| pc-dmis | PART NAME : 481343_A | | August 19, 2014 | 07:24 |
|---|---|---|---|---|
| | REV NUMBER : | SER NUMBER : | STATS COUNT : | 1 |

SRF - 650MHZ
CAVITY, BETA = 0.9
SINGLE CELL ASSEMBLY
SERIAL NUMBER: B9AS-PAV-101

RF#97035
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 | 0.007 | 0.400 | 0.000 | 0.007 | 0.000 |

| ⌖ | MM | LOC2 - LEFT_FLANGE_PLN | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| Y | 567.500 | 565.430 | 0.500 | 0.500 | -2.070 | 1.570 |
| FL | 0.000 | 0.006 | 0.400 | 0.000 | 0.006 | 0.000 |

| ⌖ | MM | LOC3 - RIGHT_FLANGE_SEAL_SURF | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| Y | 1.000 | 0.971 | 0.500 | 0.500 | -0.029 | 0.000 |
| FL | 0.000 | 0.014 | 0.250 | 0.000 | 0.014 | 0.000 |

| FCFPERP1 | MM | ⊥ 0.4 B | | | | |
|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| DATUM_C | 0.000 | 0.055 | 0.400 | 0.000 | 0.055 | 0.000 |

| FCFPERP2 | MM | ⊥ 0.4 A | | | | |
|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| LEFT_FLANGE_PLN | 0.000 | 0.044 | 0.400 | 0.000 | 0.044 | 0.000 |

| FCFPARL1 | MM | // 0.5 C | | | | |
|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| LEFT_FLANGE_PLN | 0.000 | 0.536 | 0.500 | 0.000 | 0.536 | 0.036 |

| ⌖ | MM | LOC4 - DATUM_C | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |

| AX | I | J | K |
|---|---|---|---|
| V | -0.002 | -1.000 | 0.002 |

| ⌖ | MM | LOC5 - LEFT_FLANGE_PLN | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |

| AX | I | J | K |
|---|---|---|---|
| V | -0.001 | 1.000 | 0.000 |

| ⌖ | MM | LOC6 - RIGHT_FLANGE_SEAL_SURF | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |

| AX | I | J | K |
|---|---|---|---|
| V | -0.001 | -1.000 | 0.001 |

| | MM | LOC7 - LEFT_FLANGE_SEAL_SURF |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|

| AX | I | J | K |
|---|---|---|---|
| V | -0.001 | 1.000 | 0.000 |

| | MM | LOC8 - RIGHT_FLANGE_BEAM_TUBE_PLN |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|

| AX | I | J | K |
|---|---|---|---|
| V | -0.002 | -1.000 | 0.002 |

| | MM | LOC9 - LEFT_FLANGE_BEAM_TUBE_PLN |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|

| AX | I | J | K |
|---|---|---|---|
| V | -0.001 | 1.000 | 0.000 |

| | MM | DIST1 - LEFT_FLANGE_PLN TO LEFT_FLANGE_SEAL_SURF |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|
| M | 1.000 | 1.012 | 0.200 | 0.200 | 0.012 | 0.000 |

| | MM | FLAT1 - LEFT_FLANGE_SEAL_SURF |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|
| M | 0.000 | 0.020 | 0.250 | 0.000 | 0.020 | 0.000 |

| | MM | LOC10 - DATUM_B |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|
| D | 100.000 | 99.996 | 0.200 | 0.200 | -0.004 | 0.000 |
| RN | 0.000 | 0.458 | 0.050 | 0.000 | 0.458 | 0.408 |

| | MM | LOC11 - DATUM_A_CYL1 |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|
| D | 100.000 | 100.043 | 0.200 | 0.200 | 0.043 | 0.000 |
| RN | 0.000 | 0.262 | 0.050 | 0.000 | 0.262 | 0.212 |

| | MM | LOC12 - DAT_B_DAT_A_CYL1 |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
|---|---|---|---|---|---|---|
| D | 100.000 | 100.031 | 0.050 | 0.050 | 0.031 | 0.000 |
| RN | 0.000 | 0.779 | 0.050 | 0.000 | 0.779 | 0.729 |

| | MM | LOC13 - DATUM_B_END1 |
|---|---|---|

| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS |
|---|---|---|---|---|---|---|---|
| X | 0.000 | -0.157 | | | -0.157 | | |
| Y | 0.000 | 0.000 | | | 0.000 | | |
| Z | 0.000 | 0.141 | | | 0.141 | | |
| TP | RFS | 0.422 | 0.500 | | 0.422 | 0.000 | 0.000 |

| | MM | LOC14 - DATUM_B_END2 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | 0.130 | | | 0.130 | |
| Y | 170.000 | 170.000 | | | 0.000 | |
| Z | 0.000 | -0.177 | | | -0.177 | |
| TP | RFS | 0.439 | 0.500 | | 0.439 | 0.000 |

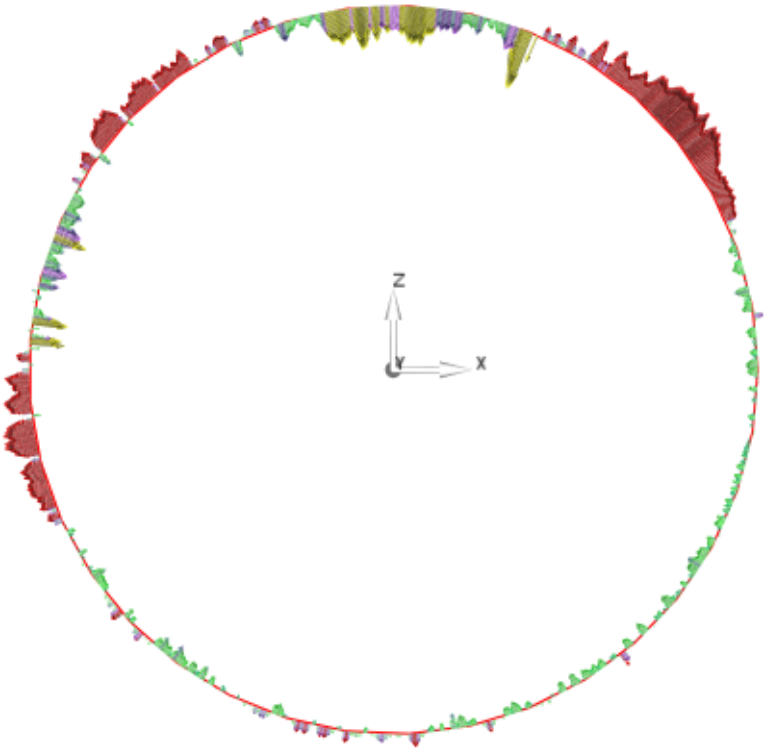
| | MM | LOC17 - DATUM_A_END1 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | -0.082 | | | -0.082 | |
| Y | 567.500 | 567.500 | | | 0.000 | |
| Z | 0.000 | 0.020 | | | 0.020 | |
| TP | RFS | 0.170 | 0.500 | | 0.170 | 0.000 |

| | MM | LOC18 - DATUM_A_END2 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | 0.085 | | | 0.085 | |
| Y | 397.500 | 397.500 | | | 0.000 | |
| Z | 0.000 | -0.009 | | | -0.009 | |
| TP | RFS | 0.172 | 0.500 | | 0.172 | 0.000 |

| | MM | LOC19 - FLANGE_RIGHT_OD | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | -0.143 | 0.050 | 0.050 | -0.143 | 0.093 |
| Z | 0.000 | 0.115 | 0.050 | 0.050 | 0.115 | 0.065 |
| D | 170.000 | 169.939 | 0.200 | 0.200 | -0.061 | 0.000 |
| RN | 0.000 | 0.020 | 0.100 | 0.000 | 0.020 | 0.000 |

| | MM | LOC20 - FLANGE_LEFT_OD | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | -0.107 | 0.050 | 0.050 | -0.107 | 0.057 |
| Z | 0.000 | -0.057 | 0.050 | 0.050 | -0.057 | 0.007 |
| D | 170.000 | 169.984 | 0.200 | 0.200 | -0.016 | 0.000 |
| RN | 0.000 | 0.007 | 0.100 | 0.000 | 0.007 | 0.000 |

| ⌖ | MM | LOC21 - MID_WELD_CIR1 | | | | |
|---|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| X | 0.000 | 0.094 | 0.500 | 0.500 | 0.094 | 0.000 |
| Y | 283.750 | 282.722 | 0.500 | 0.500 | -1.028 | 0.528 |
| Z | 0.000 | -0.048 | 0.500 | 0.500 | -0.048 | 0.000 |
| D | 404.550 | 406.378 | 0.050 | 0.000 | 1.828 | 1.778 |
| RN | 0.000 | 0.601 | 0.200 | 0.000 | 0.601 | 0.401 |




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_RIGHT_TOP_CIR1 | 8.500 | 8.502 | 0.130 | 0.130 | 0.002 | 0.000 | 0.132 | |
| FLANGE_RIGHT_CIR2 | 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.126 | |
| FLANGE_RIGHT_CIR3 | 8.500 | 8.506 | 0.130 | 0.130 | 0.006 | 0.000 | 0.136 | |
| FLANGE_RIGHT_CIR4 | 8.500 | 8.498 | 0.130 | 0.130 | -0.002 | 0.000 | 0.128 | |
| FLANGE_RIGHT_CIR5 | 8.500 | 8.503 | 0.130 | 0.130 | 0.003 | 0.000 | 0.133 | |
| FLANGE_RIGHT_CIR6 | 8.500 | 8.503 | 0.130 | 0.130 | 0.003 | 0.000 | 0.133 | |
| FLANGE_RIGHT_CIR7 | 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.126 | |
| FLANGE_RIGHT_CIR8 | 8.500 | 8.504 | 0.130 | 0.130 | 0.004 | 0.000 | 0.134 | |
| FLANGE_RIGHT_CIR9 | 8.500 | 8.498 | 0.130 | 0.130 | -0.002 | 0.000 | 0.128 | |
| FLANGE_RIGHT_CIR10 | 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.126 | |
| FLANGE_RIGHT_CIR11 | 8.500 | 8.494 | 0.130 | 0.130 | -0.006 | 0.000 | 0.124 | |
| FLANGE_RIGHT_CIR12 | 8.500 | 8.493 | 0.130 | 0.130 | -0.007 | 0.000 | 0.123 | |
| FLANGE_RIGHT_CIR13 | 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.126 | |
| FLANGE_RIGHT_CIR14 | 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.126 | |
| FLANGE_RIGHT_CIR15 | 8.500 | 8.494 | 0.130 | 0.130 | -0.006 | 0.000 | 0.124 | |
| FLANGE_RIGHT_CIR16 | 8.500 | 8.495 | 0.130 | 0.130 | -0.005 | 0.000 | 0.125 | |
| FLANGE_RIGHT_CIR17 | 8.500 | 8.496 | 0.130 | 0.130 | -0.004 | 0.000 | 0.126 | |
| FLANGE_RIGHT_CIR18 | 8.500 | 8.486 | 0.130 | 0.130 | -0.014 | 0.000 | 0.116 | |

| FCFLOC1 Position | MM | ⌖ Ø0.2 Ⓜ RF RO | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS |
| FLANGE_RIGH... | 0.000 | 0.089 | 0.200 | | 0.089 | 0.000 | 0.132 |
| FLANGE_RIGH... | 0.000 | 0.138 | 0.200 | | 0.138 | 0.000 | 0.126 |
| FLANGE_RIGH... | 0.000 | 0.114 | 0.200 | | 0.114 | 0.000 | 0.136 |
| FLANGE_RIGH... | 0.000 | 0.041 | 0.200 | | 0.041 | 0.000 | 0.128 |

| | | | |
|---|---|---|---|
| FLANGE_RIGHT_CIR5 | 0.114 | 0.133 | |
| FLANGE_RIGHT_CIR6 | 0.081 | 0.133 | |
| FLANGE_RIGHT_CIR7 | 0.090 | 0.126 | |
| FLANGE_RIGHT_CIR8 | 0.146 | 0.134 | |
| FLANGE_RIGHT_CIR9 | 0.084 | 0.128 | |
| FLANGE_RIGHT_CIR10 | 0.099 | 0.126 | |
| FLANGE_RIGHT_CIR11 | 0.074 | 0.124 | |
| FLANGE_RIGHT_CIR12 | 0.045 | 0.123 | |
| FLANGE_RIGHT_CIR13 | 0.023 | 0.126 | |
| FLANGE_RIGHT_CIR14 | 0.123 | 0.126 | |
| FLANGE_RIGHT_CIR15 | 0.036 | 0.124 | |
| FLANGE_RIGHT_CIR16 | 0.065 | 0.125 | |
| FLANGE_RIGHT_CIR17 | 0.085 | 0.126 | |
| FLANGE_RIGHT_CIR18 | 0.081 | 0.116 | |

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 | 359.881 | 0.000 |

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

| Feature | AX | NOMINAL | MEAS | DEV |
|---|---|---|---|---|
| FLANGE_RIGHT_TOP_CIR1 | PR | 75.800 | 75.756 | -0.044 |
| | PA | 90.000 | 90.003 | 0.003 |
| FLANGE_RIGHT_CIR2 | PR | 75.800 | 75.733 | -0.067 |
| | PA | 110.000 | 109.988 | -0.012 |
| FLANGE_RIGHT_CIR3 | PR | 75.800 | 75.762 | -0.038 |
| | PA | 130.000 | 130.033 | 0.033 |
| FLANGE_RIGHT_CIR4 | PR | 75.800 | 75.786 | -0.014 |
| | PA | 150.000 | 150.012 | 0.012 |
| FLANGE_RIGHT_CIR5 | PR | 75.800 | 75.744 | -0.056 |

| | | | | |
|---|---|---|---|---|
| | PA | 170.000 | 170.009 | 0.009 |
| FLANGE_RIGHT_CIR6 | PR | 75.800 | 75.765 | -0.035 |
| | PA | 190.000 | 190.015 | 0.015 |
| FLANGE_RIGHT_CIR7 | PR | 75.800 | 75.771 | -0.029 |
| | PA | 210.000 | 210.026 | 0.026 |
| FLANGE_RIGHT_CIR8 | PR | 75.800 | 75.746 | -0.054 |
| | PA | 230.000 | 230.037 | 0.037 |
| FLANGE_RIGHT_CIR9 | PR | 75.800 | 75.794 | -0.006 |
| | PA | 250.000 | 250.031 | 0.032 |
| FLANGE_RIGHT_CIR10 | PR | 75.800 | 75.782 | -0.018 |
| | PA | 270.000 | 270.035 | 0.035 |
| FLANGE_RIGHT_CIR11 | PR | 75.800 | 75.782 | -0.018 |
| | PA | 290.000 | 290.024 | 0.024 |
| FLANGE_RIGHT_CIR12 | PR | 75.800 | 75.805 | 0.005 |
| | PA | 310.000 | 310.017 | 0.017 |
| FLANGE_RIGHT_CIR13 | PR | 75.800 | 75.811 | 0.011 |
| | PA | 330.000 | 330.000 | 0.000 |
| FLANGE_RIGHT_CIR14 | PR | 75.800 | 75.743 | -0.057 |
| | PA | 350.000 | 350.018 | 0.018 |
| FLANGE_RIGHT_CIR15 | PR | 75.800 | 75.785 | -0.015 |
| | PA | 10.000 | 10.007 | 0.007 |
| FLANGE_RIGHT_CIR16 | PR | 75.800 | 75.769 | -0.031 |
| | PA | 30.000 | 29.992 | -0.008 |
| FLANGE_RIGHT_CIR17 | PR | 75.800 | 75.764 | -0.036 |
| | PA | 50.000 | 49.983 | -0.017 |
| FLANGE_RIGHT_CIR18 | PR | 75.800 | 75.765 | -0.035 |
| | PA | 70.000 | 69.984 | -0.015 |

| FCFLOC2 Size | MM | 18XØ8.5 0.13/0.13 | | | | | |
|---|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL | BONUS |
| FLANGE_LEFT_CIR1 | 8.500 | 8.597 | 0.130 | 0.130 | 0.097 | 0.000 | 0.227 |
| FLANGE_LEFT_CIR2 | 8.500 | 8.597 | 0.130 | 0.130 | 0.097 | 0.000 | 0.227 |
| FLANGE_LEFT_CIR3 | 8.500 | 8.590 | 0.130 | 0.130 | 0.090 | 0.000 | 0.220 |
| FLANGE_LEFT_CIR4 | 8.500 | 8.578 | 0.130 | 0.130 | 0.078 | 0.000 | 0.208 |
| FLANGE_LEFT_CIR5 | 8.500 | 8.571 | 0.130 | 0.130 | 0.071 | 0.000 | 0.201 |
| FLANGE_LEFT_CIR6 | 8.500 | 8.640 | 0.130 | 0.130 | 0.140 | 0.010 | 0.260 |
| FLANGE_LEFT_CIR7 | 8.500 | 8.577 | 0.130 | 0.130 | 0.077 | 0.000 | 0.207 |
| FLANGE_LEFT_CIR8 | 8.500 | 8.737 | 0.130 | 0.130 | 0.237 | 0.107 | 0.260 |
| FLANGE_LEFT_CIR9 | 8.500 | 8.600 | 0.130 | 0.130 | 0.100 | 0.000 | 0.230 |
| FLANGE_LEFT_CIR10 | 8.500 | 8.579 | 0.130 | 0.130 | 0.079 | 0.000 | 0.209 |
| FLANGE_LEFT_CIR11 | 8.500 | 8.585 | 0.130 | 0.130 | 0.085 | 0.000 | 0.215 |
| FLANGE_LEFT_CIR12 | 8.500 | 8.596 | 0.130 | 0.130 | 0.096 | 0.000 | 0.226 |
| FLANGE_LEFT_CIR13 | 8.500 | 8.620 | 0.130 | 0.130 | 0.120 | 0.000 | 0.250 |
| FLANGE_LEFT_CIR14 | 8.500 | 8.582 | 0.130 | 0.130 | 0.082 | 0.000 | 0.212 |

| | | | | |
|---|---|---|---|---|
| FLANGE_LEFT_CIR15 | 8.587 | 0.000 | 0.000 | 0.217 |
| FLANGE_LEFT_CIR16 | 8.582 | 0.000 | 0.000 | 0.212 |
| FLANGE_LEFT_CIR17 | 8.585 | 0.000 | 0.000 | 0.215 |
| FLANGE_LEFT_CIR18 | 8.618 | 0.000 | 0.000 | 0.248 |

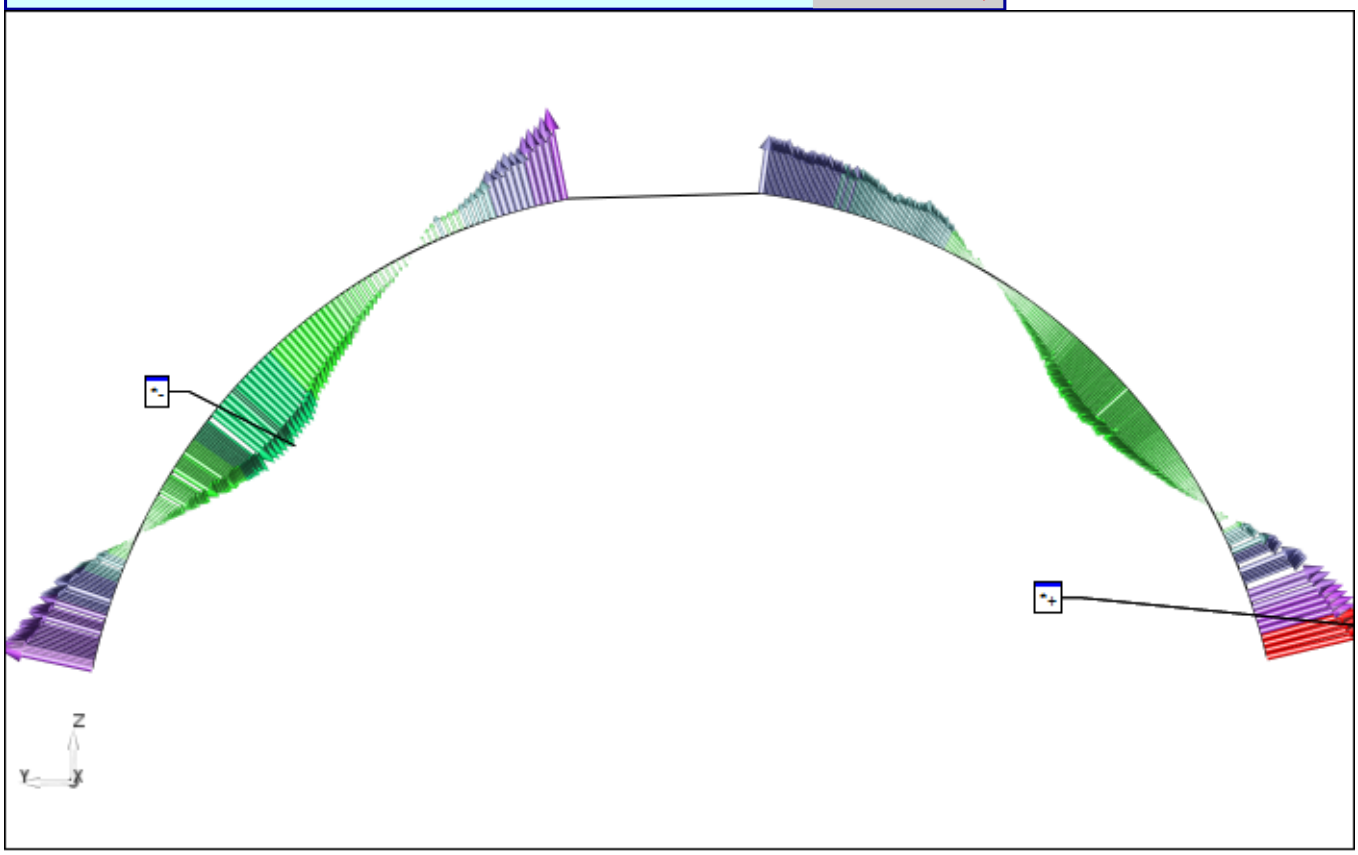
| FCFLOC2 Position | MM | ⌖ Ø0.2 Ⓜ LF LO |
|---|---|---|

| Feature | MEAS | BONUS |
|---|---|---|
| FLANGE_LEFT_CIR1 | 0.498 | 0.227 |
| FLANGE_LEFT_CIR2 | 0.376 | 0.227 |
| FLANGE_LEFT_CIR3 | 0.406 | 0.220 |
| FLANGE_LEFT_CIR4 | 0.096 | 0.208 |
| FLANGE_LEFT_CIR5 | 0.113 | 0.201 |
| FLANGE_LEFT_CIR6 | 0.935 | 0.260 |
| FLANGE_LEFT_CIR7 | 0.391 | 0.207 |
| FLANGE_LEFT_CIR8 | 0.132 | 0.260 |
| FLANGE_LEFT_CIR9 | 0.210 | 0.230 |
| FLANGE_LEFT_CIR10 | 0.113 | 0.209 |
| FLANGE_LEFT_CIR11 | 0.210 | 0.215 |
| FLANGE_LEFT_CIR12 | 0.419 | 0.226 |
| FLANGE_LEFT_CIR13 | 0.134 | 0.250 |
| FLANGE_LEFT_CIR14 | 0.254 | 0.212 |
| FLANGE_LEFT_CIR15 | 0.103 | 0.217 |
| FLANGE_LEFT_CIR16 | 0.256 | 0.212 |
| FLANGE_LEFT_CIR17 | 0.341 | 0.215 |
| FLANGE_LEFT_CIR18 | 0.621 | 0.248 |

| 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 | 359.731 | 0.000 |

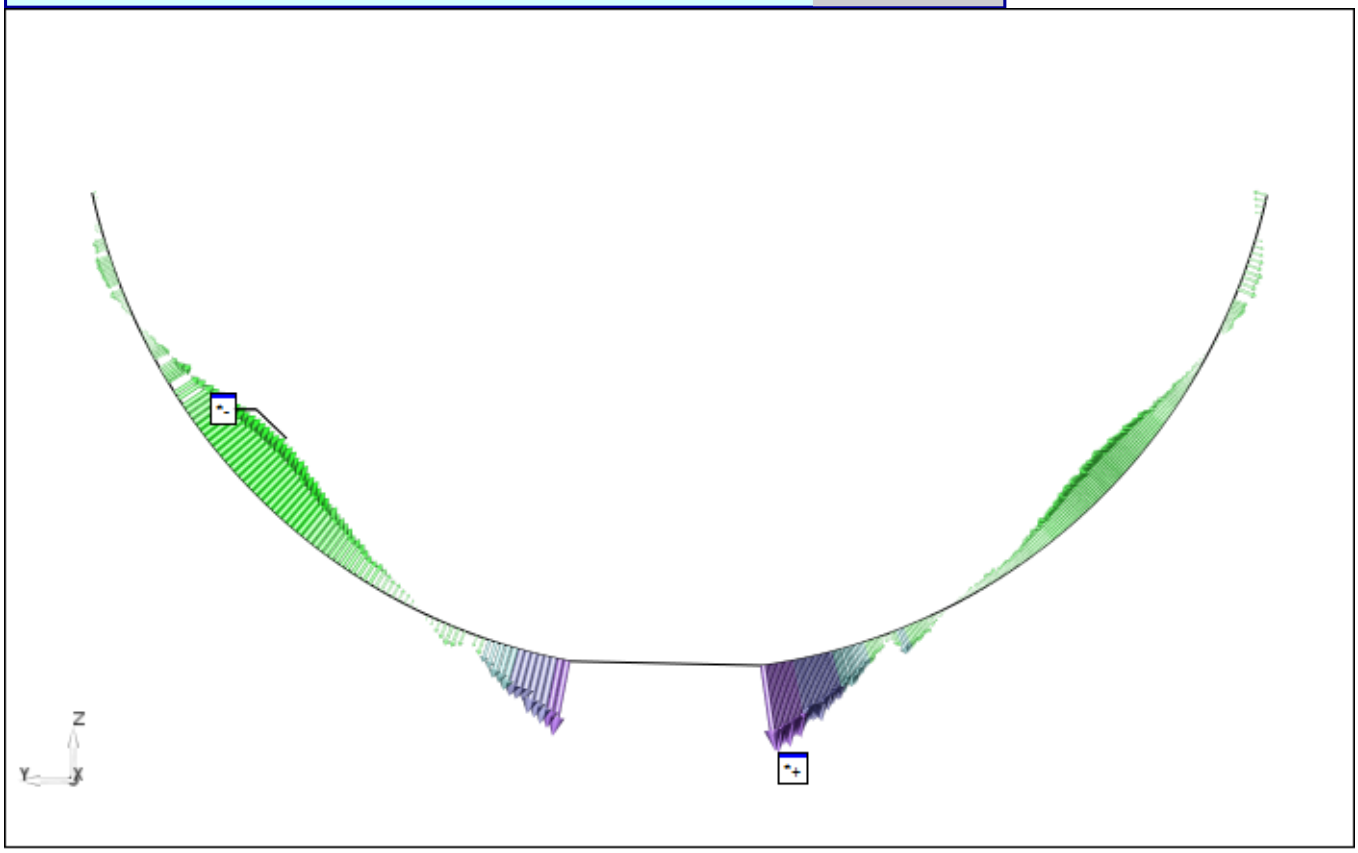
| FCFLOC2 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON | | | | |
|---|---|---|---|---|
| Feature | AX | NOMINAL | MEAS | DEV |
| FLANGE_LEFT_CIR1 | PR | 75.800 | 75.925 | 0.125 |
| | PA | 90.000 | 89.837 | -0.163 |
| FLANGE_LEFT_CIR2 | PR | 75.800 | 75.636 | -0.164 |
| | PA | 110.000 | 109.930 | -0.070 |
| FLANGE_LEFT_CIR3 | PR | 75.800 | 75.654 | -0.146 |
| | PA | 130.000 | 129.893 | -0.107 |
| FLANGE_LEFT_CIR4 | PR | 75.800 | 75.800 | 0.000 |
| | PA | 150.000 | 149.964 | -0.036 |
| FLANGE_LEFT_CIR5 | PR | 75.800 | 75.748 | -0.052 |
| | PA | 170.000 | 169.983 | -0.017 |
| FLANGE_LEFT_CIR6 | PR | 75.800 | 75.333 | -0.467 |
| | PA | 190.000 | 190.000 | 0.000 |
| FLANGE_LEFT_CIR7 | PR | 75.800 | 75.636 | -0.164 |
| | PA | 210.000 | 209.920 | -0.080 |
| FLANGE_LEFT_CIR8 | PR | 75.800 | 75.836 | 0.036 |
| | PA | 230.000 | 230.042 | 0.042 |
| FLANGE_LEFT_CIR9 | PR | 75.800 | 75.895 | 0.095 |
| | PA | 250.000 | 250.034 | 0.034 |
| FLANGE_LEFT_CIR10 | PR | 75.800 | 75.785 | -0.015 |
| | PA | 270.000 | 269.959 | -0.041 |
| FLANGE_LEFT_CIR11 | PR | 75.800 | 75.724 | -0.076 |
| | PA | 290.000 | 289.945 | -0.055 |
| FLANGE_LEFT_CIR12 | PR | 75.800 | 75.614 | -0.186 |
| | PA | 310.000 | 309.927 | -0.073 |
| FLANGE_LEFT_CIR13 | PR | 75.800 | 75.782 | -0.018 |
| | PA | 330.000 | 330.049 | 0.049 |
| FLANGE_LEFT_CIR14 | PR | 75.800 | 75.736 | -0.064 |
| | PA | 350.000 | 350.083 | 0.083 |
| FLANGE_LEFT_CIR15 | PR | 75.800 | 75.841 | 0.041 |
| | PA | 10.000 | 10.024 | 0.024 |
| FLANGE_LEFT_CIR16 | PR | 75.800 | 75.673 | -0.127 |
| | PA | 30.000 | 29.991 | -0.010 |
| FLANGE_LEFT_CIR17 | PR | 75.800 | 75.698 | -0.102 |
| | PA | 50.000 | 49.897 | -0.103 |
| FLANGE_LEFT_CIR18 | PR | 75.800 | 75.525 | -0.275 |
| | PA | 70.000 | 69.892 | -0.108 |

| FCFPROF1 | MM | .3 | ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS | | | |
|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| Set | 0.000 | 0.295 | 0.300 | 0.000 | 0.295 | 0.026 |



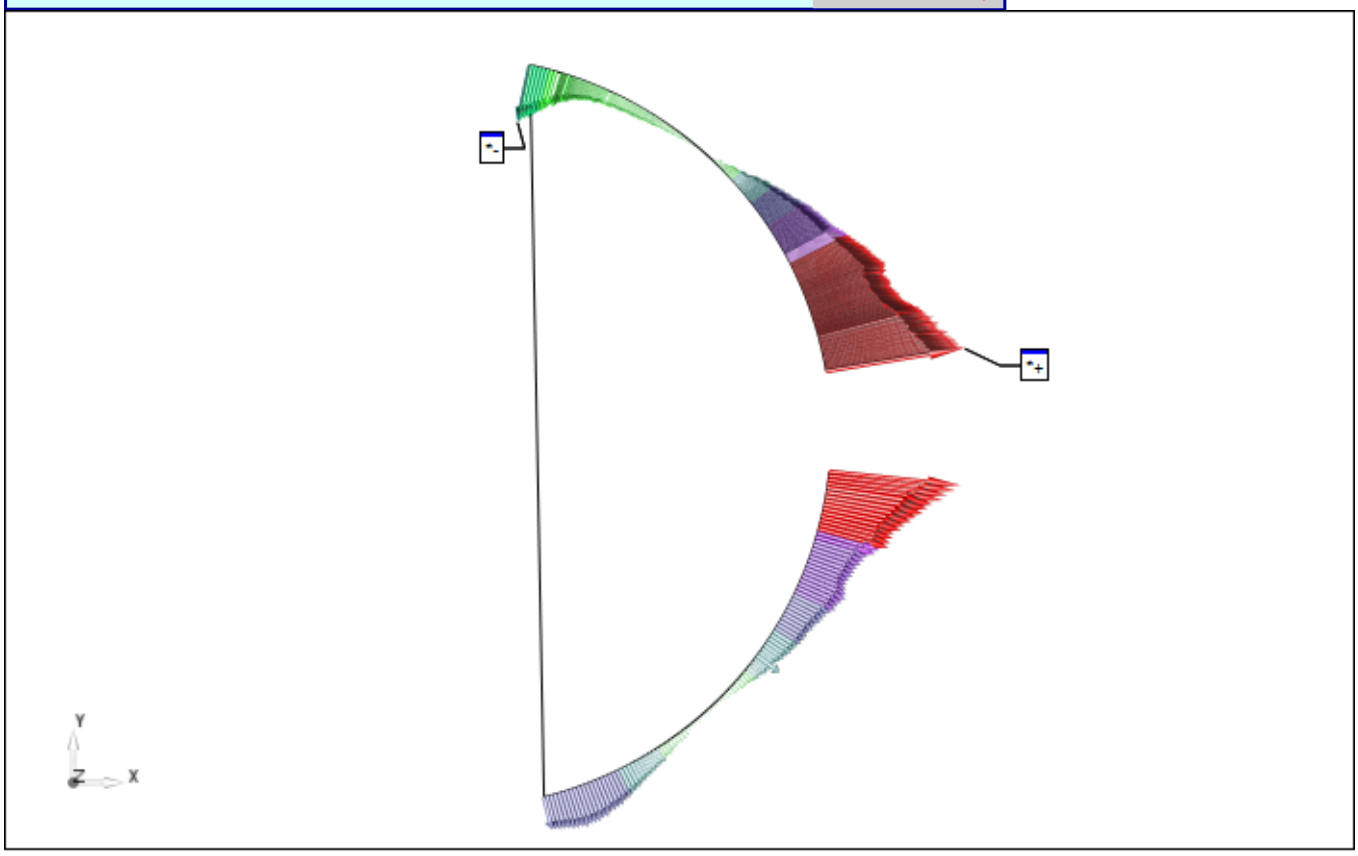

PROFILE OF RIGHT AND LEFT HALF CELLS 12 'O' CLOCK- X100

| FCFPROF2 | MM | .3 | ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS | | | |
|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| Set | 0.000 | 0.215 | 0.300 | 0.000 | 0.215 | 0.000 |



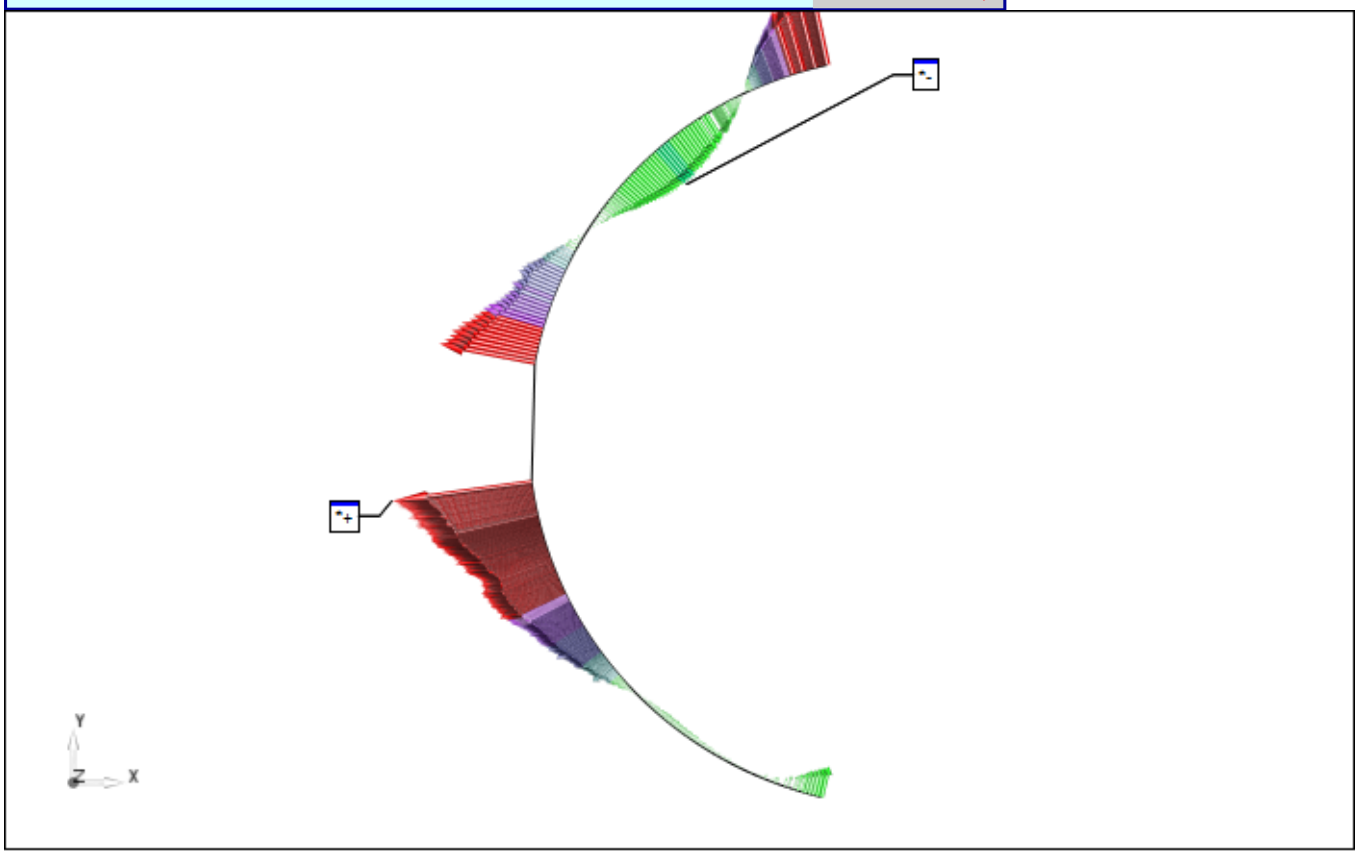

PROFILE OF RIGHT AND LEFT HALF CELLS 6 'O' CLOCK- X100

| FCFPROF3 | MM | .3 | ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS | | | |
|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| Set | 0.000 | 0.457 | 0.300 | 0.000 | 0.457 | 0.172 |

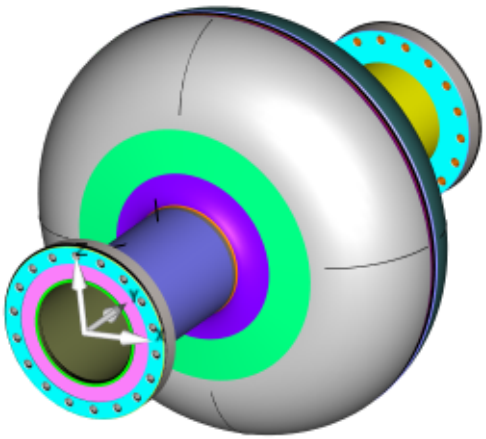



PROFILE OF RIGHT AND LEFT HALF CELLS 3 'O' CLOCK- X100

| FCFPROF4 | MM | .3 | ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS | | | |
|---|---|---|---|---|---|---|
| Feature | NOMINAL | MEAS | +TOL | -TOL | DEV | OUTTOL |
| Set | 0.000 | 0.428 | 0.300 | 0.000 | 0.428 | 0.175 |




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 | 0.200 | -0.200 | 0.000 | |

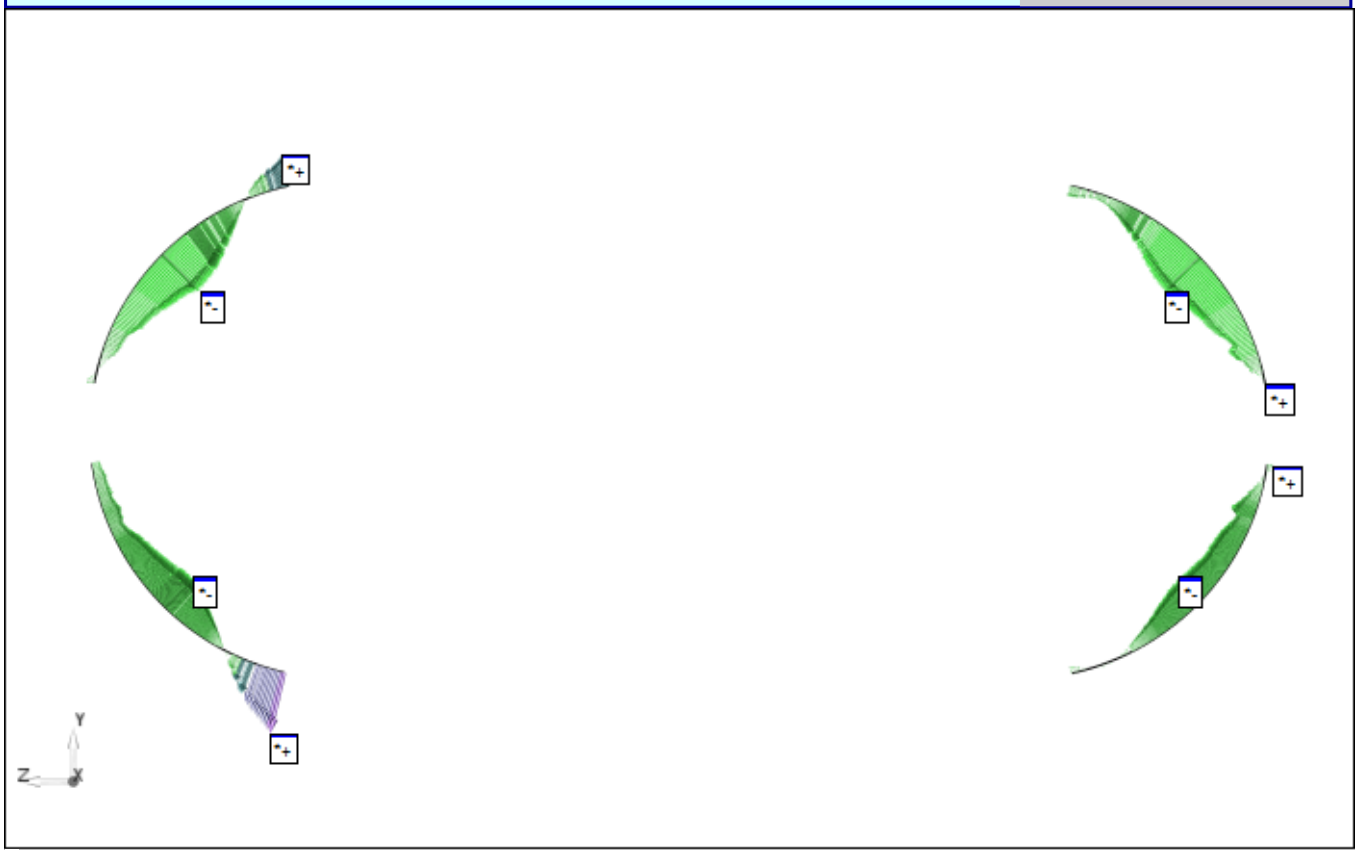
| 1 | MM | FLANGE_LEFT SURFACE FINISH | | | |
|---|---|---|---|---|---|
| AX | NOMINAL | MEAS | DEV | OUTTOL | |
| M | 0.400 | 0.200 | -0.200 | 0.000 | |

| ⌒ | MM | PROF10 - ZPLUS_RIGHT_SCN1 FORMANDLOCATION | | |
|---|---|---|---|---|
| AX | MEAS | MAX | MIN | |
| M | 0.361 | 0.219 | -0.142 | |

| ⌒ | MM | PROF11 - ZPLUS_LEFT_SCN1 FORMANDLOCATION | | |
|---|---|---|---|---|
| AX | MEAS | MAX | MIN | |
| M | 0.291 | 0.110 | -0.180 | |

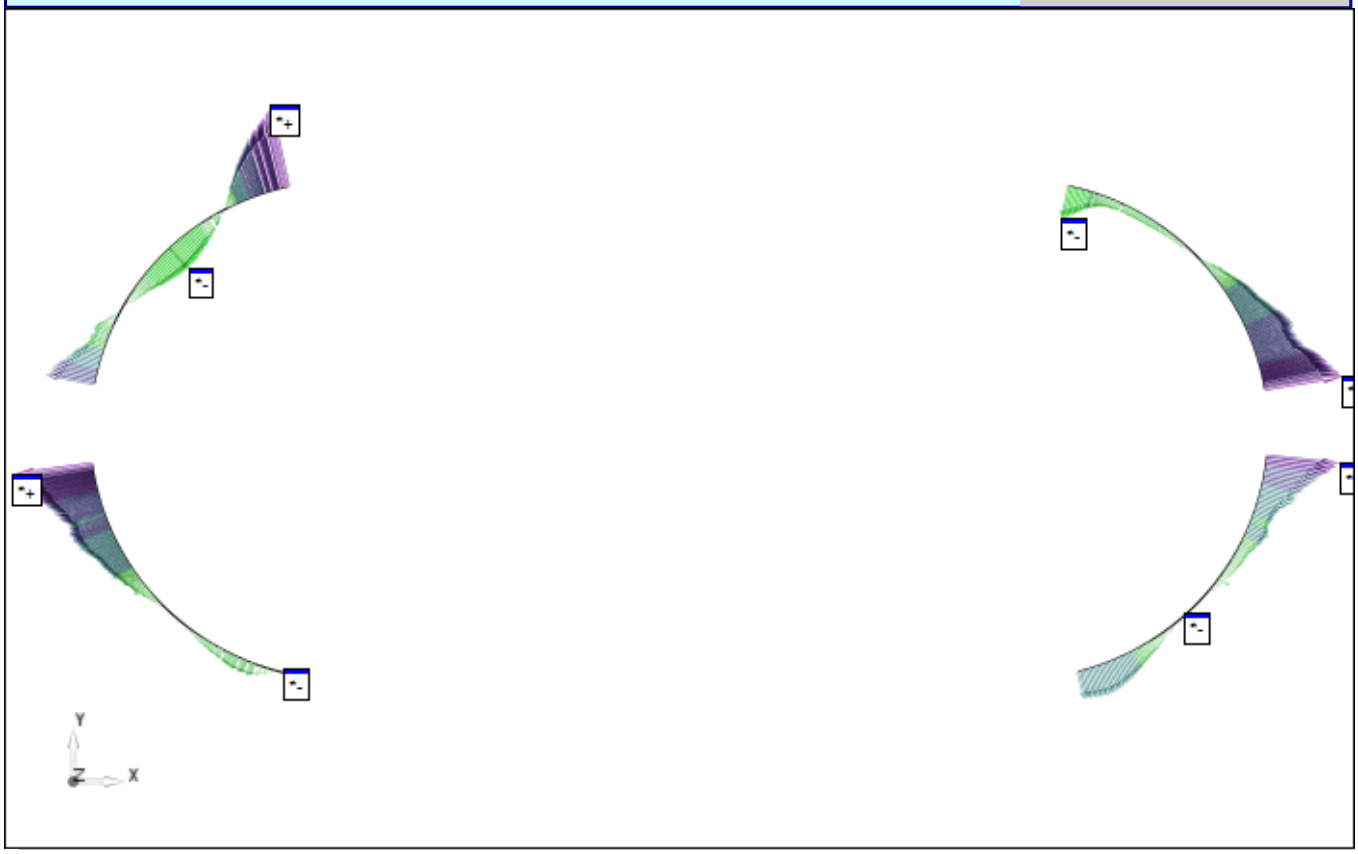
| ⌒ | MM | PROF14 - ZMINUS_RIGHT_SCN1 FORMANDLOCATION | | |
|---|---|---|---|---|
| AX | MEAS | MAX | MIN | |
| M | 0.134 | 0.024 | -0.111 | |

| ⌒ | MM | PROF15 - ZMINUS_LEFT_SCN1 FORMANDLOCATION | | |
|---|---|---|---|---|
| AX | MEAS | MAX | MIN | |
| M | 0.173 | 0.003 | -0.170 | |




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 | 0.394 | 0.276 | -0.118 | |
| ⌒ | MM | PROF13 - XPLUS_RIGHT_SCN1 FORMANDLOCATION | | |
| AX | MEAS | MAX | MIN | |
| M | 0.261 | 0.257 | -0.004 | |
| ⌒ | MM | PROF16 - XMINUS_RIGHT_SCN1 FORMANDLOCATION | | |
| AX | MEAS | MAX | MIN | |
| M | 0.284 | 0.275 | -0.008 | |
| ⌒ | MM | PROF17 - XMINUS_LEFT_SCN1 FORMANDLOCATION | | |
| AX | MEAS | MAX | MIN | |
| M | 0.384 | 0.286 | -0.098 | |




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