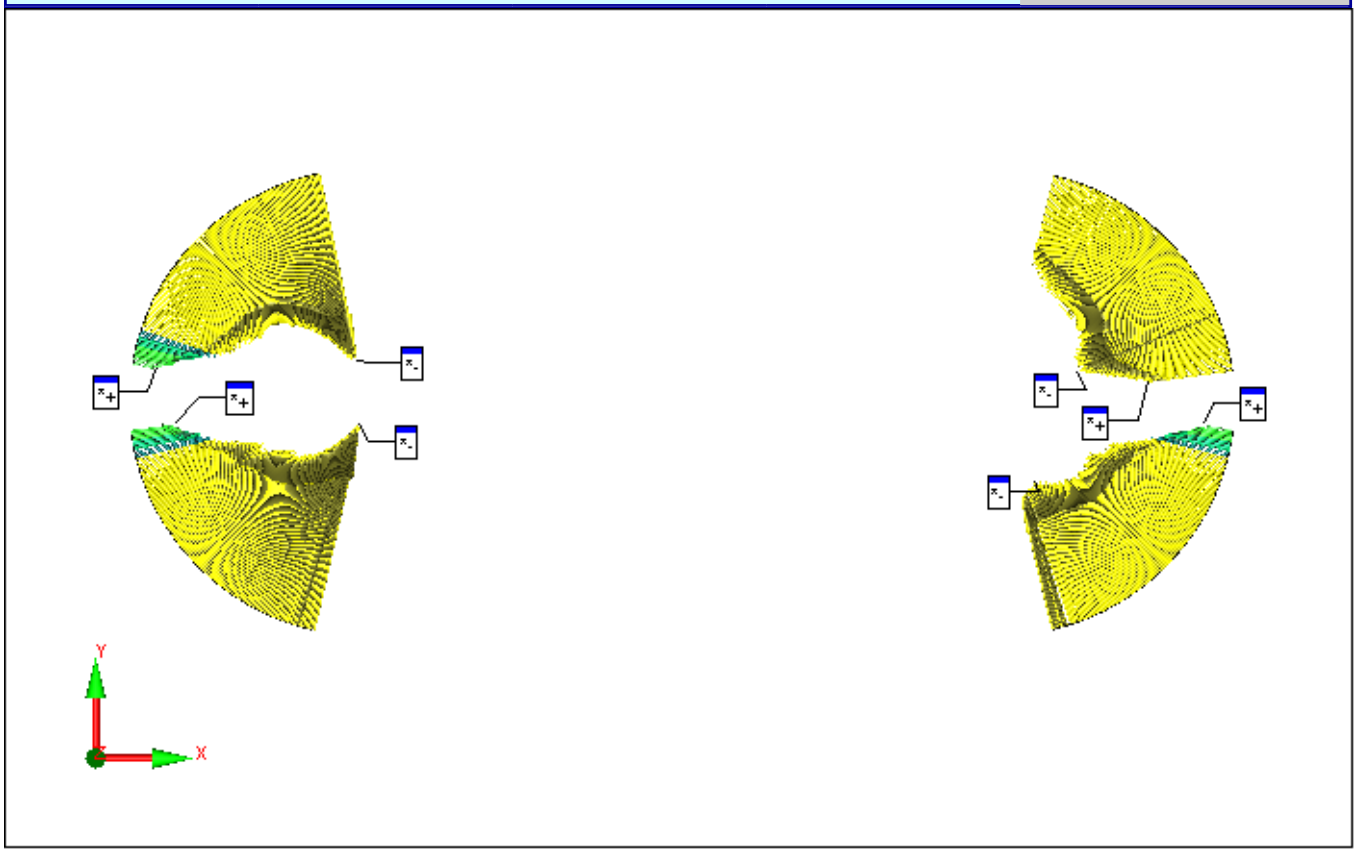
1	MM	FLANGE_RIGHT SURFACE FINISH			
AX	NOMINAL	MEAS	DEV	OUTTOL	
M	0.400	0.410	0.010	0.000	
1	MM	FLANGE_LEFT SURFACE FINISH			
AX	NOMINAL	MEAS	DEV	OUTTOL	
M	0.400	0.650	0.250	0.240	

⌒	MM	PROF10 - ZPLUS_RIGHT_SCN1 FORMANDLOCATION			
AX		MEAS	MAX	MIN	
M		0.754	0.214	-0.540	
⌒	MM	PROF11 - ZPLUS_LEFT_SCN1 FORMANDLOCATION			
AX		MEAS	MAX	MIN	
M		-0.569	-0.106	-0.569	
⌒	MM	PROF14 - ZMINUS_RIGHT_SCN1 FORMANDLOCATION			
AX		MEAS	MAX	MIN	
M		0.981	0.263	-0.718	
⌒	MM	PROF15 - ZMINUS_LEFT_SCN1 FORMANDLOCATION			
AX		MEAS	MAX	MIN	
M		-0.591	-0.025	-0.591	



BESTFIT TO ALL 8 SCANS PROFILE OF RIGHT AND LEFT HALF CELLS 12'O' and 6'0'CLOCK -X100

⌒	MM	PROF12 - XPLUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		-0.561	-0.310	-0.561
⌒	MM	PROF13 - XPLUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		-0.544	-0.108	-0.544
⌒	MM	PROF16 - XMINUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		-0.777	-0.157	-0.777
⌒	MM	PROF17 - XMINUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		-0.710	-0.089	-0.710



BESTFIT TO ALL 8 SCANS PROFILE OF RIGHT AND LEFT HALF CELLS 9'O' and 3'0'CLOCK- X100