pc-dmis	PART NAME : 481343_A		August 19, 2014	10:59
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

SRF - 650MHZ
CAVITY, BETA = 0.9
SINGLE CELL ASSEMBLY
SERIAL NUMBER: B9AS-PAV-102

RF#97043
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	565.812	0.500	0.500	-1.688	1.188
FL	0.000	0.004	0.400	0.000	0.004	0.000

⊕	MM	LOC3 - RIGHT_FLANGE_SEAL_SURF				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	1.000	0.901	0.500	0.500	-0.099	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	0.043	0.400	0.000	0.043	0.000

FCFPERP2	MM	⊥ 0.4 A				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_PLN	0.000	0.059	0.400	0.000	0.059	0.000

FCFPARL1	MM	// 0.5 C				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_PLN	0.000	0.601	0.500	0.000	0.601	0.101

⊕	MM	LOC4 - DATUM_C				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		0.000		-1.000		-0.002

⊕	MM	LOC5 - LEFT_FLANGE_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
AX		I		J		K
V		-0.002		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	-0.001

	MM	LOC7 - LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL

AX	I	J	K
V	-0.002	1.000	0.000

	MM	LOC8 - RIGHT_FLANGE_BEAM_TUBE_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL

AX	I	J	K
V	0.000	-1.000	-0.002

	MM	LOC9 - LEFT_FLANGE_BEAM_TUBE_PLN

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL

AX	I	J	K
V	-0.002	1.000	-0.001

	MM	DIST1 - LEFT_FLANGE_PLN TO LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	1.000	0.993	0.200	0.200	-0.007	0.000

	MM	FLAT1 - LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.000	0.004	0.250	0.000	0.004	0.000

	MM	LOC10 - DATUM_B

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	99.935	0.200	0.200	-0.065	0.000
RN	0.000	0.299	0.050	0.000	0.299	0.249

	MM	LOC11 - DATUM_A_CYL1

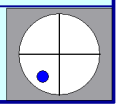
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.008	0.200	0.200	0.008	0.000
RN	0.000	0.190	0.050	0.000	0.190	0.140

	MM	LOC12 - DAT_B_DAT_A_CYL1

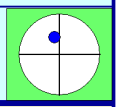
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	99.993	0.050	0.050	-0.007	0.000
RN	0.000	0.472	0.050	0.000	0.472	0.422

	MM	LOC13 - DATUM_B_END1

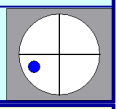
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
X	0.000	-0.105			-0.105		
Y	0.000	0.000			0.000		
Z	0.000	-0.136			-0.136		
TP	RFS	0.343	0.500		0.343	0.000	0.000



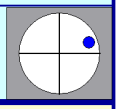
MM	LOC14 - DATUM_B_END2					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.030			-0.030	
Y	170.000	170.000			0.000	
Z	0.000	0.107			0.107	
TP	RFS	0.221	0.500		0.221	0.000



MM	LOC17 - DATUM_A_END1					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.155			-0.155	
Y	567.500	567.500			0.000	
Z	0.000	-0.077			-0.077	
TP	RFS	0.346	0.500		0.346	0.000



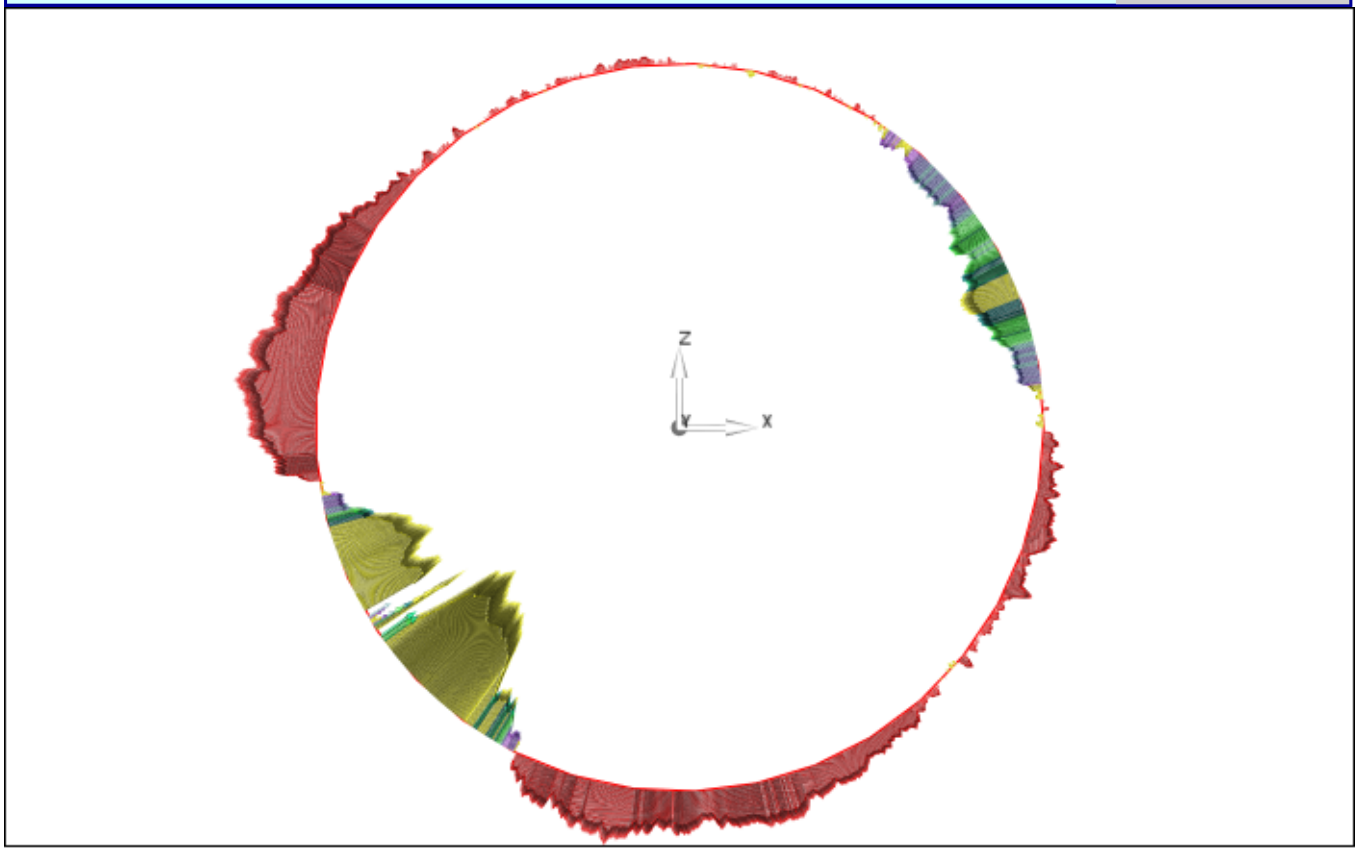
MM	LOC18 - DATUM_A_END2					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.181			0.181	
Y	397.500	397.500			0.000	
Z	0.000	0.069			0.069	
TP	RFS	0.388	0.500		0.388	0.000



MM	LOC19 - FLANGE_RIGHT_OD					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.102	0.050	0.050	-0.102	0.052
Z	0.000	-0.145	0.050	0.050	-0.145	0.095
D	170.000	169.963	0.200	0.200	-0.037	0.000
RN	0.000	0.015	0.100	0.000	0.015	0.000

MM	LOC20 - FLANGE_LEFT_OD					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.144	0.050	0.050	-0.144	0.094
Z	0.000	-0.008	0.050	0.050	-0.008	0.000
D	170.000	169.970	0.200	0.200	-0.030	0.000
RN	0.000	0.031	0.100	0.000	0.031	0.000

⌖	MM	LOC21 - MID_WELD_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.131	0.500	0.500	0.131	0.000
Y	283.750	282.903	0.500	0.500	-0.847	0.347
Z	0.000	0.182	0.500	0.500	0.182	0.000
D	404.550	406.220	0.050	0.000	1.670	1.620
RN	0.000	1.295	0.200	0.000	1.295	1.095



PROFILE OF TWO HALF CELLS CENTER WELD CIRCLE

********** 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

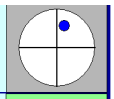
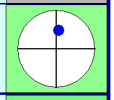
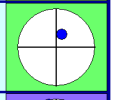
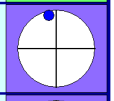
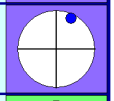
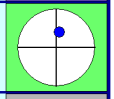
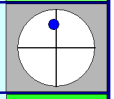
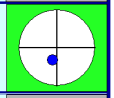
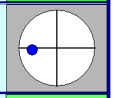
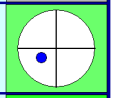
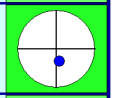
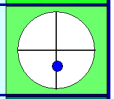
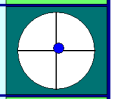
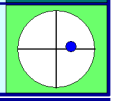
4) LEFT FLANGE OUTSIDE DIAMETER DATUM= LO

(SEE DRAWING 481600 FLANGE, HEX-SEAL)

****

FCFLOC1 Size	MM	18XØ8.5 0.13/0.13						
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS	
FLANGE_RIGHT_TOP_CIR1	8.500	8.685	0.130	0.130	0.185	0.055	0.260	
FLANGE_RIGHT_CIR2	8.500	8.686	0.130	0.130	0.186	0.056	0.260	
FLANGE_RIGHT_CIR3	8.500	8.697	0.130	0.130	0.197	0.067	0.260	
FLANGE_RIGHT_CIR4	8.500	8.679	0.130	0.130	0.179	0.049	0.260	
FLANGE_RIGHT_CIR5	8.500	8.686	0.130	0.130	0.186	0.056	0.260	
FLANGE_RIGHT_CIR6	8.500	8.715	0.130	0.130	0.215	0.085	0.260	
FLANGE_RIGHT_CIR7	8.500	8.697	0.130	0.130	0.197	0.067	0.260	
FLANGE_RIGHT_CIR8	8.500	8.707	0.130	0.130	0.207	0.077	0.260	
FLANGE_RIGHT_CIR9	8.500	8.690	0.130	0.130	0.190	0.060	0.260	
FLANGE_RIGHT_CIR10	8.500	8.689	0.130	0.130	0.189	0.059	0.260	
FLANGE_RIGHT_CIR11	8.500	8.690	0.130	0.130	0.190	0.060	0.260	
FLANGE_RIGHT_CIR12	8.500	8.693	0.130	0.130	0.193	0.063	0.260	
FLANGE_RIGHT_CIR13	8.500	8.695	0.130	0.130	0.195	0.065	0.260	
FLANGE_RIGHT_CIR14	8.500	8.693	0.130	0.130	0.193	0.063	0.260	
FLANGE_RIGHT_CIR15	8.500	8.688	0.130	0.130	0.188	0.058	0.260	
FLANGE_RIGHT_CIR16	8.500	8.703	0.130	0.130	0.203	0.073	0.260	
FLANGE_RIGHT_CIR17	8.500	8.686	0.130	0.130	0.186	0.056	0.260	
FLANGE_RIGHT_CIR18	8.500	8.685	0.130	0.130	0.185	0.055	0.260	

FCFLOC1 Position	MM	⌖ Ø0.2 Ⓜ RF RO					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_RIGH...	0.000	0.225	0.200		0.225	0.000	0.260
FLANGE_RIGH...	0.000	0.333	0.200		0.333	0.000	0.260
FLANGE_RIGH...	0.000	0.286	0.200		0.286	0.000	0.260
FLANGE_RIGH...	0.000	0.222	0.200		0.222	0.000	0.260

FLANGE_RIGHT_CIR5	0.276	0.260	
FLANGE_RIGHT_CIR6	0.219	0.260	
FLANGE_RIGHT_CIR7	0.165	0.260	
FLANGE_RIGHT_CIR8	0.399	0.260	
FLANGE_RIGHT_CIR9	0.399	0.260	
FLANGE_RIGHT_CIR10	0.193	0.260	
FLANGE_RIGHT_CIR11	0.278	0.260	
FLANGE_RIGHT_CIR12	0.153	0.260	
FLANGE_RIGHT_CIR13	0.299	0.260	
FLANGE_RIGHT_CIR14	0.203	0.260	
FLANGE_RIGHT_CIR15	0.153	0.260	
FLANGE_RIGHT_CIR16	0.193	0.260	
FLANGE_RIGHT_CIR17	0.043	0.260	
FLANGE_RIGHT_CIR18	0.177	0.260	

FCFLOC1 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	360.000	Fixed

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

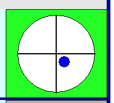
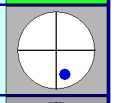
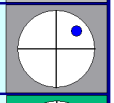
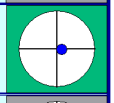
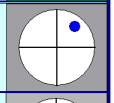
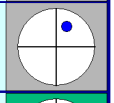
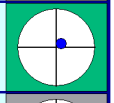
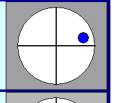
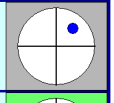
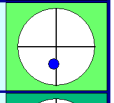
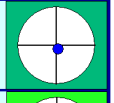
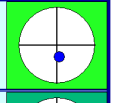
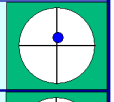
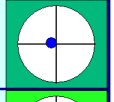
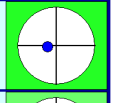
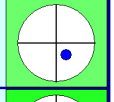
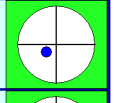
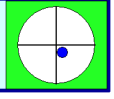
Feature	AX	NOMINAL	MEAS	DEV
FLANGE_RIGHT_TOP_CIR1	PR	75.800	75.758	-0.042
	PA	90.000	89.921	-0.079
FLANGE_RIGHT_CIR2	PR	75.800	75.745	-0.055
	PA	110.000	109.881	-0.119
FLANGE_RIGHT_CIR3	PR	75.800	75.769	-0.031
	PA	130.000	129.894	-0.106
FLANGE_RIGHT_CIR4	PR	75.800	75.762	-0.038
	PA	150.000	149.921	-0.079
FLANGE_RIGHT_CIR5	PR	75.800	75.777	-0.023

	PA	170.000	169.897	-0.103
FLANGE_RIGHT_CIR6	PR	75.800	75.767	-0.033
	PA	190.000	189.921	-0.079
FLANGE_RIGHT_CIR7	PR	75.800	75.735	-0.065
	PA	210.000	209.961	-0.039
FLANGE_RIGHT_CIR8	PR	75.800	75.679	-0.121
	PA	230.000	229.880	-0.120
FLANGE_RIGHT_CIR9	PR	75.800	75.601	-0.199
	PA	250.000	250.015	0.015
FLANGE_RIGHT_CIR10	PR	75.800	75.706	-0.094
	PA	270.000	270.015	0.015
FLANGE_RIGHT_CIR11	PR	75.800	75.665	-0.135
	PA	290.000	290.026	0.026
FLANGE_RIGHT_CIR12	PR	75.800	75.837	0.037
	PA	310.000	309.950	-0.050
FLANGE_RIGHT_CIR13	PR	75.800	75.676	-0.124
	PA	330.000	329.937	-0.063
FLANGE_RIGHT_CIR14	PR	75.800	75.724	-0.076
	PA	350.000	349.949	-0.051
FLANGE_RIGHT_CIR15	PR	75.800	75.804	0.004
	PA	10.000	9.942	-0.058
FLANGE_RIGHT_CIR16	PR	75.800	75.757	-0.043
	PA	30.000	29.935	-0.065
FLANGE_RIGHT_CIR17	PR	75.800	75.821	0.021
	PA	50.000	49.998	-0.002
FLANGE_RIGHT_CIR18	PR	75.800	75.842	0.042
	PA	70.000	69.941	-0.059

FCFLOC2 Size	MM	18XØ8.5 0.13/0.13					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_LEFT_CIR1	8.500	8.684	0.130	0.130	0.184	0.054	0.260
FLANGE_LEFT_CIR2	8.500	8.691	0.130	0.130	0.191	0.061	0.260
FLANGE_LEFT_CIR3	8.500	8.657	0.130	0.130	0.157	0.027	0.260
FLANGE_LEFT_CIR4	8.500	8.653	0.130	0.130	0.153	0.023	0.260
FLANGE_LEFT_CIR5	8.500	8.693	0.130	0.130	0.193	0.063	0.260
FLANGE_LEFT_CIR6	8.500	8.691	0.130	0.130	0.191	0.061	0.260
FLANGE_LEFT_CIR7	8.500	8.686	0.130	0.130	0.186	0.056	0.260
FLANGE_LEFT_CIR8	8.500	8.696	0.130	0.130	0.196	0.066	0.260
FLANGE_LEFT_CIR9	8.500	8.697	0.130	0.130	0.197	0.067	0.260
FLANGE_LEFT_CIR10	8.500	8.688	0.130	0.130	0.188	0.058	0.260
FLANGE_LEFT_CIR11	8.500	8.676	0.130	0.130	0.176	0.046	0.260
FLANGE_LEFT_CIR12	8.500	8.680	0.130	0.130	0.180	0.050	0.260
FLANGE_LEFT_CIR13	8.500	8.685	0.130	0.130	0.185	0.055	0.260
FLANGE_LEFT_CIR14	8.500	8.693	0.130	0.130	0.193	0.063	0.260

FLANGE_LEFT_CIR15	8.673	0.000	0.000	0.260
FLANGE_LEFT_CIR16	8.695	0.000	0.000	0.260
FLANGE_LEFT_CIR17	8.682	0.000	0.000	0.260
FLANGE_LEFT_CIR18	8.699	0.000	0.000	0.260

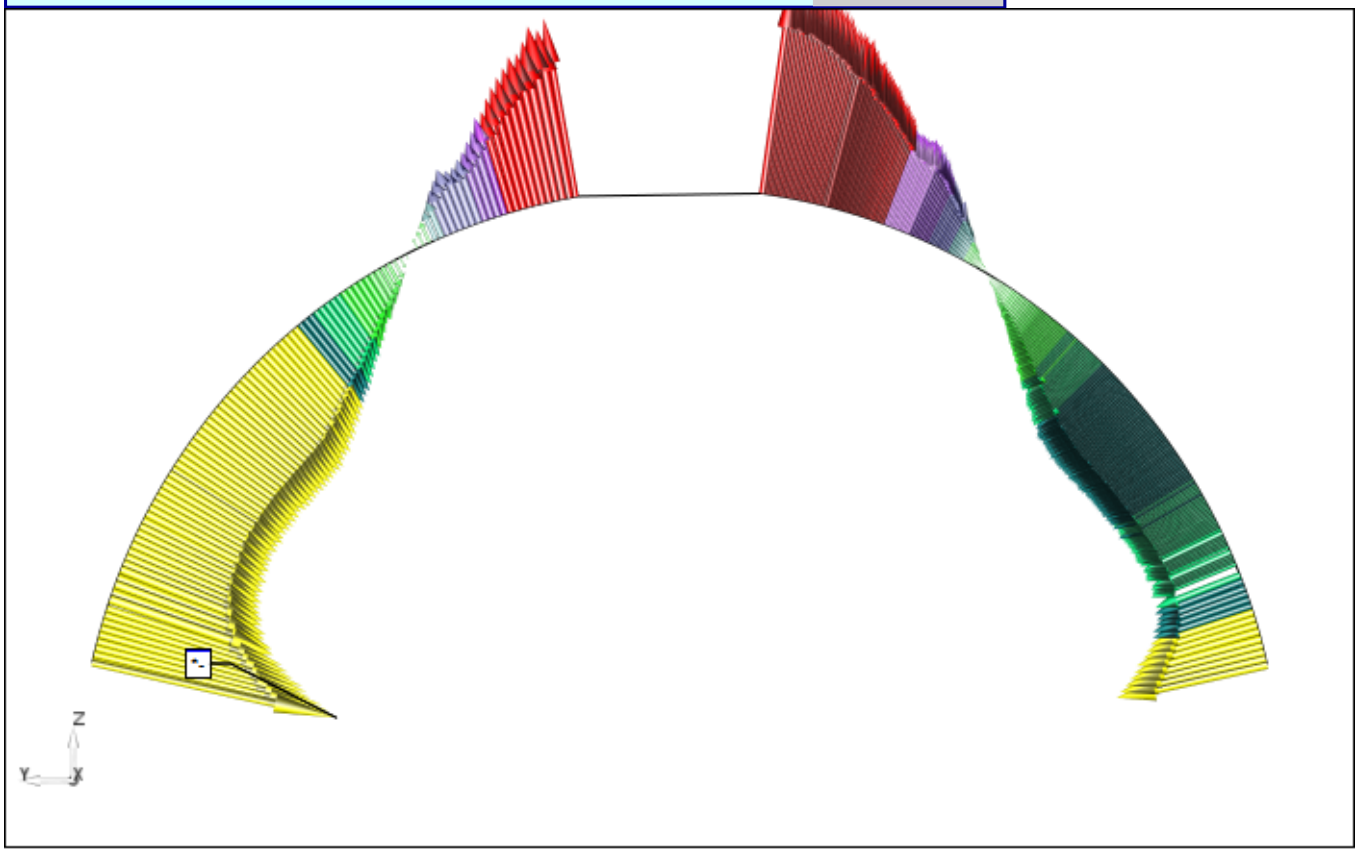
FCFLOC2 Position	MM	⌖ Ø0.2 Ⓜ LF LO

Feature	MEAS	BONUS	
FLANGE_LEFT_CIR1	0.129	0.260	
FLANGE_LEFT_CIR2	0.302	0.260	
FLANGE_LEFT_CIR3	0.318	0.260	
FLANGE_LEFT_CIR4	0.058	0.260	
FLANGE_LEFT_CIR5	0.334	0.260	
FLANGE_LEFT_CIR6	0.273	0.260	
FLANGE_LEFT_CIR7	0.077	0.260	
FLANGE_LEFT_CIR8	0.334	0.260	
FLANGE_LEFT_CIR9	0.294	0.260	
FLANGE_LEFT_CIR10	0.202	0.260	
FLANGE_LEFT_CIR11	0.053	0.260	
FLANGE_LEFT_CIR12	0.141	0.260	
FLANGE_LEFT_CIR13	0.093	0.260	
FLANGE_LEFT_CIR14	0.060	0.260	
FLANGE_LEFT_CIR15	0.102	0.260	
FLANGE_LEFT_CIR16	0.183	0.260	
FLANGE_LEFT_CIR17	0.144	0.260	
FLANGE_LEFT_CIR18	0.120	0.260	

FCFLOC2 Datum Shift						
Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	359.510	Fixed

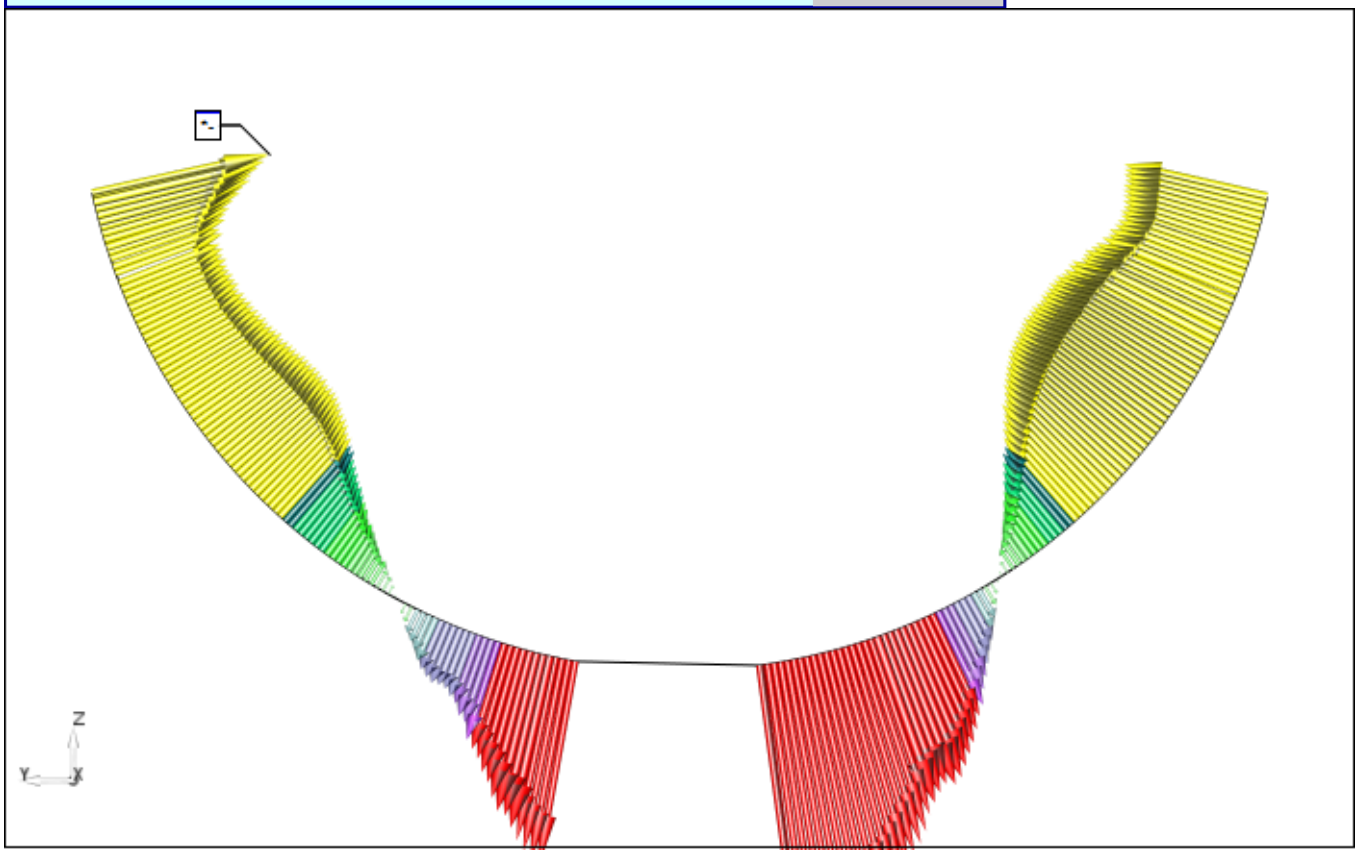
FCFLOC2 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON				
Feature	AX	NOMINAL	MEAS	DEV
FLANGE_LEFT_CIR1	PR	75.800	75.754	-0.046
	PA	90.000	89.966	-0.034
FLANGE_LEFT_CIR2	PR	75.800	75.649	-0.151
	PA	110.000	110.001	0.001
FLANGE_LEFT_CIR3	PR	75.800	75.802	0.002
	PA	130.000	129.880	-0.120
FLANGE_LEFT_CIR4	PR	75.800	75.773	-0.027
	PA	150.000	149.992	-0.008
FLANGE_LEFT_CIR5	PR	75.800	75.716	-0.084
	PA	170.000	169.891	-0.109
FLANGE_LEFT_CIR6	PR	75.800	75.718	-0.082
	PA	190.000	189.918	-0.082
FLANGE_LEFT_CIR7	PR	75.800	75.762	-0.038
	PA	210.000	209.997	-0.003
FLANGE_LEFT_CIR8	PR	75.800	75.660	-0.140
	PA	230.000	230.069	0.069
FLANGE_LEFT_CIR9	PR	75.800	75.665	-0.135
	PA	250.000	250.043	0.043
FLANGE_LEFT_CIR10	PR	75.800	75.900	0.100
	PA	270.000	269.989	-0.011
FLANGE_LEFT_CIR11	PR	75.800	75.826	0.026
	PA	290.000	290.002	0.002
FLANGE_LEFT_CIR12	PR	75.800	75.862	0.062
	PA	310.000	309.976	-0.024
FLANGE_LEFT_CIR13	PR	75.800	75.782	-0.018
	PA	330.000	330.032	0.032
FLANGE_LEFT_CIR14	PR	75.800	75.770	-0.030
	PA	350.000	350.001	0.001
FLANGE_LEFT_CIR15	PR	75.800	75.749	-0.051
	PA	10.000	10.001	0.001
FLANGE_LEFT_CIR16	PR	75.800	75.817	0.017
	PA	30.000	29.932	-0.068
FLANGE_LEFT_CIR17	PR	75.800	75.730	-0.070
	PA	50.000	50.013	0.013
FLANGE_LEFT_CIR18	PR	75.800	75.769	-0.031
	PA	70.000	69.961	-0.039

FCFPROF1	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.682	0.300	0.000	0.682	0.382



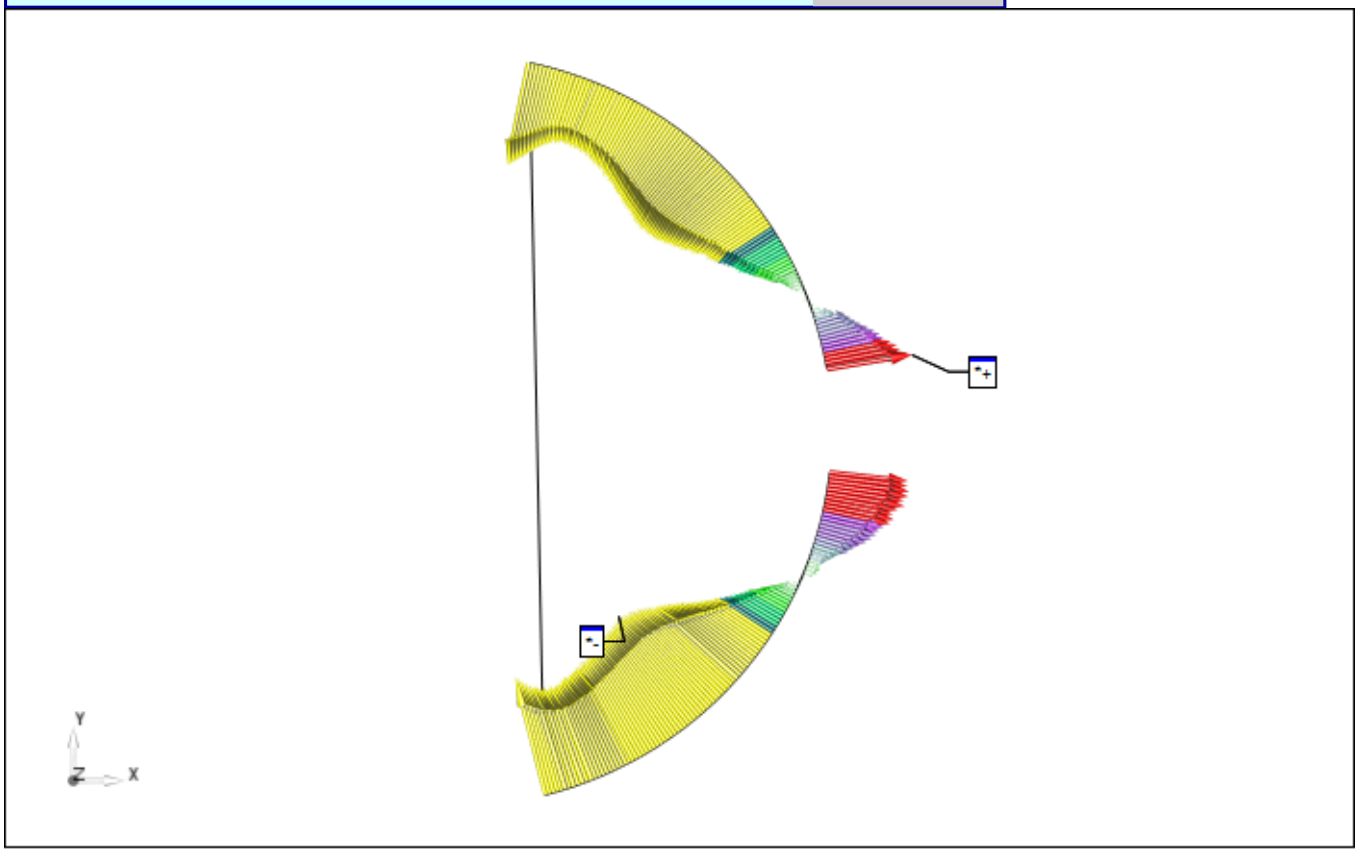
PROFILE OF RIGHT AND LEFT HALF CELLS 12 'O' CLOCK- X100

FCFPROF2	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.763	0.300	0.000	0.763	0.463



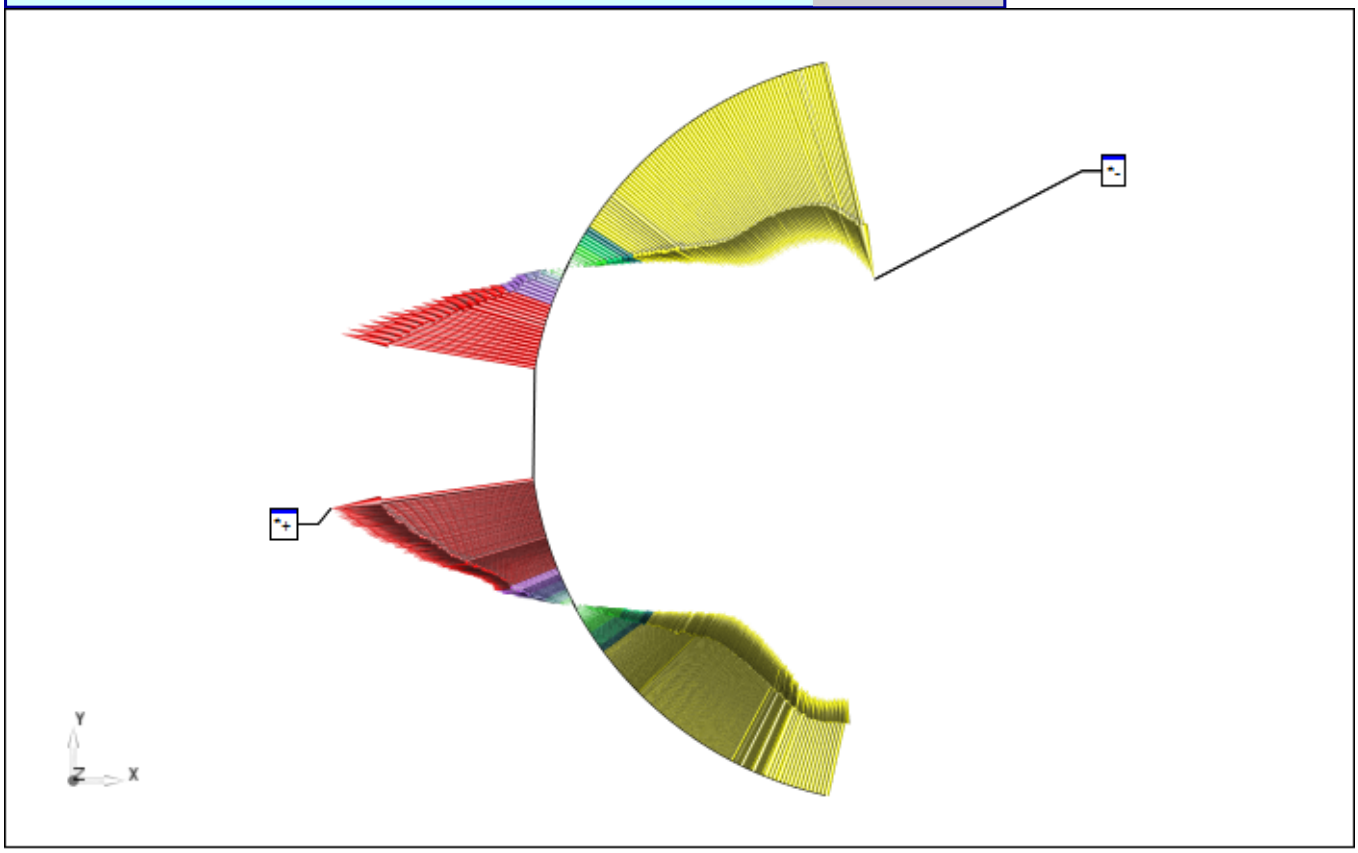
PROFILE OF RIGHT AND LEFT HALF CELLS 6 'O' CLOCK- X100

FCFPROF3	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.495	0.300	0.000	0.495	0.195

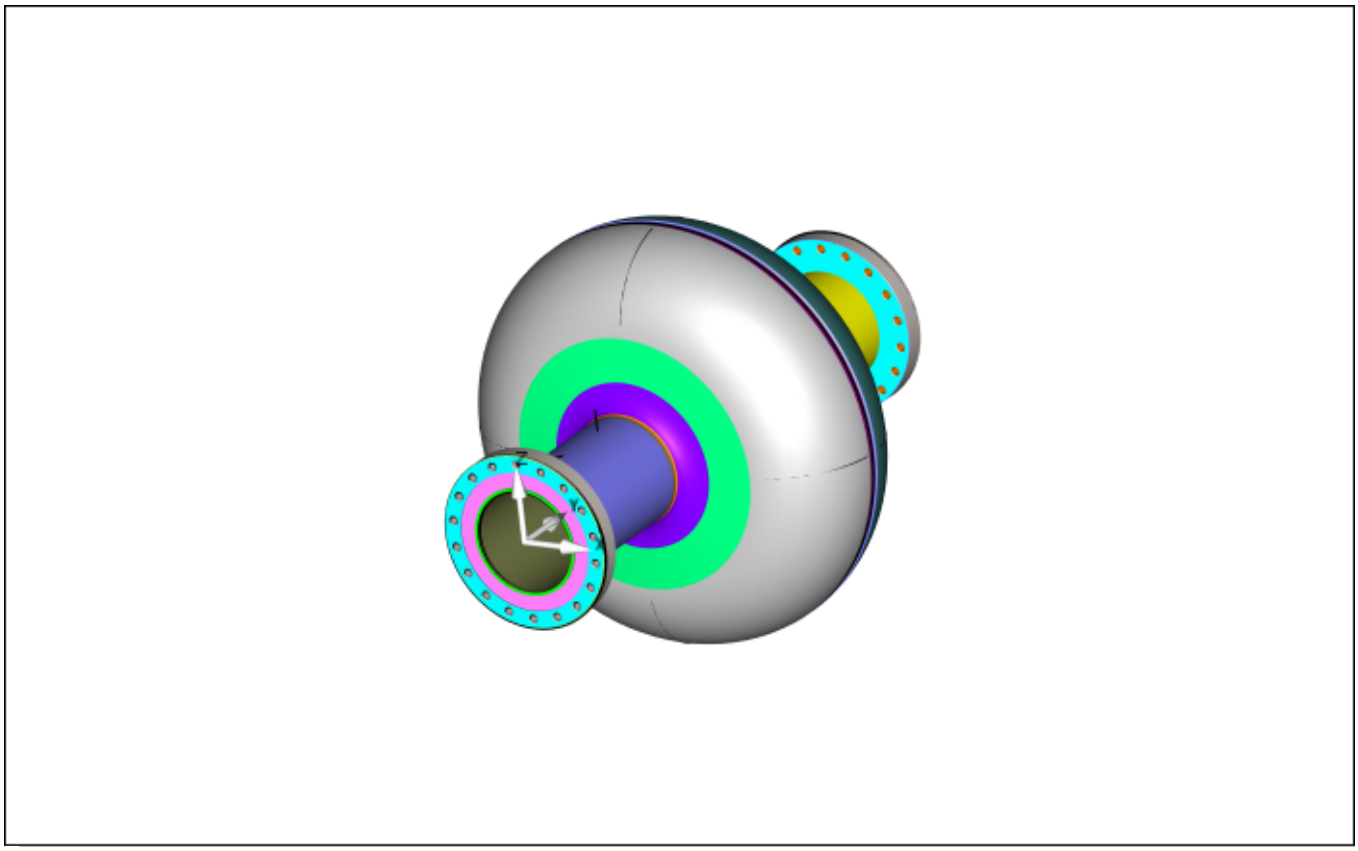


PROFILE OF RIGHT AND LEFT HALF CELLS 3 'O' CLOCK- X100

FCFPROF4	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.982	0.300	0.000	0.982	0.682



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	

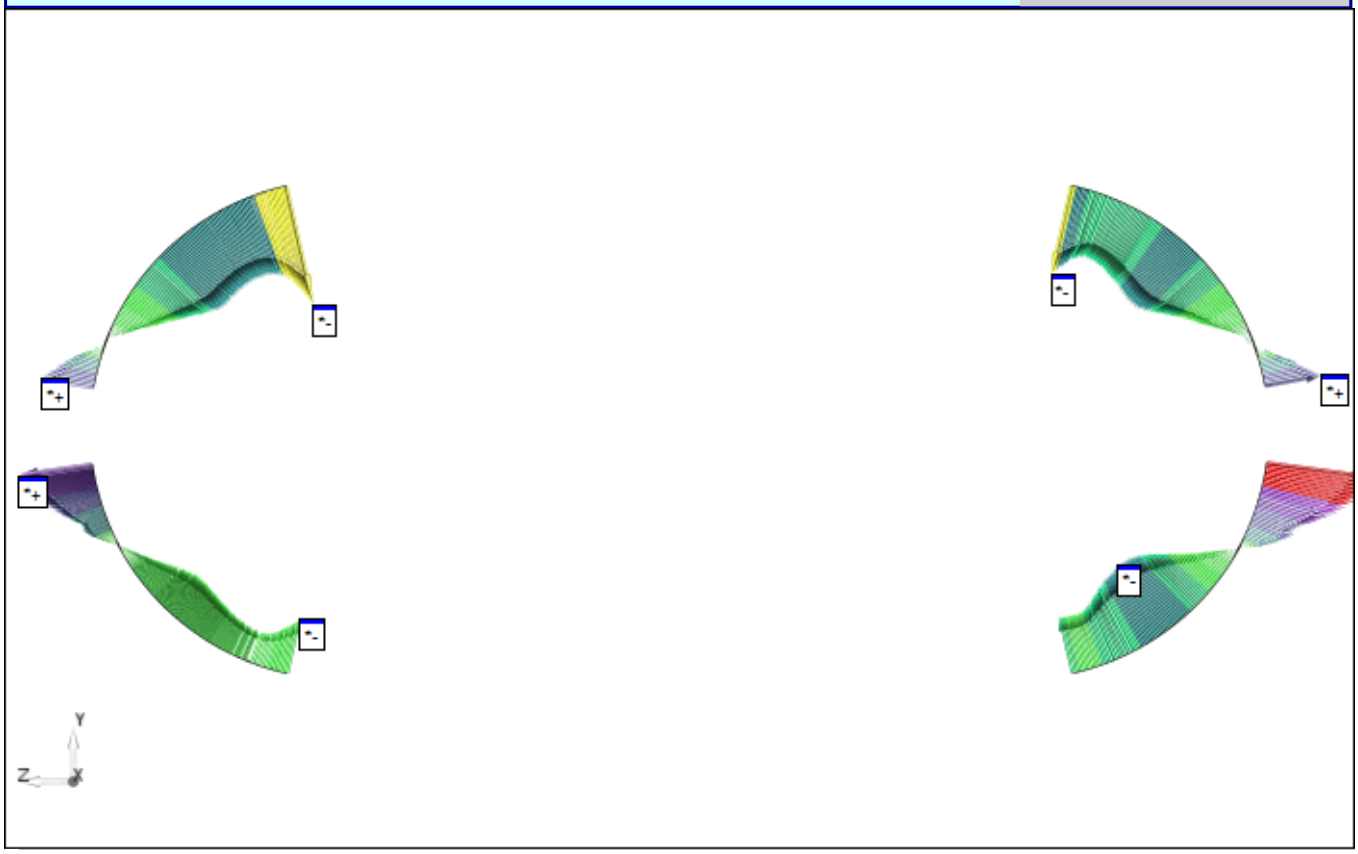
1	MM	FLANGE_LEFT SURFACE FINISH			
AX	NOMINAL	MEAS	DEV	OUTTOL	
M	0.400	0.200	-0.200	0.000	

	MM	PROF10 - ZPLUS_RIGHT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.449	0.258	-0.190	

	MM	PROF11 - ZPLUS_LEFT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.608	0.187	-0.421	

	MM	PROF14 - ZMINUS_RIGHT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.689	0.405	-0.284	

	MM	PROF15 - ZMINUS_LEFT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.511	0.195	-0.316	



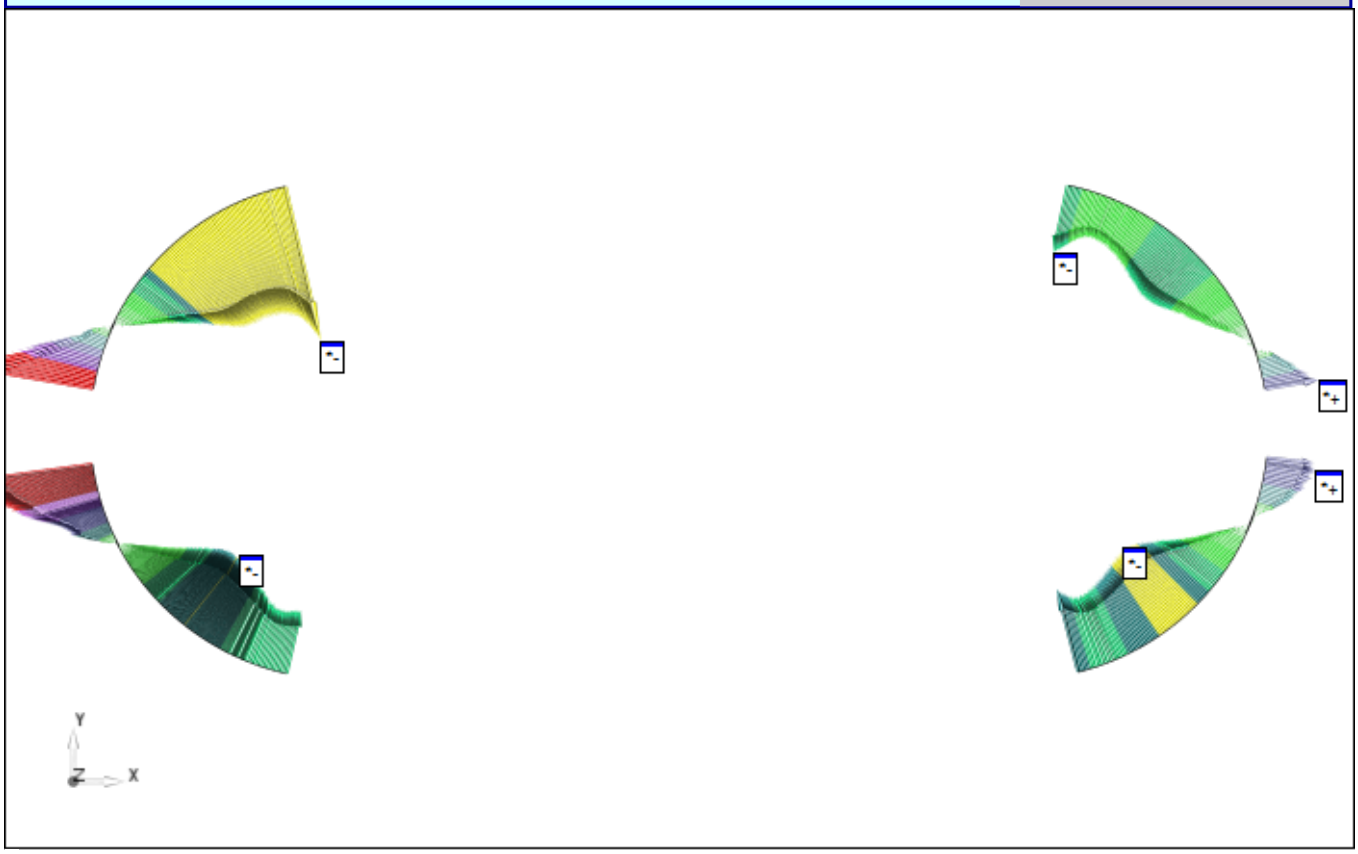
BESTFIT TO ALL 8 SCANS PROFILE OF RIGHT AND LEFT HALF CELLS 12'O' and 6'0'CLOCK -X100

	MM	PROF12 - XPLUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.424	0.187	-0.236

	MM	PROF13 - XPLUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.488	0.171	-0.316

	MM	PROF16 - XMINUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.757	0.454	-0.302

	MM	PROF17 - XMINUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.974	0.426	-0.548



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