pc-dmis	PART NAME : PN457528-n-v5-IL-PIPPS03-001		July 13, 2012	09:55
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

457528-n
DESY 1.3GHZ TESLA
SINGLE CELL RF CAVITY ASSEMBLY
RF#94735 S/N PIPPS03-001 (STFC DARESBURY)
INSPECTOR: O. LIRA 07/12/12

⌖	MM	LOC1 - PLN1_FLANGE1				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	196.000	196.142	0.142	0.500	0.500	0.000
FL	0.000	0.073	0.073	0.400	0.000	0.000

⌖	MM	LOC2 - PLN1_FLANGE2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-196.000	-196.143	-0.143	0.500	0.500	0.000
FL	0.000	0.074	0.074	0.400	0.000	0.000

⌖	MM	LOC3 - PLN1_SEAL_SURF_FLNG1				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	195.000	195.396	0.396	0.500	0.500	0.000
FL	0.000	0.032	0.032	0.400	0.000	0.000

⌖	MM	LOC4 - PLN1_SEAL_SURF_FLNG2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-195.000	-195.395	-0.395	0.500	0.500	0.000
FL	0.000	0.032	0.032	0.400	0.000	0.000

⌖	MM	LOC5(WELD) - PLN1_BEAM_TUBE_FLNG1				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	196.000	195.444	-0.556	0.500	0.500	-0.056
FL	0.000	0.044	0.044	0.400	0.000	0.000

⌖	MM	LOC6(WELD) - PLN1_BEAM_TUBE_FLNG2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-196.000	-195.517	0.483	0.500	0.500	0.000
FL	0.000	0.139	0.139	0.400	0.000	0.000

⊥	MM	PERP1 - PLN1_FLANGE1 TO LIN1_BEAM_AXIS				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0	0.178	0.178	0.400	0	0.000

⊥	MM	PERP2 - PLN1_FLANGE2 TO LIN1_BEAM_AXIS				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0	0.288	0.288	0.400	0	0.000

//	MM	PARL1 - PLN1_FLANGE1 TO PLN1_FLANGE2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	0	0.434	0.434	0.400	0	0.034

⌖	MM	LOC7 - PLN1_FLANGE1				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL

AX	I	J	K
V	1.00000	-0.00117	0.00080

⌖	MM	LOC8 - PLN1_FLANGE2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL

AX	I	J	K
V	-1.00000	-0.00170	0.00103

⌗	MM	LOC9 - PLN1_SEAL_SURF_FLNG1

AX	I	J	K
V	1.00000	-0.00162	0.00188

⌗	MM	LOC10 - PLN1_SEAL_SURF_FLNG2

AX	I	J	K
V	-1.00000	-0.00163	0.00126

⌗	MM	LOC11 - PLN1_BEAM_TUBE_FLNG1

AX	I	J	K
V	1.00000	-0.00092	0.00048

⌗	MM	LOC12 - PLN1_BEAM_TUBE_FLNG2

AX	I	J	K
V	-1.00000	-0.00149	0.00225

↔	MM	DIST1 - PLN1_FLANGE1 TO PLN1_FLANGE2 (XAXIS)

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	392.000	392.285	0.285	1.000	1.000	0.000

↔	MM	DIST2 - PLN1_FLANGE1 TO PLN1_SEAL_SURF_FLNG1 (XAXIS)

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	1.000	0.747	-0.253	0.100	0.000	-0.253

↔	MM	DIST3 - PLN1_FLANGE2 TO PLN1_SEAL_SURF_FLNG2 (XAXIS)

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	1.000	0.747	-0.253	0.100	0.000	-0.253

↔	MM	DIST4 - PNT2_FLNG1 TO PNT2_FLNG2 (XAXIS)

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	392.000	392.275	0.275	1.000	1.000	0.000

↔	MM	DIST5 - PNT5_FLNG1 TO PNT5_FLNG2 (XAXIS)

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	392.000	392.113	0.113	1.000	1.000	0.000

↔	MM	DIST6 - PNT8_FLNG1 TO PNT8_FLNG2 (XAXIS)

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	392.000	392.176	0.176	1.000	1.000	0.000

↔	MM	DIST7 - PNT11_FLNG1 TO PNT11_FLNG2 (XAXIS)

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
M	392.000	392.563	0.563	1.000	1.000	0.000

⌗	MM	LOC13 - CIR1_BTUBE1_ID

AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	193.000	193.959	0.959	10.000	10.000	0.000
Y	0.000	0.000	0.000	0.000	0.000	0.000
Z	0.000	0.000	0.000	0.000	0.000	0.000
D	78.100	78.221	0.121	0.050	0.000	0.071
RN	0.000	0.314	0.314	0.050	0.000	0.264

⌗	MM	LOC14 - CIR1_BTUBE2_ID				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-193.000	-194.239	-1.239	10.000	10.000	0.000
Y	0.000	0.004	0.004	0.000	0.000	0.004
Z	0.000	-0.056	-0.056	0.000	0.000	-0.056
D	78.100	78.390	0.290	0.050	0.000	0.240
RN	0.000	0.393	0.393	0.050	0.000	0.343

⌗	MM	LOC15 - CIR1_BOLT_CIR_FLNG1				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	193.000	192.904	-0.096	10.000	10.000	0.000
Y	0.000	0.027	0.027	0.150	0.150	0.000
Z	0.000	0.007	0.007	0.150	0.150	0.000
D	120.000	119.991	-0.009	0.150	0.150	0.000
RN	0.000	0.094	0.094	0.150	0.000	0.000

⌗	MM	LOC16 - CIR2_BOLT_CIR_FLNG2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-193.000	-193.184	-0.184	10.000	10.000	0.000
Y	0.000	-0.015	-0.015	0.150	0.150	0.000
Z	0.000	-0.077	-0.077	0.150	0.150	0.000
D	120.000	120.029	0.029	0.150	0.150	0.000
RN	0.000	0.042	0.042	0.150	0.000	0.000

⌗	MM	LOC17 - CIRC_HALF_CELL_1				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	4.500	5.023	0.523	1.000	1.000	0.000
Y	0.000	0.133	0.133	0.100	0.100	0.033
Z	0.000	-0.137	-0.137	0.100	0.100	-0.037
D	210.300	211.211	0.911	0.050	0.000	0.861
RN	0.000	0.155	0.155	0.050	0.000	0.105

⌗	MM	LOC18 - CIRC_HALF_CELL_2				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	-4.500	-3.982	0.518	1.000	1.000	0.000
Y	0.000	0.185	0.185	0.100	0.100	0.085
Z	0.000	-0.075	-0.075	0.100	0.100	0.000
D	210.300	211.111	0.811	0.050	0.000	0.761
RN	0.000	0.230	0.230	0.050	0.000	0.180

⌗	MM	LOC19 - CIRC_BEAM_TUBE1_OD				
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL
X	61.527	61.521	-0.006	1.000	1.000	0.000
Y	0.000	0.224	0.224	0.100	0.100	0.124
Z	0.000	-0.148	-0.148	0.100	0.100	-0.048
D	82.000	84.159	2.159	0.100	0.050	2.059
RN	0.000	0.231	0.231	0.150	0.000	0.081

⌗	MM	LOC20 - CIRC_BEAM_TUBE2_OD					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
X	-66.473	-66.479	-0.006	1.000	1.000	0.000	
Y	0.000	0.307	0.307	0.100	0.100	0.207	
Z	0.000	-0.135	-0.135	0.100	0.100	-0.035	
D	82.000	84.236	2.236	0.100	0.050	2.136	
RN	0.000	0.282	0.282	0.150	0.000	0.132	

∡	DEG	ANGL1(CLOCKING BETWEEN FLANGE HOLES) - LIN_ROT_FLNG1 TO LIN1_ROT_FLNG2		
AX	NOMINAL	MEAS	DEV	
A	0.000	-7.256	-7.256	

⌗	MM	LOC21 - LIN_ROT_FLNG1		
AX	NOMINAL	MEAS	DEV	
AX	I	J	K	
V	0.00210	0.00000	1.00000	

⌗	MM	LOC22 - LIN1_ROT_FLNG2		
AX	NOMINAL	MEAS	DEV	
AX	I	J	K	
V	0.00205	0.12630	0.99199	

⌗	MM	LOC25 - CIR1_SEAL_SURF_ID_FLNG1					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
D	109.200	101.377	-7.823	0.200	0.000	-7.823	
RN	0.000	0.019	0.019	0.200	0.000	0.000	

⌗	MM	LOC26 - CIR1_SEAL_SURF_ID_FLNG2					
AX	NOMINAL	MEAS	DEV	+TOL	-TOL	OUTTOL	
D	109.200	101.408	-7.792	0.200	0.000	-7.792	
RN	0.000	0.021	0.021	0.200	0.000	0.000	

****** REPORT ABBREVIATIONS ******

BT= BEAM TUBE

HC= HALF CELL

FLNG= FLANGE

OD= OUTSIDE DIAMETER

ID= INSIDE DIAMETER

BC= BOLT CIRCLE