pc-dmis	PART NAME : TE5CAT006		October 31, 2013	09:32
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

1.3 GHz SCRF CAVITY
FIVE CELL CAVITY ASSEMBLY
SERIAL NUMBER: TE5CAT006

RF#96083
INSPECTOR: O. LIRA

FCFCONCE...	MM	◎ Ø0.8 AB					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
CELL1_CIR1	0.000	0.145	0.800		0.145	0.000	
CELL1_CIR2	0.000	0.425	0.800		0.425	0.000	
CELL2_CIR1	0.000	0.793	0.800		0.793	0.000	
CELL2_CIR2	0.000	0.670	0.800		0.670	0.000	
CELL3_CIR1	0.000	0.716	0.800		0.716	0.000	
CELL3_CIR2	0.000	0.667	0.800		0.667	0.000	
CELL4_CIR1	0.000	0.831	0.800		0.831	0.031	
CELL4_CIR2	0.000	0.794	0.800		0.794	0.000	
CELL5_CIR1	0.000	0.379	0.800		0.379	0.000	
CELL5_CIR2	0.000	0.734	0.800		0.734	0.000	

FCFLOC1 Size	MM	10XØ210.3 0.5/0.5				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
CELL1_CIR1	210.300	210.432	0.500	0.500	0.132	0.000
CELL1_CIR2	210.300	210.536	0.500	0.500	0.236	0.000
CELL2_CIR1	210.300	210.440	0.500	0.500	0.140	0.000
CELL2_CIR2	210.300	210.498	0.500	0.500	0.198	0.000
CELL3_CIR1	210.300	210.569	0.500	0.500	0.269	0.000
CELL3_CIR2	210.300	210.503	0.500	0.500	0.203	0.000
CELL4_CIR1	210.300	210.447	0.500	0.500	0.147	0.000
CELL4_CIR2	210.300	210.459	0.500	0.500	0.159	0.000
CELL5_CIR1	210.300	210.537	0.500	0.500	0.237	0.000
CELL5_CIR2	210.300	210.422	0.500	0.500	0.122	0.000

FCFLOC1 Position	MM	⌖ Ø0.8 AB				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
CELL1_CIR1	0.000	0.145	0.800		0.145	0.000
CELL1_CIR2	0.000	0.425	0.800		0.425	0.000
CELL2_CIR1	0.000	0.793	0.800		0.793	0.000
CELL2_CIR2	0.000	0.670	0.800		0.670	0.000
CELL3_CIR1	0.000	0.716	0.800		0.716	0.000

CELL3_CIR2	0.000	0.667	0.667	0.000
CELL4_CIR1	0.000	0.831	0.831	0.000
CELL4_CIR2	0.000	0.794	0.794	0.000
CELL5_CIR1	0.000	0.379	0.379	0.000
CELL5_CIR2	0.000	0.734	0.734	0.000

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	-6.781	-0.000

FCFLOC1 Summary FIT TO DATUMS=ON

Feature	AX	NOMINAL	MEAS	DEV
CELL1_CIR1	X	0.000	-0.044	-0.044
	Z	0.000	0.058	0.058
CELL1_CIR2	X	0.000	-0.192	-0.192
	Z	0.000	0.091	0.091
CELL2_CIR1	X	0.000	-0.129	-0.129
	Z	0.000	0.375	0.375
CELL2_CIR2	X	0.000	-0.105	-0.105
	Z	0.000	0.318	0.318
CELL3_CIR1	X	0.000	-0.101	-0.101
	Z	0.000	0.344	0.344
CELL3_CIR2	X	0.000	-0.065	-0.065
	Z	0.000	0.327	0.327
CELL4_CIR1	X	0.000	0.192	0.192
	Z	0.000	0.369	0.369
CELL4_CIR2	X	0.000	0.099	0.099
	Z	0.000	0.384	0.384
CELL5_CIR1	X	0.000	0.025	0.025
	Z	0.000	0.188	0.188
CELL5_CIR2	X	0.000	0.166	0.166
	Z	0.000	0.328	0.328

	MM	LOC3 - DATUM_A_DATUM_B_CYL1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.000	0.050	0.050	0.000	0.000
Z	0.000	0.000	0.050	0.050	0.000	0.000
D	78.000	77.927	0.200	0.200	-0.073	0.000
RN	0.000	0.246	0.300	0.000	0.246	0.000

	MM	DIST1 - RIGHT_FLNG_PLN1 TO LEFT_FLNG_PLN2 (YAXIS)

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	853.600	855.683	0.800	0.800	2.083	1.283

	MM	DIST2 - LEFT_FLNG_PLN2 TO SS_LEFT_FLNG_PLN1 (YAXIS)

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	1.000	1.123	0.100	0.100	0.123	0.023

↔	MM	DIST3 - RIGHT_FLNG_PLN1 TO SS_RIGHT_FLNG_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	1.000	1.063	0.100	0.100	0.063	0.000

FCFPERP1	MM	⊥ 0.8 AB					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
RIGHT_FLNG...	0.000	0.281	0.800	0.000	0.281	0.000	0.000

FCFPERP2	MM	⊥ 0.8 AB					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
LEFT_FLNG_...	0.000	0.185	0.800	0.000	0.185	0.000	0.000

⌖	MM	LOC4 - RIGHT_FLNG_OD_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.044	0.100	0.100	-0.044	0.000
Z	0.000	-0.181	0.100	0.100	-0.181	0.081
D	140.000	139.906	0.200	0.200	-0.094	0.000
RN	0.000	0.024	0.100	0.000	0.024	0.000

⌖	MM	LOC5 - LEFT_FLNG_OD_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.035	0.100	0.100	0.035	0.000
Z	0.000	-0.059	0.100	0.100	-0.059	0.000
D	140.000	139.908	0.200	0.200	-0.092	0.000
RN	0.000	0.037	0.100	0.000	0.037	0.000

THE FOLLOWING LOCATIONS 6 AND 7 ARE:
LOCATION OF RIGHT AND LEFT FLANGE HOLE LOCATED AT NOMINAL POLAR ANGLE OF 90 DEGREES

⌖	MM	LOC6 - RIGHT_FLNG_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
PR	60.000	59.780	0.100	0.100	-0.220	0.120
PA	90.000	90.000	1.000	1.000	0.000	0.000
D	8.800	8.634	0.200	0.200	-0.166	0.000
RN	0.000	0.022	0.100	0.000	0.022	0.000

⌖	MM	LOC7 - LEFT_FLNG_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
PR	60.000	59.974	0.100	0.100	-0.026	0.000
PA	90.000	91.496	1.000	1.000	1.496	0.496
D	8.800	8.488	0.200	0.200	-0.312	0.112
RN	0.000	0.028	0.100	0.000	0.028	0.000

FCFLOC2 Size	MM	12XØ8.8 0.5/0.5				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
RIGHT_FLNG_CIR1	8.800	8.634	0.500	0.500	-0.166	0.000
RIGHT_FLNG_CIR2	8.800	8.641	0.500	0.500	-0.159	0.000
RIGHT_FLNG_CIR3	8.800	8.642	0.500	0.500	-0.158	0.000
RIGHT_FLNG_CIR4	8.800	8.630	0.500	0.500	-0.170	0.000
RIGHT_FLNG_CIR5	8.800	8.634	0.500	0.500	-0.166	0.000
RIGHT_FLNG_CIR6	8.800	8.625	0.500	0.500	-0.175	0.000
RIGHT_FLNG_CIR7	8.800	8.633	0.500	0.500	-0.167	0.000
RIGHT_FLNG_CIR8	8.800	8.621	0.500	0.500	-0.179	0.000
RIGHT_FLNG_CIR9	8.800	8.639	0.500	0.500	-0.161	0.000
RIGHT_FLNG_CIR10	8.800	8.602	0.500	0.500	-0.198	0.000
RIGHT_FLNG_CIR11	8.800	8.596	0.500	0.500	-0.204	0.000
RIGHT_FLNG_CIR12	8.800	8.605	0.500	0.500	-0.195	0.000

FCFLOC2 Position	MM	⌖ Ø0.3 A_				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
RIGHT_FLNG_CIR1	0.000	0.085	0.300		0.085	0.000
RIGHT_FLNG_CIR2	0.000	0.110	0.300		0.110	0.000
RIGHT_FLNG_CIR3	0.000	0.133	0.300		0.133	0.000
RIGHT_FLNG_CIR4	0.000	0.154	0.300		0.154	0.000
RIGHT_FLNG_CIR5	0.000	0.139	0.300		0.139	0.000
RIGHT_FLNG_CIR6	0.000	0.108	0.300		0.108	0.000
RIGHT_FLNG_CIR7	0.000	0.130	0.300		0.130	0.000
RIGHT_FLNG_CIR8	0.000	0.042	0.300		0.042	0.000
RIGHT_FLNG_CIR9	0.000	0.036	0.300		0.036	0.000
RIGHT_FLNG_CIR10	0.000	0.005	0.300		0.005	0.000
RIGHT_FLNG_CIR11	0.000	0.061	0.300		0.061	0.000
RIGHT_FLNG_CIR12	0.000	0.055	0.300		0.055	0.000

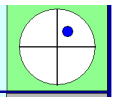
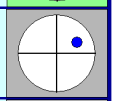
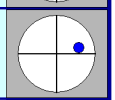
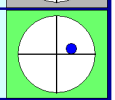
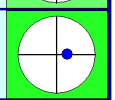
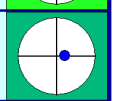
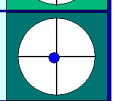
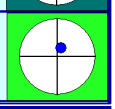
FCFLOC2 Datum Shift						
Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed

FCFLOC2 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON				
Feature	AX	NOMINAL	MEAS	DEV
RIGHT_FLNG_CIR1	PR	60.000	59.957	-0.043
	PA	90.000	90.000	0.000

RIGHT_FLNG_CIR2	PR	60.000	59.947	-0.053
	PA	60.000	59.986	-0.014
RIGHT_FLNG_CIR3	PR	60.000	59.952	-0.048
	PA	30.000	29.956	-0.044
RIGHT_FLNG_CIR4	PR	60.000	59.978	-0.022
	PA	0.000	-0.070	-0.070
RIGHT_FLNG_CIR5	PR	60.000	60.006	0.006
	PA	-30.000	-30.066	-0.066
RIGHT_FLNG_CIR6	PR	60.000	60.026	0.026
	PA	-60.000	-60.045	-0.045
RIGHT_FLNG_CIR7	PR	60.000	60.047	0.047
	PA	-90.000	-90.042	-0.042
RIGHT_FLNG_CIR8	PR	60.000	60.021	0.021
	PA	-120.000	-120.003	-0.003
RIGHT_FLNG_CIR9	PR	60.000	60.018	0.018
	PA	-150.000	-149.997	0.003
RIGHT_FLNG_CIR10	PR	60.000	60.002	0.002
	PA	-180.000	-179.999	0.001
RIGHT_FLNG_CIR11	PR	60.000	59.992	-0.008
	PA	150.000	150.028	0.028
RIGHT_FLNG_CIR12	PR	60.000	59.974	-0.026
	PA	120.000	120.008	0.008

FCFLOC3 Size	MM	12XØ8.8 0.5/0.5				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLNG_CIR1	8.800	8.488	0.500	0.500	-0.312	0.000
LEFT_FLNG_CIR2	8.800	8.491	0.500	0.500	-0.309	0.000
LEFT_FLNG_CIR3	8.800	8.488	0.500	0.500	-0.312	0.000
LEFT_FLNG_CIR4	8.800	8.496	0.500	0.500	-0.304	0.000
LEFT_FLNG_CIR5	8.800	8.496	0.500	0.500	-0.304	0.000
LEFT_FLNG_CIR6	8.800	8.500	0.500	0.500	-0.300	0.000
LEFT_FLNG_CIR7	8.800	8.494	0.500	0.500	-0.306	0.000
LEFT_FLNG_CIR8	8.800	8.484	0.500	0.500	-0.316	0.000
LEFT_FLNG_CIR9	8.800	8.481	0.500	0.500	-0.319	0.000
LEFT_FLNG_CIR10	8.800	8.475	0.500	0.500	-0.325	0.000
LEFT_FLNG_CIR11	8.800	8.481	0.500	0.500	-0.319	0.000
LEFT_FLNG_CIR12	8.800	8.482	0.500	0.500	-0.318	0.000

FCFLOC3 Position	MM	⌖ Ø0.3 B_				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLNG_CIR1	0.000	0.066	0.300		0.066	0.000
LEFT_FLNG_CIR2	0.000	0.116	0.300		0.116	0.000
LEFT_FLNG_CIR3	0.000	0.114	0.300		0.114	0.000
LEFT_FLNG_CIR4	0.000	0.150	0.300		0.150	0.000

LEFT_FLNG_CIR5	0.000	0.147	0.147	0.000	
LEFT_FLNG_CIR6	0.000	0.180	0.180	0.000	
LEFT_FLNG_CIR7	0.000	0.174	0.174	0.000	
LEFT_FLNG_CIR8	0.000	0.122	0.122	0.000	
LEFT_FLNG_CIR9	0.000	0.082	0.082	0.000	
LEFT_FLNG_CIR10	0.000	0.063	0.063	0.000	
LEFT_FLNG_CIR11	0.000	0.018	0.018	0.000	
LEFT_FLNG_CIR12	0.000	0.070	0.070	0.000	

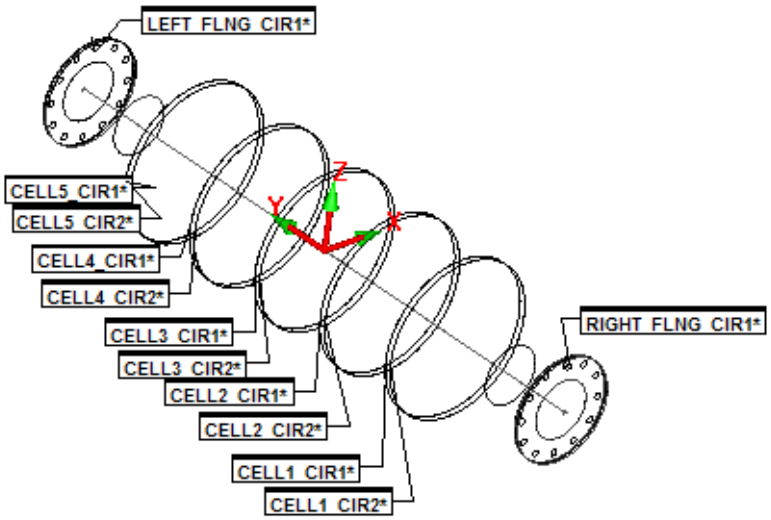
FCFLOC3 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed

FCFLOC3 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON

Feature	AX	NOMINAL	MEAS	DEV
LEFT_FLNG_CIR1	PR	60.000	60.033	0.033
	PA	90.000	90.000	0.000
LEFT_FLNG_CIR2	PR	60.000	60.058	0.058
	PA	60.000	59.998	-0.002
LEFT_FLNG_CIR3	PR	60.000	60.040	0.040
	PA	30.000	30.039	0.039
LEFT_FLNG_CIR4	PR	60.000	60.029	0.029
	PA	0.000	0.066	0.066
LEFT_FLNG_CIR5	PR	60.000	60.005	0.005
	PA	-30.000	-29.930	0.070
LEFT_FLNG_CIR6	PR	60.000	60.002	0.002
	PA	-60.000	-59.914	0.086
LEFT_FLNG_CIR7	PR	60.000	59.977	-0.023
	PA	-90.000	-89.920	0.080
LEFT_FLNG_CIR8	PR	60.000	59.954	-0.046
	PA	-120.000	-119.962	0.038
LEFT_FLNG_CIR9	PR	60.000	59.963	-0.037
	PA	-150.000	-149.983	0.017
LEFT_FLNG_CIR10	PR	60.000	59.968	-0.032
	PA	-180.000	-180.003	-0.003
LEFT_FLNG_CIR11	PR	60.000	60.005	0.005
	PA	150.000	150.007	0.007
LEFT_FLNG_CIR12	PR	60.000	60.020	0.020
	PA	120.000	119.973	-0.027

FCFPARL1	MM	// 0.8 RF		
Feature	MEAS	DEV		
LEFT_FLNG_PLN2	0.167	0.167		

1	MM	FLANGE_RIGHT SURFACE FINISH		
AX	NOMINAL	MEAS	DEV	
M	0.400	0.340	-0.060	

1	MM	FLANGE_LEFT SURFACE FINISH		
AX	NOMINAL	MEAS	DEV	
M	0.400	0.480	0.080