pc-dmis	PART NAME : 439480J_113		January 08, 2013	09:19
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

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HINS- FRONT END SSR1
SSR1 SINGLE SPOKE RESONATOR
ME-439480 REV. J
RF# 95339 SERIAL # S1G-NR-113
INSPECTOR :O. LIRA

            AXIS ALIGNMENT(REFERENCE FRAME)WAS CREATED AS FOLLOWS :

            ALIGNMENT/LEVEL,XPLUS,LINE_OUTER_M5_M6
            ALIGNMENT/TRANS,YAXIS,ORIGIN
            ALIGNMENT/TRANS,ZAXIS,ORIGIN
            ALIGNMENT/ROTATE,YMINUS,TO,6"_CF_LINE,ABOUT,XPLUS
            ALIGNMENT/TRANS,XAXIS,ORIGIN

LINE_OUTER_M5_M6= CONSTRUCTED LINE OUT OF THE TWO OUTER CIRCLES M5 AND M6 (DATUM A)
          ORIGIN= CONSTRUCTED POINT AT THE INTERSECTION OF LINE_OUTER_M5_M6 AND MIDPLN_X
        MIDPLN_X= CONSTRUCTED MID PLANE BETWEEN LEFT AND RIGHT FLANGE
      6"_CF_LINE= CONSTRUCTED LINE OUT OF FRONT AND BACK 6" CF ID CYLINDERS
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↔	MM	M1 - LOWER_M1_PLN TO UPPER_M1_PLN							
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	MAX	MIN	
M	614.500	614.941	0.050	0.050	0.441	0.391	615.281	614.598	

FCFFLAT1	MM	⏥ 0.05				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LOWER_M1_PLN	0.000	0.046	0.050		0.046	0.000
UPPER_M1_PLN	0.000	0.046	0.050		0.046	0.000

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Following are point to point measurements for M2
M2 @ 12:00 measures 342.121
M2 @ 03:00 measures 341.907
M2 @ 06:00 measures 342.161
M2 @ 09:00 measures 342.002
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FCFFLAT2	MM	⏥ 0.05				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M2_LEFT_PLN	0.000	0.106	0.050		0.106	0.056
M2_RIGHT_PLN	0.000	0.081	0.050		0.081	0.031

↔	MM	M3-1 - FRONT_LOWER_LEFT_M3 TO FRONT_LOWER_RIGHT_M3 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	100.000	100.877	0.200	0.200	0.877	0.677

↔	MM	M3-2 - FRONT_LEFT_M3 TO FRONT_RIGHT_M3 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	100.000	96.083	0.200	0.200	-3.917	-3.717

↔	MM	M3-3 - FRONT_UPPER_LEFT_M3 TO FRONT_UPPER_RIGHT_M3 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	100.000	101.625	0.200	0.200	1.625	1.425

↔	MM	M3-4 - BACK_UPPER_LEFT_M3 TO BACK_UPPER_RIGHT_M3 (XAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	100.000	99.870	0.200	0.200	-0.130	0.000	

↔	MM	M3-5 - BACK_LOWER_LEFT_M3 TO BACK_LOWER_RIGHT_M3 (XAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	100.000	97.972	0.200	0.200	-2.028	-1.828	

⌗	MM	M4_MAX - M4_CYL_MIN_CIRCUBSCRIBED					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	0.000	-0.235	1.000	1.000	-0.235	0.000	
Z	0.000	0.174	1.000	1.000	0.174	0.000	
D	497.900	498.698	0.200	0.200	0.798	0.598	
RN	0.000	2.216	0.050	0.000	2.216	2.166	

⌗	MM	M4_MIN - M4_CYL_MAX_INSCRIBED					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	0.000	0.079	1.000	1.000	0.079	0.000	
Z	0.000	-0.344	1.000	1.000	-0.344	0.000	
D	497.900	495.433	0.200	0.200	-2.467	-2.267	
RN	0.000	2.114	0.050	0.000	2.114	2.064	

⌗	MM	M5_MIN - M5_MAX_INSC					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	0.000	-0.080	1.000	1.000	-0.080	0.000	
Z	0.000	-0.099	1.000	1.000	-0.099	0.000	
D	29.640	29.358	0.050	0.050	-0.282	-0.232	
RN	0.000	0.054	0.050	0.000	0.054	0.004	

⌗	MM	M5_MAX - M5_MIN_CIRCUMSCRIBED					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	0.000	-0.067	1.000	1.000	-0.067	0.000	
Z	0.000	-0.082	1.000	1.000	-0.082	0.000	
D	29.640	29.436	0.050	0.050	-0.204	-0.154	
RN	0.000	0.057	0.050	0.000	0.057	0.007	

⌗	MM	M6 - M6_CYL					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	0.000	0.006	1.000	1.000	0.006	0.000	
Z	0.000	0.002	1.000	1.000	0.002	0.000	
D	29.640	29.408	0.050	0.050	-0.232	-0.182	
RN	0.000	0.036	0.050	0.000	0.036	0.000	

⌗	MM	M6_MIN - M6_MAX_INSC					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	0.000	-0.029	1.000	1.000	-0.029	0.000	
Z	0.000	0.002	1.000	1.000	0.002	0.000	
D	29.640	29.378	0.050	0.050	-0.262	-0.212	
RN	0.000	0.036	0.050	0.000	0.036	0.000	

	MM	M6_MAX - M6_MIN_CIRCUMSCRIBED

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	-0.033	1.000	1.000	-0.033	0.000
Z	0.000	-0.007	1.000	1.000	-0.007	0.000
D	29.640	29.441	0.050	0.050	-0.199	-0.149
RN	0.000	0.042	0.050	0.000	0.042	0.000

	MM	M7 - M7_PNT TO LEFT_FLANGE_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	129.000	129.736	0.200	0.200	0.736	0.536

	MM	M8 - PNT21 TO RIGHT_FLANGE_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	129.000	129.954	0.200	0.200	0.954	0.754

	MM	M9 - LEFT_FLANGE_PLN TO RIGHT_FLANGE_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	MAX	MIN
M	292.270	293.576	0.200	0.200	1.306	1.106	294.544	294.205

	MM	M10 - M10_RIGHT_PLN TO M10_LEFT_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	MAX	MIN
M	301.600	301.472	0.200	0.200	-0.128	0.000	301.740	301.153

	MM	A1-AXIS - M5_OUTER_CIR3

AX	NOMINAL	MEAS	DEV
Y	0.000	0.000	0.000
Z	0.000	0.000	0.000
DF	29.640	29.408	-0.232
RN	0.000	0.017	0.017
TP	RFS	0.000	0.000

	MM	M11_A - M5_MID_CIR2

AX	NOMINAL	MEAS	DEV
Y	0.000	-0.076	-0.076
Z	0.000	-0.091	-0.091
DF	29.640	29.379	-0.261
RN	0.000	0.030	0.030
TP	RFS	0.238	0.238

	MM	M11_B - M5_INNER_CIR1

AX	NOMINAL	MEAS	DEV
Y	0.000	-0.140	-0.140
Z	0.000	-0.166	-0.166
DF	29.640	29.423	-0.217
RN	0.000	0.021	0.021
TP	RFS	0.435	0.435

⌖	MM	M11_C - CENTER_CYL_XMINUS_CIR2		
AX		NOMINAL	MEAS	DEV
Y		0.000	-0.176	-0.175
Z		0.000	-0.530	-0.530
DF		29.640	29.405	-0.235
RN		0.000	0.039	0.039
TP		RFS	1.116	1.116

⌖	MM	M11_D - CENTER_CYL_XPLUS_CIR1		
AX		NOMINAL	MEAS	DEV
Y		0.000	-0.132	-0.131
Z		0.000	-0.549	-0.549
DF		29.640	29.393	-0.247
RN		0.000	0.043	0.043
TP		RFS	1.129	1.129

⌖	MM	M11_E - M6_INNER_CIR1		
AX		NOMINAL	MEAS	DEV
Y		0.000	-0.068	-0.068
Z		0.000	-0.006	-0.006
DF		29.640	29.431	-0.209
RN		0.000	0.018	0.018
TP		RFS	0.137	0.137

⌖	MM	M11_F - M6_MID_CIR2		
AX		NOMINAL	MEAS	DEV
Y		0.000	-0.028	-0.028
Z		0.000	0.003	0.003
DF		29.640	29.385	-0.255
RN		0.000	0.008	0.008
TP		RFS	0.057	0.057

⌖	MM	A2-AXIS - M6_OUTER_CIR3		
AX		NOMINAL	MEAS	DEV
Y		0.000	0.000	0.000
Z		0.000	0.000	0.000
DF		29.640	29.405	-0.235
RN		0.000	0.010	0.010
TP		RFS	0.000	0.000