pc-dmis	PART NAME : 481343_A		May 17, 2012	15:29
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

SRF - 650MHZ
CAVITY, BETA = 0.9
SINGLE CELL ASSEMBLY
SERIAL NUMBER: B9AS-AES-006
RF#94368
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	0.020	0.400	0.000	0.020	0.000

⌗	MM	LOC2 - LEFT_FLANGE_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	567.500	566.914	0.500	0.500	-0.586	-0.086
FL	0.000	0.016	0.400	0.000	0.016	0.000

⌗	MM	LOC3 - RIGHT_FLANGE_SEAL_SURF				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	1.000	0.985	0.500	0.500	-0.015	0.000
FL	0.000	0.010	0.250	0.000	0.010	0.000

FCFPERP1	MM	⊥ 0.4 B				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
DATUM_C	0.000	0.082	0.400	0.000	0.082	0.000

FCFPERP2	MM	⊥ 0.4 A				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_...	0.000	0.021	0.400	0.000	0.021	0.000

FCFPARL1	MM	// 0.5 C				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_...	0.000	0.133	0.500	0.000	0.133	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	0.001	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	0.000

⌗	MM	LOC7 - LEFT_FLANGE_SEAL_SURF				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL

AX	I	J	K
V	0.001	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		0.001		1.000		0.001

↔	MM	DIST1 - LEFT_FLANGE_PLN TO LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	1.000	0.974	0.200	0.200	-0.026	0.000

▱	MM	FLAT1 - LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.000	0.007	0.250	0.000	0.007	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	0.264	0.050	0.000	0.264	0.214

⌗	MM	LOC11 - DATUM_A_CYL1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.389	0.200	0.200	0.389	0.189
RN	0.000	0.326	0.050	0.000	0.326	0.276

⌗	MM	LOC12 - DAT_B_DAT_A_CYL1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.335	0.050	0.050	0.335	0.285
RN	0.000	0.414	0.050	0.000	0.414	0.364

⌖	MM	LOC13 - DATUM_B_END1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
X	0.000	0.021			0.021		
Y	0.000	0.000			0.000		
Z	0.000	-0.045			-0.045		
TP	RFS	0.100	0.500		0.100	0.000	0.000

⌖	MM	LOC14 - DATUM_B_END2

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.016			-0.016	
Y	170.000	170.000			0.000	
Z	0.000	0.078			0.078	
TP	RFS	0.160	0.500		0.160	0.000

⌖	MM	LOC17 - DATUM_A_END1

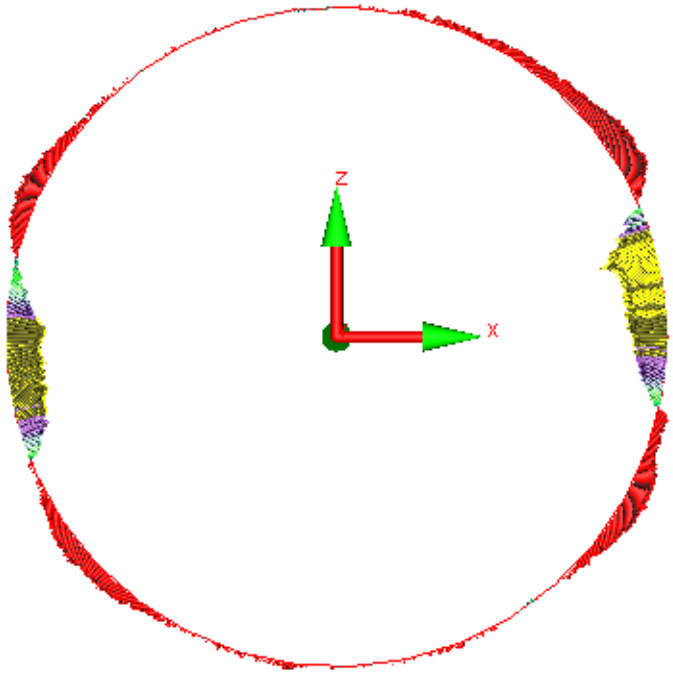
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.039			0.039	
Y	567.500	567.500			0.000	
Z	0.000	0.041			0.041	
TP	RFS	0.113	0.500		0.113	0.000

⌖	MM	LOC18 - DATUM_A_END2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.048			-0.048	
Y	397.500	397.500			0.000	
Z	0.000	-0.073			-0.073	
TP	RFS	0.174	0.500		0.174	0.000

⌗	MM	LOC19 - FLANGE_RIGHT_OD				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.064	0.050	0.050	0.064	0.014
Z	0.000	-0.052	0.050	0.050	-0.052	-0.002
D	170.000	169.917	0.200	0.200	-0.083	0.000
RN	0.000	0.024	0.100	0.000	0.024	0.000

⌗	MM	LOC20 - FLANGE_LEFT_OD				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.036	0.050	0.050	0.036	0.000
Z	0.000	-0.008	0.050	0.050	-0.008	0.000
D	170.000	169.930	0.200	0.200	-0.070	0.000
RN	0.000	0.006	0.100	0.000	0.006	0.000

卌	MM	LOC21 - MID_WELD_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.010	0.500	0.500	0.010	0.000
Y	283.750	284.093	0.500	0.500	0.343	0.000
Z	0.000	-0.085	0.500	0.500	-0.085	0.000
D	404.550	404.645	0.050	0.000	0.095	0.045
RN	0.000	0.554	0.200	0.000	0.554	0.354



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	8.512	0.130	0.130	0.012	0.000	0.142
FLANGE_RIG...	8.500	8.527	0.130	0.130	0.027	0.000	0.157
FLANGE_RIG...	8.500	8.526	0.130	0.130	0.026	0.000	0.156
FLANGE_RIG...	8.500	8.512	0.130	0.130	0.012	0.000	0.142
FLANGE_RIG...	8.500	8.522	0.130	0.130	0.022	0.000	0.152
FLANGE_RIG...	8.500	8.507	0.130	0.130	0.007	0.000	0.137
FLANGE_RIG...	8.500	8.512	0.130	0.130	0.012	0.000	0.142
FLANGE_RIG...	8.500	8.505	0.130	0.130	0.005	0.000	0.135
FLANGE_RIG...	8.500	8.522	0.130	0.130	0.022	0.000	0.152
FLANGE_RIG...	8.500	8.515	0.130	0.130	0.015	0.000	0.145
FLANGE_RIG...	8.500	8.505	0.130	0.130	0.005	0.000	0.135
FLANGE_RIG...	8.500	8.510	0.130	0.130	0.010	0.000	0.140
FLANGE_RIG...	8.500	8.514	0.130	0.130	0.014	0.000	0.144
FLANGE_RIG...	8.500	8.525	0.130	0.130	0.025	0.000	0.155
FLANGE_RIG...	8.500	8.526	0.130	0.130	0.026	0.000	0.156
FLANGE_RIG...	8.500	8.528	0.130	0.130	0.028	0.000	0.158
FLANGE_RIG...	8.500	8.511	0.130	0.130	0.011	0.000	0.141
FLANGE_RIG...	8.500	8.518	0.130	0.130	0.018	0.000	0.148

FCFLOC1 Position	MM	⌖ Ø0.2 Ⓜ RF RO					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_RIGH...	0.000	0.056	0.200		0.056	0.000	0.142
FLANGE_RIGH...	0.000	0.034	0.200		0.034	0.000	0.157
FLANGE_RIGH...	0.000	0.031	0.200		0.031	0.000	0.156
FLANGE_RIGH...	0.000	0.055	0.200		0.055	0.000	0.142
FLANGE_RIGH...	0.000	0.009	0.200		0.009	0.000	0.152
FLANGE_RIGH...	0.000	0.021	0.200		0.021	0.000	0.137

FLANGE_RIGHT_CIR7	0.030	0.142	
FLANGE_RIGHT_CIR8	0.048	0.135	
FLANGE_RIGHT_CIR9	0.042	0.152	
FLANGE_RIGHT_CIR10	0.045	0.145	
FLANGE_RIGHT_CIR11	0.059	0.135	
FLANGE_RIGHT_CIR12	0.057	0.140	
FLANGE_RIGHT_CIR13	0.016	0.144	
FLANGE_RIGHT_CIR14	0.016	0.155	
FLANGE_RIGHT_CIR15	0.024	0.156	
FLANGE_RIGHT_CIR16	0.078	0.158	
FLANGE_RIGHT_CIR17	0.053	0.141	
FLANGE_RIGHT_CIR18	0.059	0.148	

FCFLOC1 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	0.000	0.000	0.000	0.000	0.027	0.000

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

Feature	AX	NOMINAL	MEAS	DEV
FLANGE_RIGHT_TOP_CIR1	PR	75.800	75.805	0.005
	PA	90.000	90.021	0.021
FLANGE_RIGHT_CIR2	PR	75.800	75.809	0.009
	PA	110.000	110.011	0.011
FLANGE_RIGHT_CIR3	PR	75.800	75.814	0.014
	PA	130.000	130.005	0.005
FLANGE_RIGHT_CIR4	PR	75.800	75.803	0.003
	PA	150.000	150.021	0.021
FLANGE_RIGHT_CIR5	PR	75.800	75.796	-0.004
	PA	170.000	169.998	-0.002
FLANGE_RIGHT_CIR6	PR	75.800	75.803	0.003
	PA	190.000	190.008	0.008
FLANGE_RIGHT_CIR7	PR	75.800	75.814	0.014
	PA	210.000	210.003	0.003
FLANGE_RIGHT_CIR8	PR	75.800	75.821	0.021
	PA	230.000	229.992	-0.008
FLANGE_RIGHT_CIR9	PR	75.800	75.800	0.000
	PA	250.000	249.984	-0.016

FLANGE_RIGHT_CIR10	PR	75.800	75.779	-0.021
	PA	270.000	269.995	-0.005
FLANGE_RIGHT_CIR11	PR	75.800	75.771	-0.029
	PA	290.000	290.000	0.000
FLANGE_RIGHT_CIR12	PR	75.800	75.772	-0.028
	PA	310.000	309.994	-0.006
FLANGE_RIGHT_CIR13	PR	75.800	75.792	-0.008
	PA	330.000	330.000	0.000
FLANGE_RIGHT_CIR14	PR	75.800	75.803	0.003
	PA	350.000	350.006	0.006
FLANGE_RIGHT_CIR15	PR	75.800	75.792	-0.008
	PA	10.000	10.007	0.007
FLANGE_RIGHT_CIR16	PR	75.800	75.773	-0.027
	PA	30.000	30.021	0.021
FLANGE_RIGHT_CIR17	PR	75.800	75.781	-0.019
	PA	50.000	50.014	0.014
FLANGE_RIGHT_CIR18	PR	75.800	75.779	-0.021
	PA	70.000	70.016	0.016

FCFLOC2 Size	MM	18XØ8.5 0.13/0.13

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_LEF...	8.500	8.547	0.130	0.130	0.047	0.000	0.177
FLANGE_LEF...	8.500	8.518	0.130	0.130	0.018	0.000	0.148
FLANGE_LEF...	8.500	8.522	0.130	0.130	0.022	0.000	0.152
FLANGE_LEF...	8.500	8.532	0.130	0.130	0.032	0.000	0.162
FLANGE_LEF...	8.500	8.527	0.130	0.130	0.027	0.000	0.157
FLANGE_LEF...	8.500	8.533	0.130	0.130	0.033	0.000	0.163
FLANGE_LEF...	8.500	8.526	0.130	0.130	0.026	0.000	0.156
FLANGE_LEF...	8.500	8.526	0.130	0.130	0.026	0.000	0.156
FLANGE_LEF...	8.500	8.528	0.130	0.130	0.028	0.000	0.158
FLANGE_LEF...	8.500	8.527	0.130	0.130	0.027	0.000	0.157
FLANGE_LEF...	8.500	8.540	0.130	0.130	0.040	0.000	0.170
FLANGE_LEF...	8.500	8.527	0.130	0.130	0.027	0.000	0.157
FLANGE_LEF...	8.500	8.529	0.130	0.130	0.029	0.000	0.159
FLANGE_LEF...	8.500	8.520	0.130	0.130	0.020	0.000	0.150
FLANGE_LEF...	8.500	8.519	0.130	0.130	0.019	0.000	0.149
FLANGE_LEF...	8.500	8.532	0.130	0.130	0.032	0.000	0.162
FLANGE_LEF...	8.500	8.557	0.130	0.130	0.057	0.000	0.187
FLANGE_LEF...	8.500	8.543	0.130	0.130	0.043	0.000	0.173

FCFLOC2 Position	MM	⌖ Ø0.2 Ⓜ LF LO

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_LEFT_CIR1	0.000	0.099	0.200		0.099	0.000	0.177
FLANGE_LEFT_CIR2	0.000	0.081	0.200		0.081	0.000	0.148
FLANGE_LEFT_CIR3	0.000	0.047	0.200		0.047	0.000	0.152

FLANGE_LEFT_CIR4	0.091	0.162	
FLANGE_LEFT_CIR5	0.109	0.157	
FLANGE_LEFT_CIR6	0.088	0.163	
FLANGE_LEFT_CIR7	0.092	0.156	
FLANGE_LEFT_CIR8	0.091	0.156	
FLANGE_LEFT_CIR9	0.104	0.158	
FLANGE_LEFT_CIR10	0.115	0.157	
FLANGE_LEFT_CIR11	0.109	0.170	
FLANGE_LEFT_CIR12	0.113	0.157	
FLANGE_LEFT_CIR13	0.141	0.159	
FLANGE_LEFT_CIR14	0.144	0.150	
FLANGE_LEFT_CIR15	0.146	0.149	
FLANGE_LEFT_CIR16	0.127	0.162	
FLANGE_LEFT_CIR17	0.116	0.187	
FLANGE_LEFT_CIR18	0.103	0.173	

FCFLOC2 Datum Shift

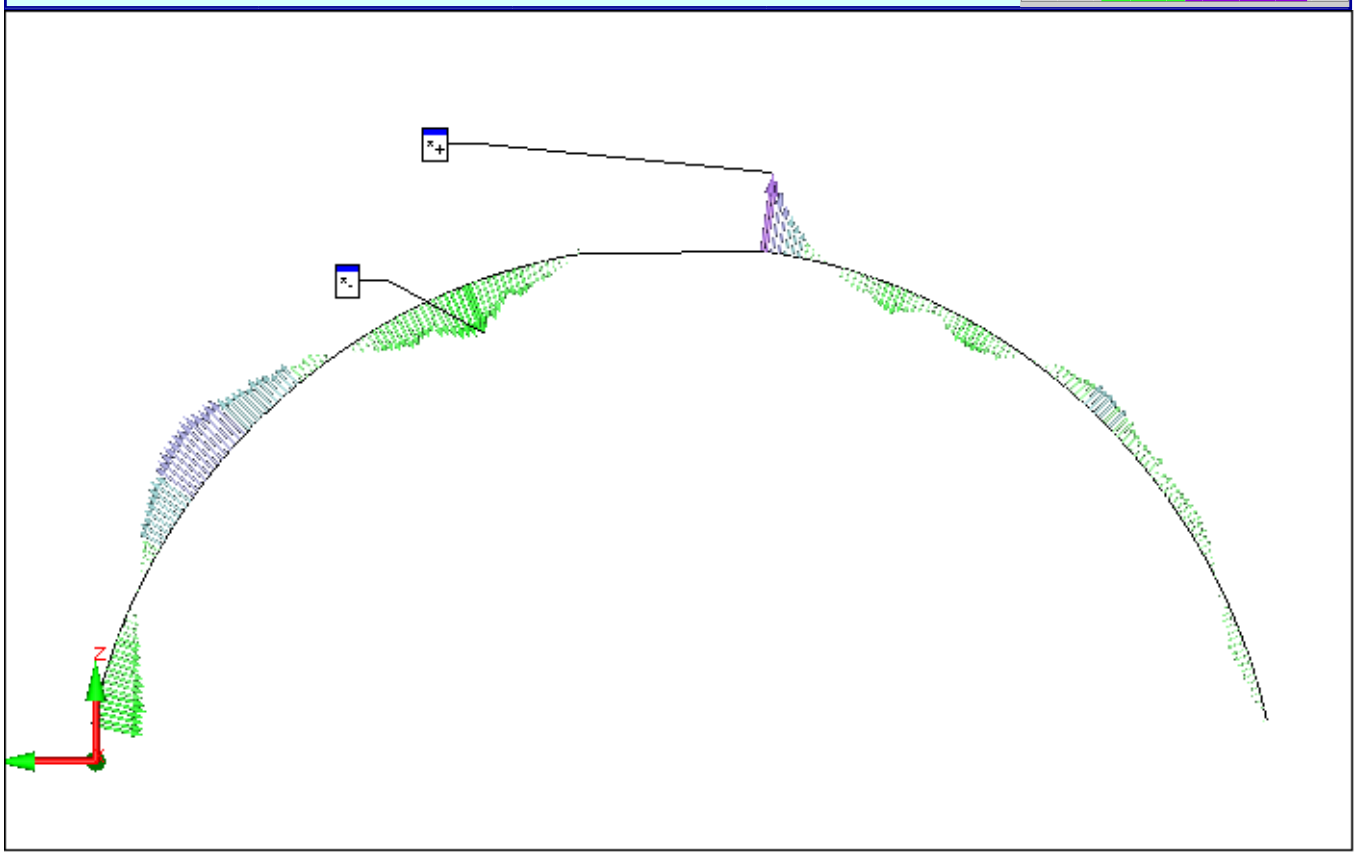
Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	0.000	0.000	0.000	0.000	358.920	0.000

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

Feature	AX	NOMINAL	MEAS	DEV
FLANGE_LEFT_CIR1	PR	75.800	75.807	0.007
	PA	90.000	90.037	0.037
FLANGE_LEFT_CIR2	PR	75.800	75.820	0.020
	PA	110.000	110.027	0.027
FLANGE_LEFT_CIR3	PR	75.800	75.819	0.019
	PA	130.000	130.010	0.010
FLANGE_LEFT_CIR4	PR	75.800	75.844	0.044
	PA	150.000	150.008	0.008
FLANGE_LEFT_CIR5	PR	75.800	75.852	0.052
	PA	170.000	169.988	-0.012
FLANGE_LEFT_CIR6	PR	75.800	75.839	0.039
	PA	190.000	189.985	-0.015

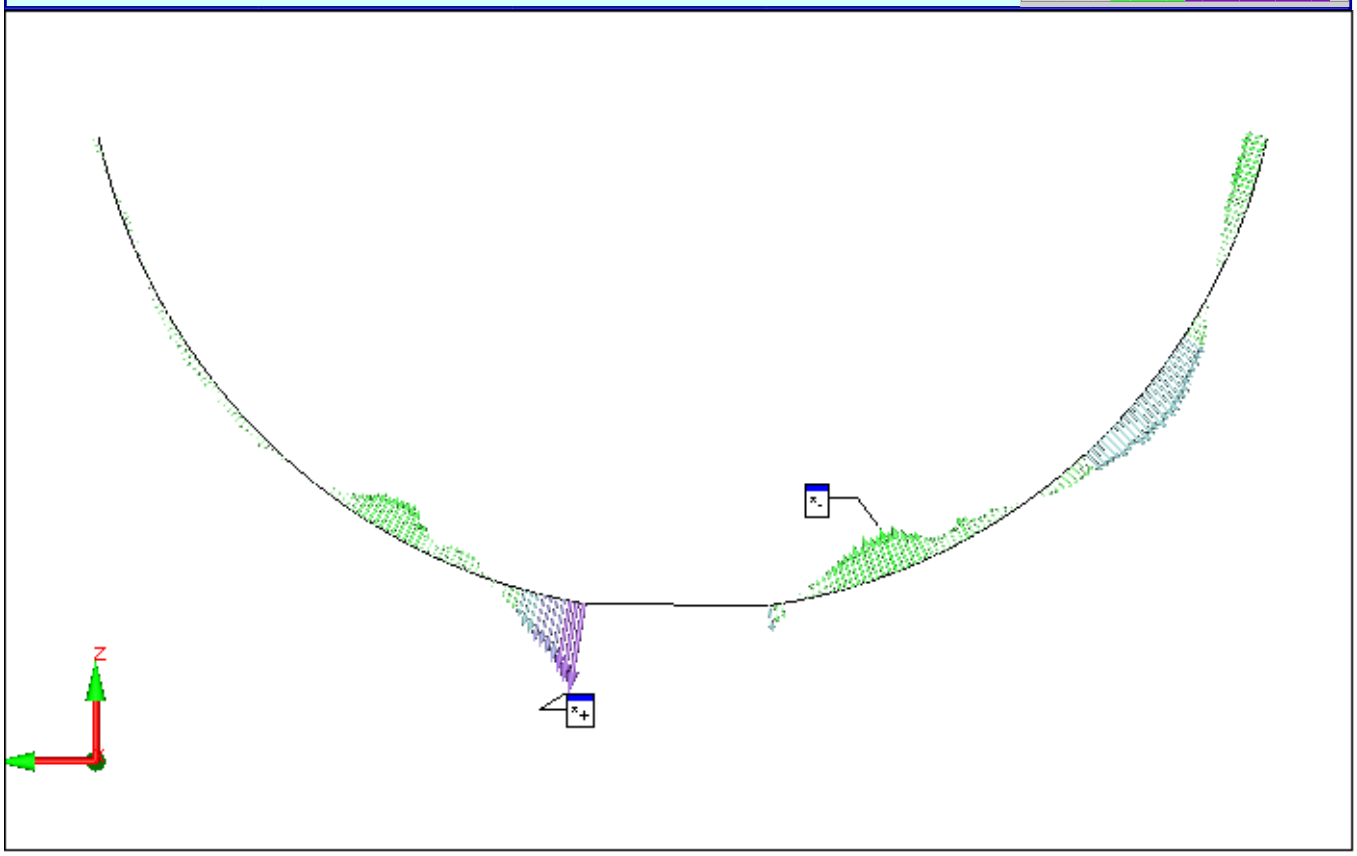
FLANGE_LEFT_CIR7	PR	75.800	75.821	0.021
	PA	210.000	209.969	-0.031
FLANGE_LEFT_CIR8	PR	75.800	75.809	0.009
	PA	230.000	229.966	-0.034
FLANGE_LEFT_CIR9	PR	75.800	75.805	0.005
	PA	250.000	249.961	-0.039
FLANGE_LEFT_CIR10	PR	75.800	75.804	0.004
	PA	270.000	269.957	-0.043
FLANGE_LEFT_CIR11	PR	75.800	75.796	-0.004
	PA	290.000	289.959	-0.041
FLANGE_LEFT_CIR12	PR	75.800	75.773	-0.027
	PA	310.000	309.962	-0.038
FLANGE_LEFT_CIR13	PR	75.800	75.738	-0.062
	PA	330.000	329.975	-0.025
FLANGE_LEFT_CIR14	PR	75.800	75.731	-0.069
	PA	350.000	349.984	-0.016
FLANGE_LEFT_CIR15	PR	75.800	75.727	-0.073
	PA	10.000	10.000	0.000
FLANGE_LEFT_CIR16	PR	75.800	75.743	-0.057
	PA	30.000	30.020	0.020
FLANGE_LEFT_CIR17	PR	75.800	75.779	-0.021
	PA	50.000	50.041	0.041
FLANGE_LEFT_CIR18	PR	75.800	75.800	0.000
	PA	70.000	70.039	0.039

FCFPROF1	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS	
Feature	MEAS	MAX	MIN	
Set	0.189	0.112	-0.076	



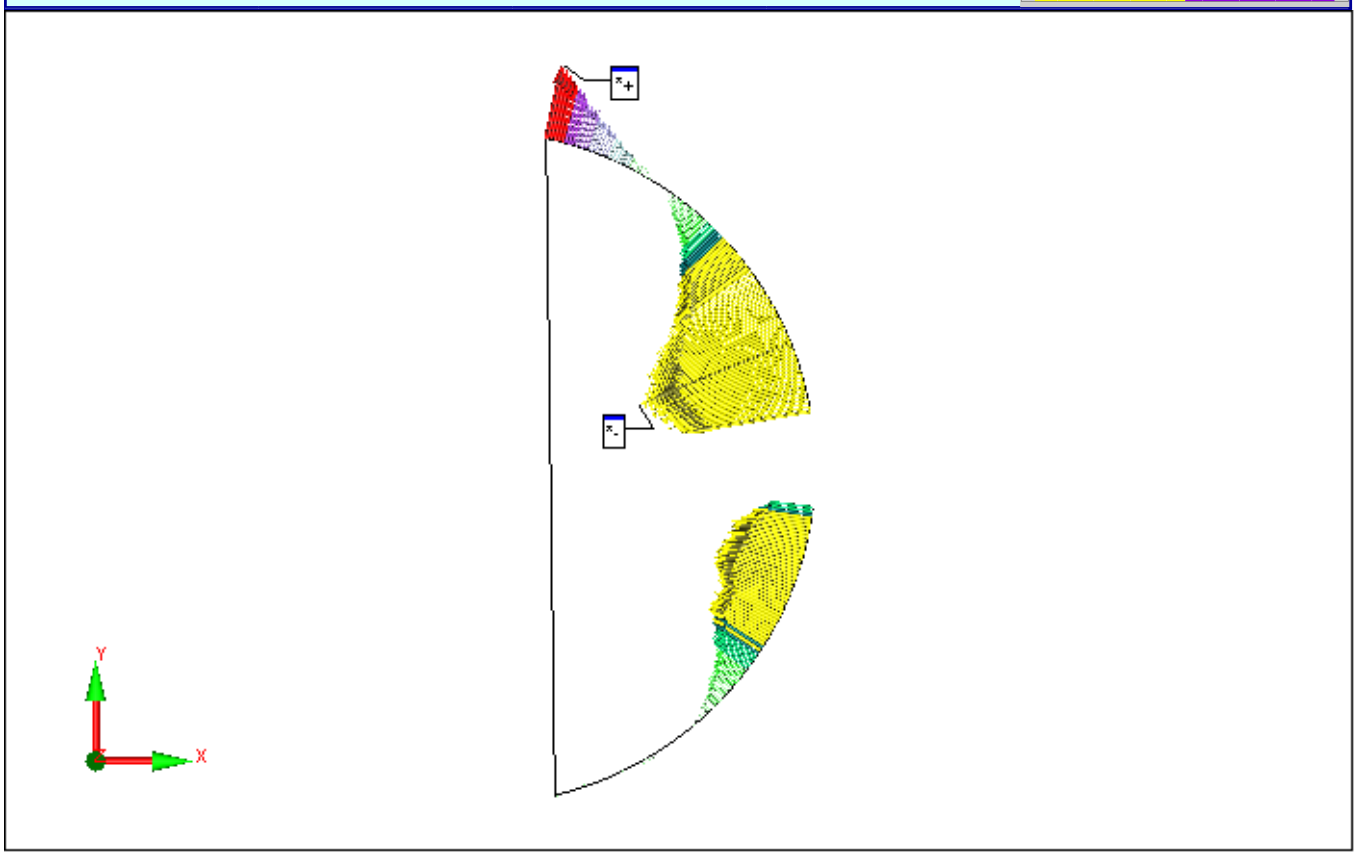
PROFILE OF RIGHT AND LEFT HALF CELLS 12 'O' CLOCK- X100

FCFPROF2	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS	
Feature	MEAS	MAX	MIN	
Set	0.201	0.133	-0.068	



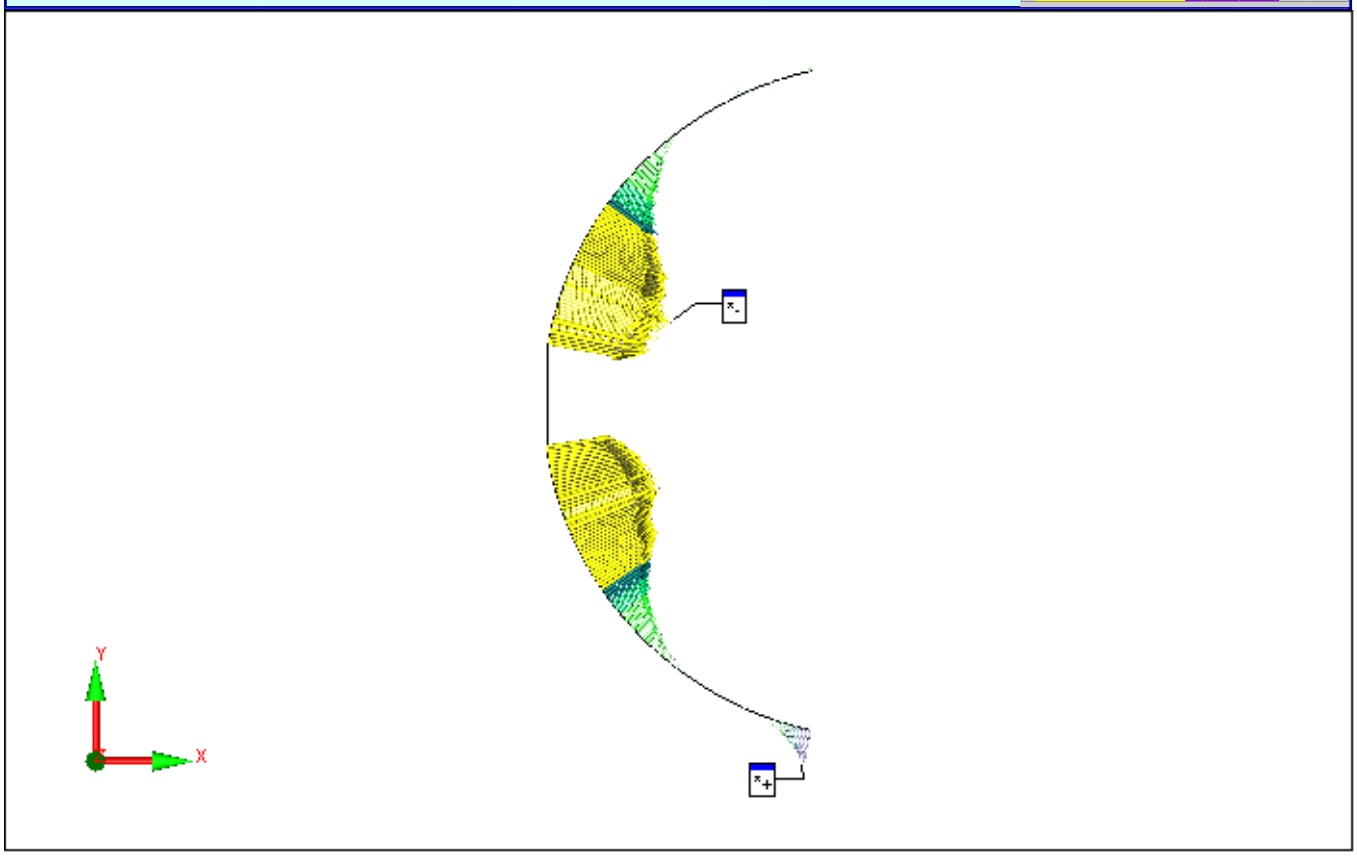
PROFILE OF RIGHT AND LEFT HALF CELLS 6 'O' CLOCK- X100

FCFPROF3	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS	
Feature	MEAS	MAX	MIN	
Set	0.616	0.192	-0.424	

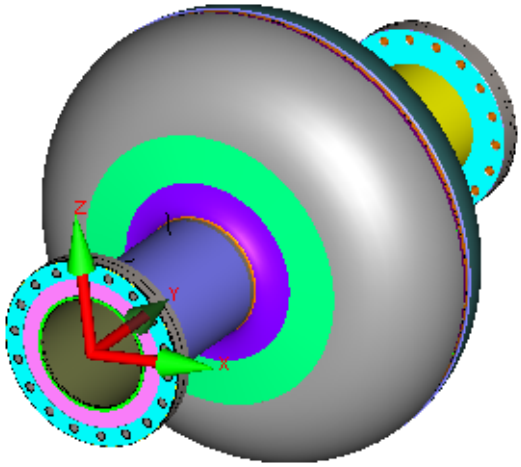


PROFILE OF RIGHT AND LEFT HALF CELLS 3 'O' CLOCK- X100

FCFPROF4	MM	.3	FORMONLY VECTOR_LST_SQR ABOUT XPLUS	
Feature	MEAS	MAX	MIN	
Set	0.377	0.086	-0.291	



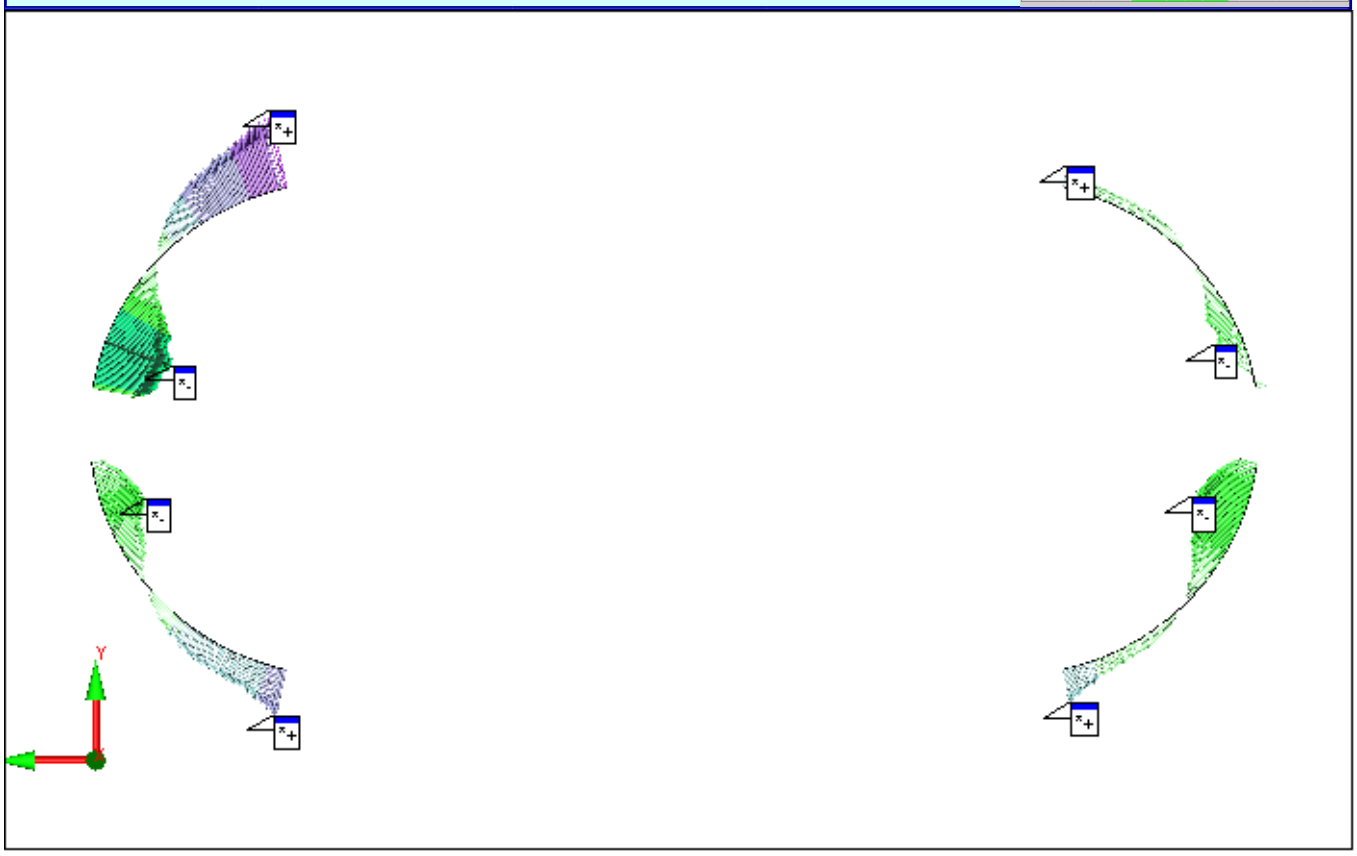
PROFILE OF RIGHT AND LEFT HALF CELLS 9 'O' CLOCK- X100



1	MM	FLANGE_RIGHT SURFACE FINISH			
AX	NOMINAL	MEAS	DEV	OUTTOL	
M	0.400	0.580	0.180	0.170	

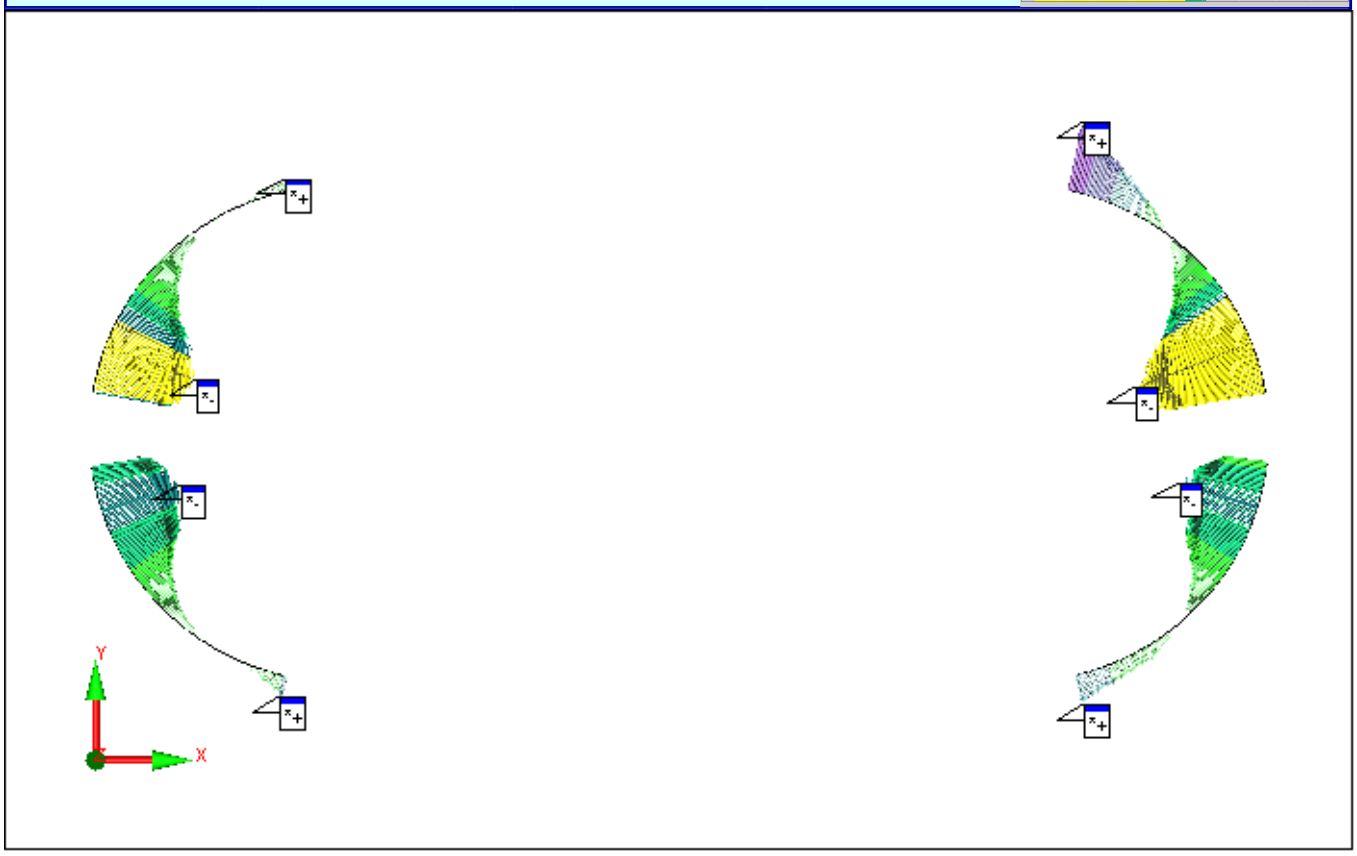
1	MM	FLANGE_LEFT SURFACE FINISH			
AX	NOMINAL	MEAS	DEV	OUTTOL	
M	0.400	0.300	-0.100	0.000	

⌒	MM	PROF10 - ZPLUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.322	0.168	-0.154
⌒	MM	PROF11 - ZPLUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.527	0.275	-0.252
⌒	MM	PROF14 - ZMINUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.308	0.119	-0.189
⌒	MM	PROF15 - ZMINUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.178	0.080	-0.098



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		0.669	0.240	-0.429
⌒	MM	PROF13 - XPLUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.386	0.104	-0.282
⌒	MM	PROF16 - XMINUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.367	0.074	-0.293
⌒	MM	PROF17 - XMINUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.379	0.039	-0.340



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