pc-dmis	PART NAME : 481343_A		October 02, 2014	15:07
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

SRF - 650MHZ
CAVITY, BETA = 0.9
SINGLE CELL ASSEMBLY
SERIAL NUMBER: B9AS-PAV-105

RF#97205
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	0.013	0.400	0.000	0.013	0.000

⌖	MM	LOC2 - LEFT_FLANGE_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	567.500	566.860	0.500	0.500	-0.640	0.140
FL	0.000	0.008	0.400	0.000	0.008	0.000

⌖	MM	LOC3 - RIGHT_FLANGE_SEAL_SURF				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	1.000	1.005	0.500	0.500	0.005	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	0.035	0.400	0.000	0.035	0.000

FCFPERP2	MM	⊥ 0.4 A				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_PLN	0.000	0.038	0.400	0.000	0.038	0.000

FCFPARL1	MM	// 0.5 C				
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
LEFT_FLANGE_PLN	0.000	0.906	0.500	0.000	0.906	0.406

⌖	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	-0.002	1.000	-0.002

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

AX	I	J	K
V	-0.001	-1.000	-0.003

	MM	LOC7 - LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL

AX	I	J	K
V	-0.003	1.000	-0.002

	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	-0.002	1.000	-0.002

	MM	DIST1 - LEFT_FLANGE_PLN TO LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	1.000	1.026	0.200	0.200	0.026	0.000

	MM	FLAT1 - LEFT_FLANGE_SEAL_SURF

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.000	0.006	0.250	0.000	0.006	0.000

	MM	LOC10 - DATUM_B

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.048	0.200	0.200	0.048	0.000
RN	0.000	0.463	0.050	0.000	0.463	0.413

	MM	LOC11 - DATUM_A_CYL1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.006	0.200	0.200	0.006	0.000
RN	0.000	0.191	0.050	0.000	0.191	0.141

	MM	LOC12 - DAT_B_DAT_A_CYL1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
D	100.000	100.017	0.050	0.050	0.017	0.000
RN	0.000	0.738	0.050	0.000	0.738	0.688

	MM	LOC13 - DATUM_B_END1

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
X	0.000	-0.204			-0.204		
Y	0.000	0.000			0.000		
Z	0.000	-0.227			-0.227		
TP	RFS	0.610	0.500		0.610	0.110	0.000

	MM	LOC14 - DATUM_B_END2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.065			0.065	
Y	170.000	170.000			0.000	
Z	0.000	0.137			0.137	
TP	RFS	0.304	0.500		0.304	0.000

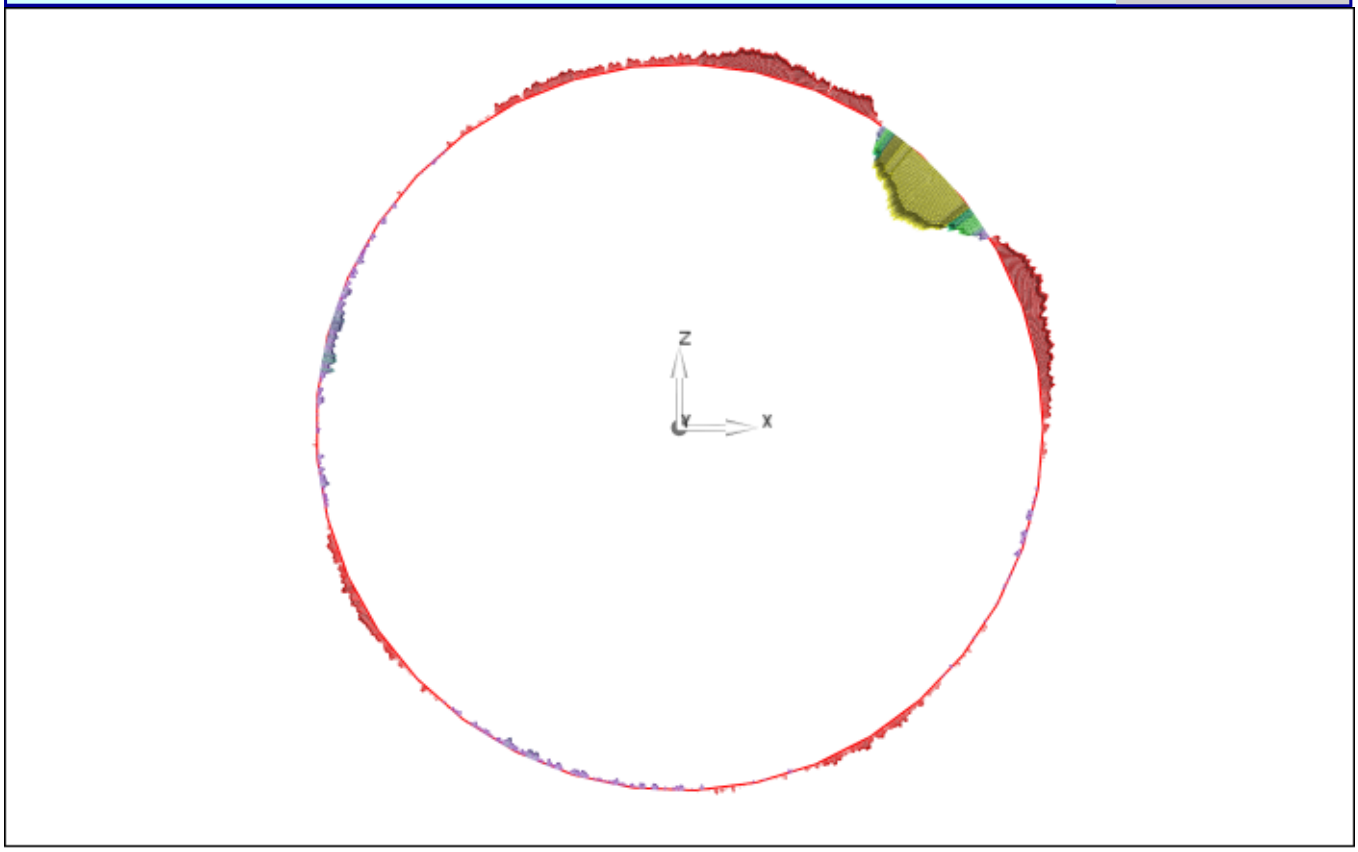
	MM	LOC17 - DATUM_A_END1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.183			-0.183	
Y	567.500	567.500			0.000	
Z	0.000	-0.145			-0.145	
TP	RFS	0.467	0.500		0.467	0.000

	MM	LOC18 - DATUM_A_END2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.214			0.214	
Y	397.500	397.500			0.000	
Z	0.000	0.160			0.160	
TP	RFS	0.534	0.500		0.534	0.034

	MM	LOC19 - FLANGE_RIGHT_OD				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.198	0.050	0.050	-0.198	0.148
Z	0.000	-0.177	0.050	0.050	-0.177	0.127
D	170.000	169.987	0.200	0.200	-0.013	0.000
RN	0.000	0.017	0.100	0.000	0.017	0.000

	MM	LOC20 - FLANGE_LEFT_OD				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	-0.193	0.050	0.050	-0.193	0.143
Z	0.000	-0.131	0.050	0.050	-0.131	0.081
D	170.000	169.973	0.200	0.200	-0.027	0.000
RN	0.000	0.011	0.100	0.000	0.011	0.000

⌖	MM	LOC21 - MID_WELD_CIR1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.000	0.169	0.500	0.500	0.169	0.000
Y	283.750	283.427	0.500	0.500	-0.323	0.000
Z	0.000	0.277	0.500	0.500	0.277	0.000
D	404.550	405.577	0.050	0.000	1.027	0.977
RN	0.000	0.548	0.200	0.000	0.548	0.348



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	8.738	0.130	0.130	0.238	0.108	0.260
FLANGE_RIGHT_CIR2	8.500	8.718	0.130	0.130	0.218	0.088	0.260
FLANGE_RIGHT_CIR3	8.500	8.734	0.130	0.130	0.234	0.104	0.260
FLANGE_RIGHT_CIR4	8.500	8.761	0.130	0.130	0.261	0.131	0.260
FLANGE_RIGHT_CIR5	8.500	8.793	0.130	0.130	0.293	0.163	0.260
FLANGE_RIGHT_CIR6	8.500	8.783	0.130	0.130	0.283	0.153	0.260
FLANGE_RIGHT_CIR7	8.500	8.787	0.130	0.130	0.287	0.157	0.260
FLANGE_RIGHT_CIR8	8.500	8.751	0.130	0.130	0.251	0.121	0.260
FLANGE_RIGHT_CIR9	8.500	8.764	0.130	0.130	0.264	0.134	0.260
FLANGE_RIGHT_CIR10	8.500	8.762	0.130	0.130	0.262	0.132	0.260
FLANGE_RIGHT_CIR11	8.500	8.752	0.130	0.130	0.252	0.122	0.260
FLANGE_RIGHT_CIR12	8.500	8.738	0.130	0.130	0.238	0.108	0.260
FLANGE_RIGHT_CIR13	8.500	8.741	0.130	0.130	0.241	0.111	0.260
FLANGE_RIGHT_CIR14	8.500	8.802	0.130	0.130	0.302	0.172	0.260
FLANGE_RIGHT_CIR15	8.500	8.820	0.130	0.130	0.320	0.190	0.260
FLANGE_RIGHT_CIR16	8.500	8.753	0.130	0.130	0.253	0.123	0.260
FLANGE_RIGHT_CIR17	8.500	8.736	0.130	0.130	0.236	0.106	0.260
FLANGE_RIGHT_CIR18	8.500	8.770	0.130	0.130	0.270	0.140	0.260

FCFLOC1 Position	MM	⌖ Ø0.2 Ⓜ RF RO					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_RIGHT_TOP_CIR1	0.000	0.103	0.200		0.103	0.000	0.260
FLANGE_RIGHT_CIR2	0.000	0.190	0.200		0.190	0.000	0.260
FLANGE_RIGHT_CIR3	0.000	0.227	0.200		0.227	0.000	0.260
FLANGE_RIGHT_CIR4	0.000	0.036	0.200		0.036	0.000	0.260

FLANGE_RIGHT_CIR5	0.000	0.216	0.216	0.000	0.260	
FLANGE_RIGHT_CIR6	0.000	0.156	0.156	0.000	0.260	
FLANGE_RIGHT_CIR7	0.000	0.170	0.170	0.000	0.260	
FLANGE_RIGHT_CIR8	0.000	0.056	0.056	0.000	0.260	
FLANGE_RIGHT_CIR9	0.000	0.212	0.212	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.080	0.080	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.187	0.187	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.285	0.285	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.229	0.229	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.073	0.073	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.211	0.211	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.081	0.081	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.090	0.090	0.000	0.260	
FLANGE_RIGHT_CI...	0.000	0.148	0.148	0.000	0.260	

FCFLOC1 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	359.885	Fixed

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

Feature	AX	NOMINAL	MEAS	DEV
FLANGE_RIGHT_TOP_CIR1	PR	75.800	75.778	-0.022
	PA	90.000	89.965	-0.036
FLANGE_RIGHT_CIR2	PR	75.800	75.778	-0.022
	PA	110.000	110.070	0.070
FLANGE_RIGHT_CIR3	PR	75.800	75.713	-0.087
	PA	130.000	129.945	-0.055
FLANGE_RIGHT_CIR4	PR	75.800	75.796	-0.004
	PA	150.000	150.013	0.013
FLANGE_RIGHT_CIR5	PR	75.800	75.699	-0.101

	PA	170.000	169.971	-0.029
FLANGE_RIGHT_CIR6	PR	75.800	75.783	-0.017
	PA	190.000	189.942	-0.058
FLANGE_RIGHT_CIR7	PR	75.800	75.722	-0.078
	PA	210.000	210.026	0.025
FLANGE_RIGHT_CIR8	PR	75.800	75.813	0.013
	PA	230.000	229.981	-0.019
FLANGE_RIGHT_CIR9	PR	75.800	75.699	-0.101
	PA	250.000	250.024	0.024
FLANGE_RIGHT_CIR10	PR	75.800	75.784	-0.016
	PA	270.000	270.028	0.028
FLANGE_RIGHT_CIR11	PR	75.800	75.765	-0.035
	PA	290.000	290.065	0.065
FLANGE_RIGHT_CIR12	PR	75.800	75.657	-0.143
	PA	310.000	310.000	0.000
FLANGE_RIGHT_CIR13	PR	75.800	75.769	-0.031
	PA	330.000	330.084	0.083
FLANGE_RIGHT_CIR14	PR	75.800	75.836	0.036
	PA	350.000	350.004	0.004
FLANGE_RIGHT_CIR15	PR	75.800	75.899	0.099
	PA	10.000	10.028	0.028
FLANGE_RIGHT_CIR16	PR	75.800	75.822	0.022
	PA	30.000	30.025	0.025
FLANGE_RIGHT_CIR17	PR	75.800	75.762	-0.038
	PA	50.000	50.018	0.018
FLANGE_RIGHT_CIR18	PR	75.800	75.809	0.009
	PA	70.000	70.056	0.056

FCFLOC2 Size	MM	18XØ8.5 0.13/0.13					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	BONUS
FLANGE_LEFT_CIR1	8.500	8.715	0.130	0.130	0.215	0.085	0.260
FLANGE_LEFT_CIR2	8.500	8.717	0.130	0.130	0.217	0.087	0.260
FLANGE_LEFT_CIR3	8.500	8.711	0.130	0.130	0.211	0.081	0.260
FLANGE_LEFT_CIR4	8.500	8.708	0.130	0.130	0.208	0.078	0.260
FLANGE_LEFT_CIR5	8.500	8.717	0.130	0.130	0.217	0.087	0.260
FLANGE_LEFT_CIR6	8.500	8.714	0.130	0.130	0.214	0.084	0.260
FLANGE_LEFT_CIR7	8.500	8.699	0.130	0.130	0.199	0.069	0.260
FLANGE_LEFT_CIR8	8.500	8.712	0.130	0.130	0.212	0.082	0.260
FLANGE_LEFT_CIR9	8.500	8.707	0.130	0.130	0.207	0.077	0.260
FLANGE_LEFT_CIR10	8.500	8.717	0.130	0.130	0.217	0.087	0.260
FLANGE_LEFT_CIR11	8.500	8.715	0.130	0.130	0.215	0.085	0.260
FLANGE_LEFT_CIR12	8.500	8.717	0.130	0.130	0.217	0.087	0.260
FLANGE_LEFT_CIR13	8.500	8.719	0.130	0.130	0.219	0.089	0.260
FLANGE_LEFT_CIR14	8.500	8.716	0.130	0.130	0.216	0.086	0.260

FLANGE_LEFT_CI...	8.500	8.698	0.198	0.068	0.260
FLANGE_LEFT_CI...	8.500	8.705	0.205	0.075	0.260
FLANGE_LEFT_CI...	8.500	8.708	0.208	0.078	0.260
FLANGE_LEFT_CI...	8.500	8.702	0.202	0.072	0.260

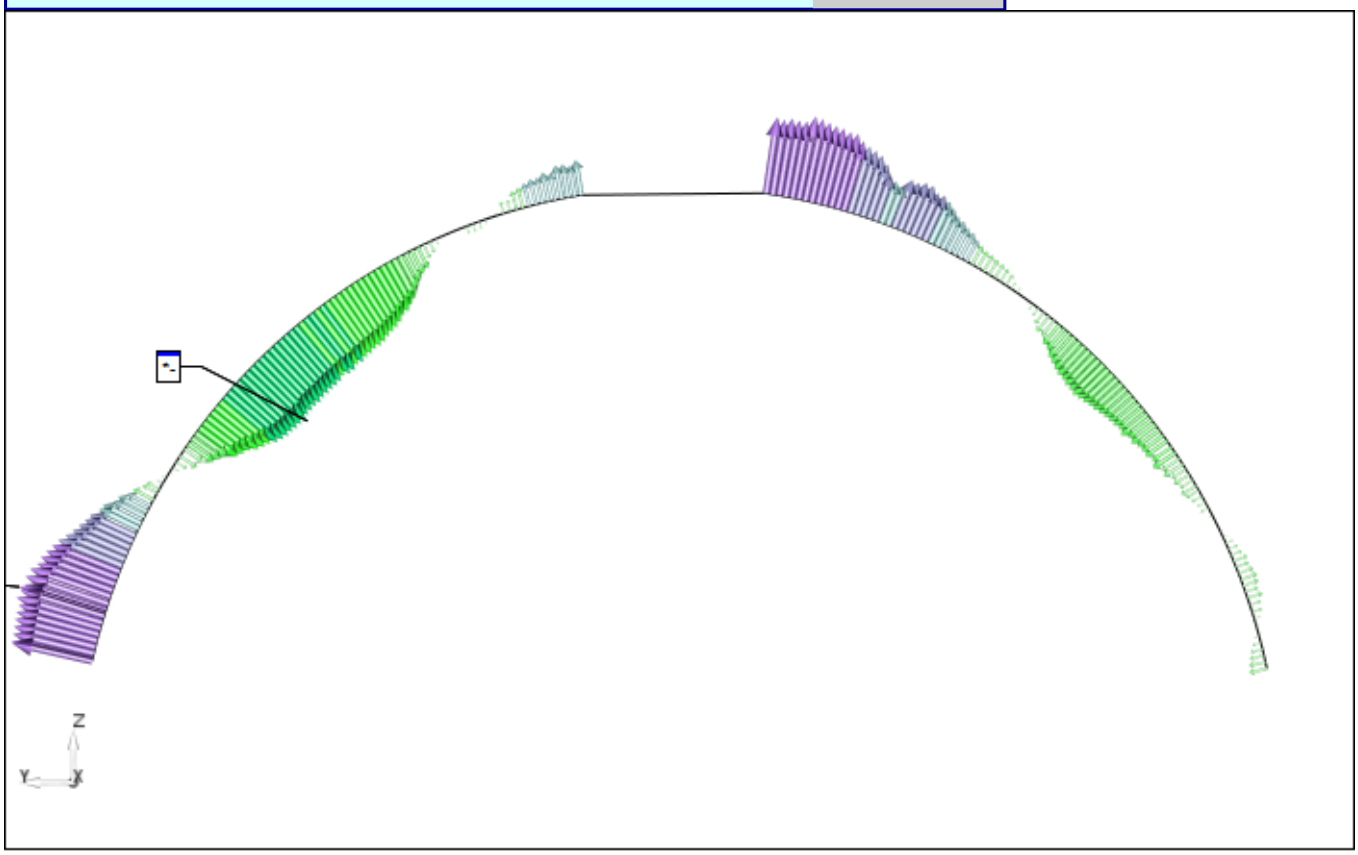
FCFLOC2 Position	MM	⌖ Ø0.2 Ⓜ LF LO

Feature	NOMINAL	MEAS	DEV	OUTTOL	BONUS
FLANGE_LEFT_CIR1	0.000	0.121	0.121	0.000	0.260
FLANGE_LEFT_CIR2	0.000	0.281	0.281	0.000	0.260
FLANGE_LEFT_CIR3	0.000	0.162	0.162	0.000	0.260
FLANGE_LEFT_CIR4	0.000	0.128	0.128	0.000	0.260
FLANGE_LEFT_CIR5	0.000	0.081	0.081	0.000	0.260
FLANGE_LEFT_CIR6	0.000	0.196	0.196	0.000	0.260
FLANGE_LEFT_CIR7	0.000	0.081	0.081	0.000	0.260
FLANGE_LEFT_CIR8	0.000	0.182	0.182	0.000	0.260
FLANGE_LEFT_CIR9	0.000	0.115	0.115	0.000	0.260
FLANGE_LEFT_CIR10	0.000	0.109	0.109	0.000	0.260
FLANGE_LEFT_CIR11	0.000	0.143	0.143	0.000	0.260
FLANGE_LEFT_CIR12	0.000	0.281	0.281	0.000	0.260
FLANGE_LEFT_CIR13	0.000	0.113	0.113	0.000	0.260
FLANGE_LEFT_CIR14	0.000	0.078	0.078	0.000	0.260
FLANGE_LEFT_CIR15	0.000	0.114	0.114	0.000	0.260
FLANGE_LEFT_CIR16	0.000	0.262	0.262	0.000	0.260
FLANGE_LEFT_CIR17	0.000	0.113	0.113	0.000	0.260
FLANGE_LEFT_CIR18	0.000	0.020	0.020	0.000	0.260

FCFLOC2 Datum Shift						
Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	3.949	Fixed

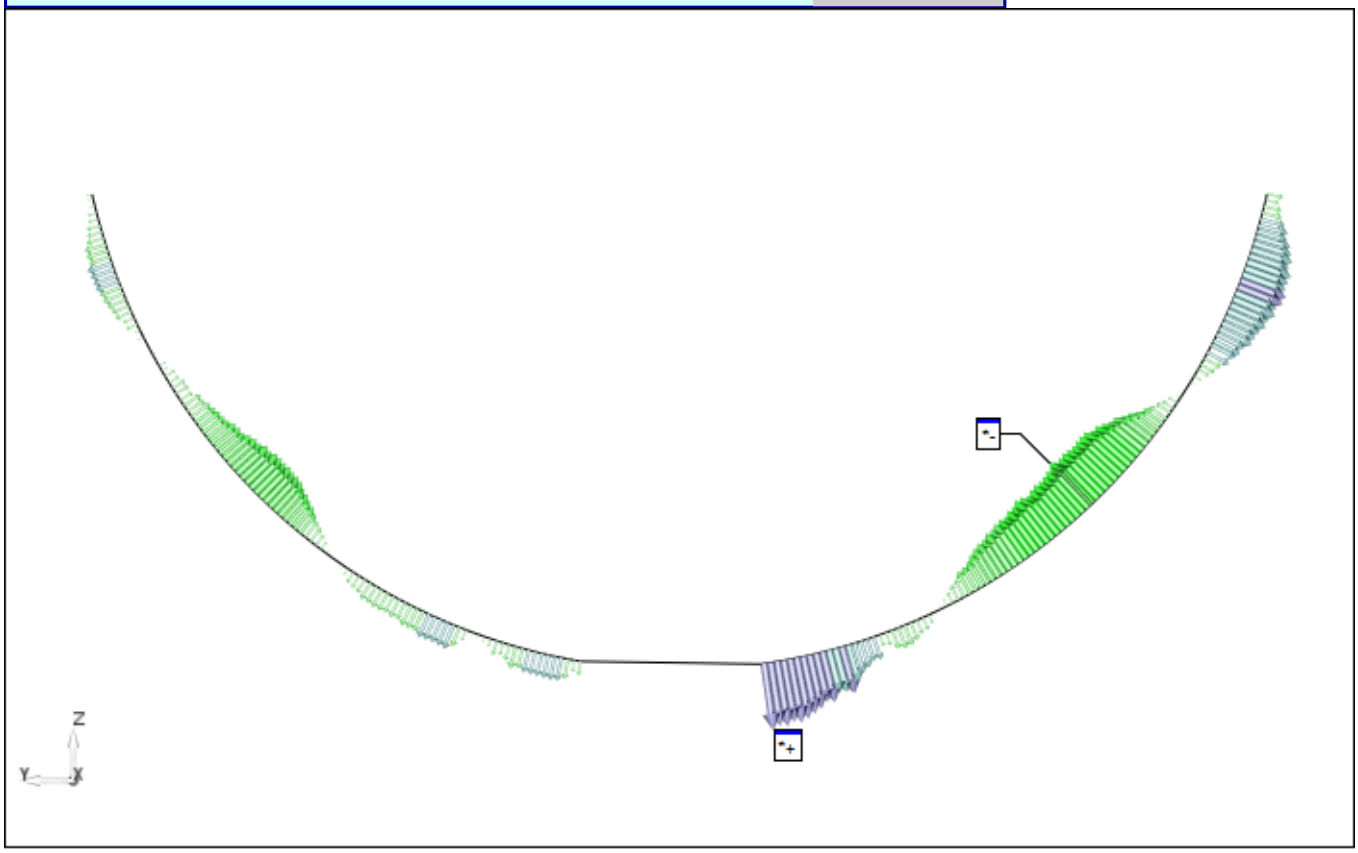
FCFLOC2 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON				
Feature	AX	NOMINAL	MEAS	DEV
FLANGE_LEFT_CIR1	PR	75.800	75.740	-0.060
	PA	90.000	89.998	-0.002
FLANGE_LEFT_CIR2	PR	75.800	75.858	0.058
	PA	110.000	110.097	0.097
FLANGE_LEFT_CIR3	PR	75.800	75.816	0.016
	PA	130.000	129.940	-0.060
FLANGE_LEFT_CIR4	PR	75.800	75.742	-0.058
	PA	150.000	149.979	-0.021
FLANGE_LEFT_CIR5	PR	75.800	75.775	-0.025
	PA	170.000	170.024	0.024
FLANGE_LEFT_CIR6	PR	75.800	75.720	-0.080
	PA	190.000	189.957	-0.043
FLANGE_LEFT_CIR7	PR	75.800	75.761	-0.039
	PA	210.000	209.992	-0.008
FLANGE_LEFT_CIR8	PR	75.800	75.760	-0.040
	PA	230.000	230.062	0.062
FLANGE_LEFT_CIR9	PR	75.800	75.749	-0.051
	PA	250.000	249.980	-0.020
FLANGE_LEFT_CIR10	PR	75.800	75.759	-0.041
	PA	270.000	270.028	0.027
FLANGE_LEFT_CIR11	PR	75.800	75.853	0.053
	PA	290.000	289.964	-0.036
FLANGE_LEFT_CIR12	PR	75.800	75.660	-0.140
	PA	310.000	310.000	-0.001
FLANGE_LEFT_CIR13	PR	75.800	75.857	0.057
	PA	330.000	330.001	0.001
FLANGE_LEFT_CIR14	PR	75.800	75.835	0.035
	PA	350.000	349.988	-0.013
FLANGE_LEFT_CIR15	PR	75.800	75.796	-0.004
	PA	10.000	10.043	0.043
FLANGE_LEFT_CIR16	PR	75.800	75.714	-0.086
	PA	30.000	30.075	0.075
FLANGE_LEFT_CIR17	PR	75.800	75.783	-0.017
	PA	50.000	49.959	-0.041
FLANGE_LEFT_CIR18	PR	75.800	75.791	-0.009
	PA	70.000	69.996	-0.004

FCFPROF1	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.239	0.300	0.000	0.239	0.000



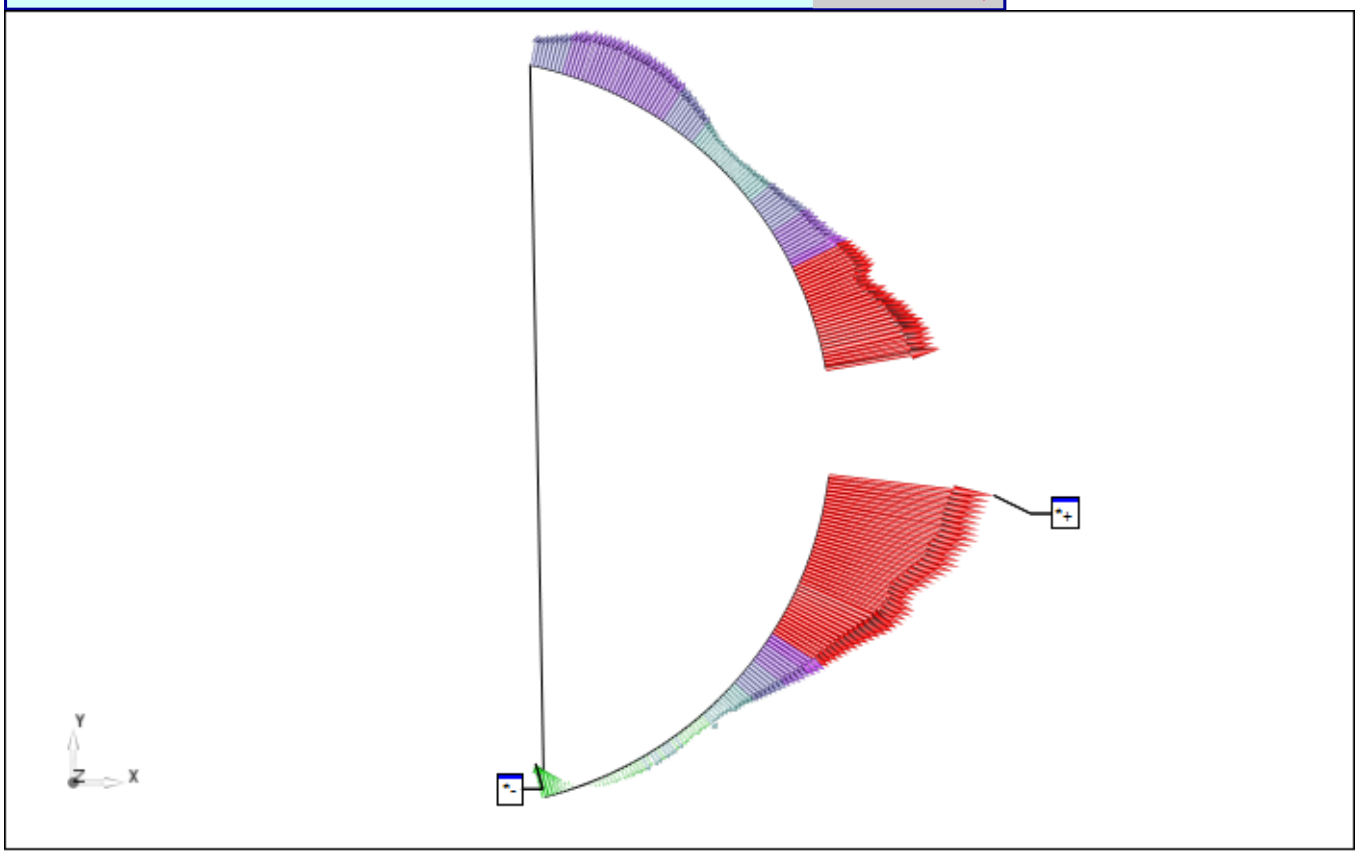
PROFILE OF RIGHT AND LEFT HALF CELLS 12 'O' CLOCK- X100

FCFPROF2	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.182	0.300	0.000	0.182	0.000



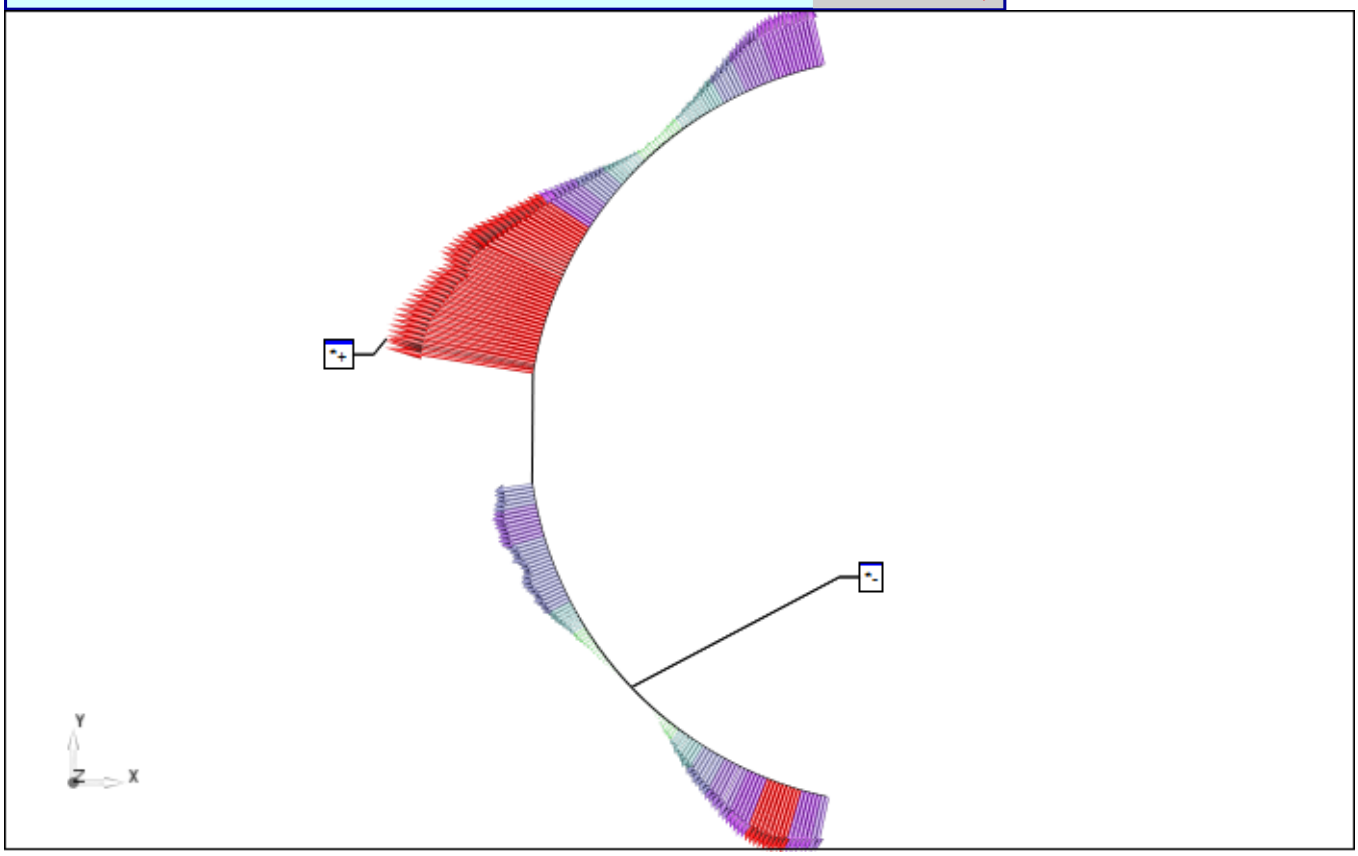
PROFILE OF RIGHT AND LEFT HALF CELLS 6 'O' CLOCK- X100

FCFPROF3	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.462	0.300	0.000	0.462	0.233

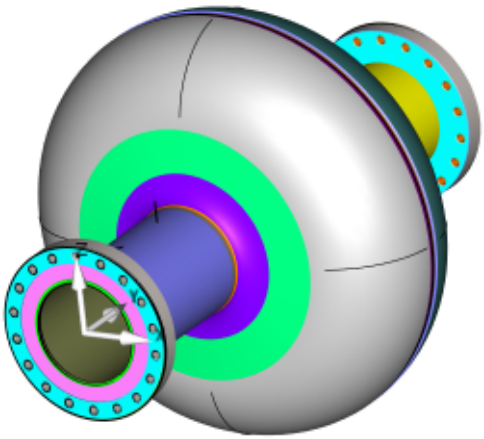


PROFILE OF RIGHT AND LEFT HALF CELLS 3 'O' CLOCK- X100

FCFPROF4	MM	.3	ASME_Y14_5 VECTOR_LST_SQR ABOUT XPLUS			
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Set	0.000	0.350	0.300	0.000	0.350	0.198



PROFILE OF RIGHT AND LEFT HALF CELLS 9 'O' CLOCK- X100



1	MM	FLANGE_RIGHT SURFACE FINISH
AX	NOMINAL	MEAS
M	0.400	0.400

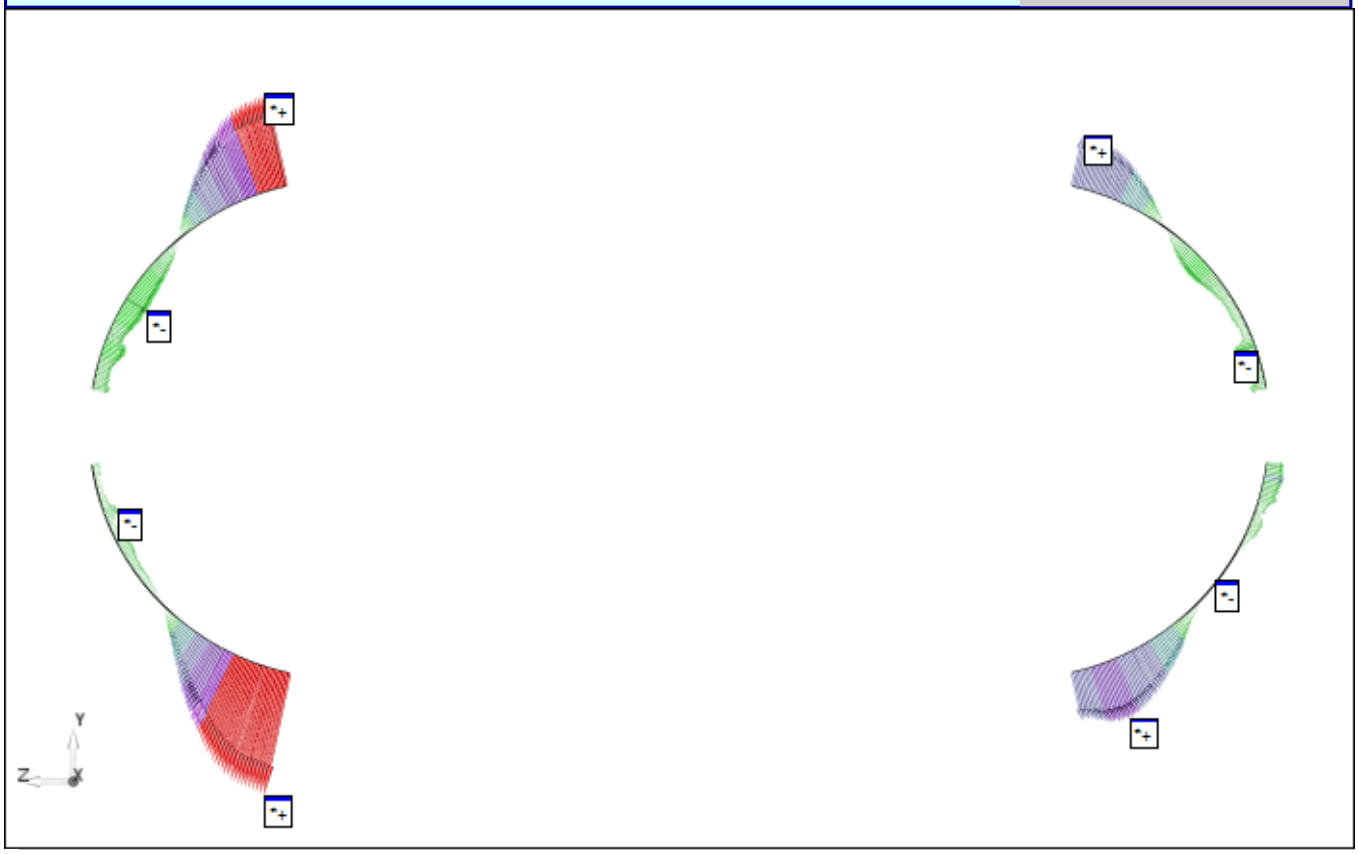
1	MM	FLANGE_LEFT SURFACE FINISH
AX	NOMINAL	MEAS
M	0.400	0.400

⌒	MM	PROF10 - ZPLUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.486	0.437	-0.049

⌒	MM	PROF11 - ZPLUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.413	0.329	-0.085

⌒	MM	PROF14 - ZMINUS_RIGHT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.216	0.213	-0.003

⌒	MM	PROF15 - ZMINUS_LEFT_SCN1 FORMANDLOCATION		
AX		MEAS	MAX	MIN
M		0.252	0.179	-0.073



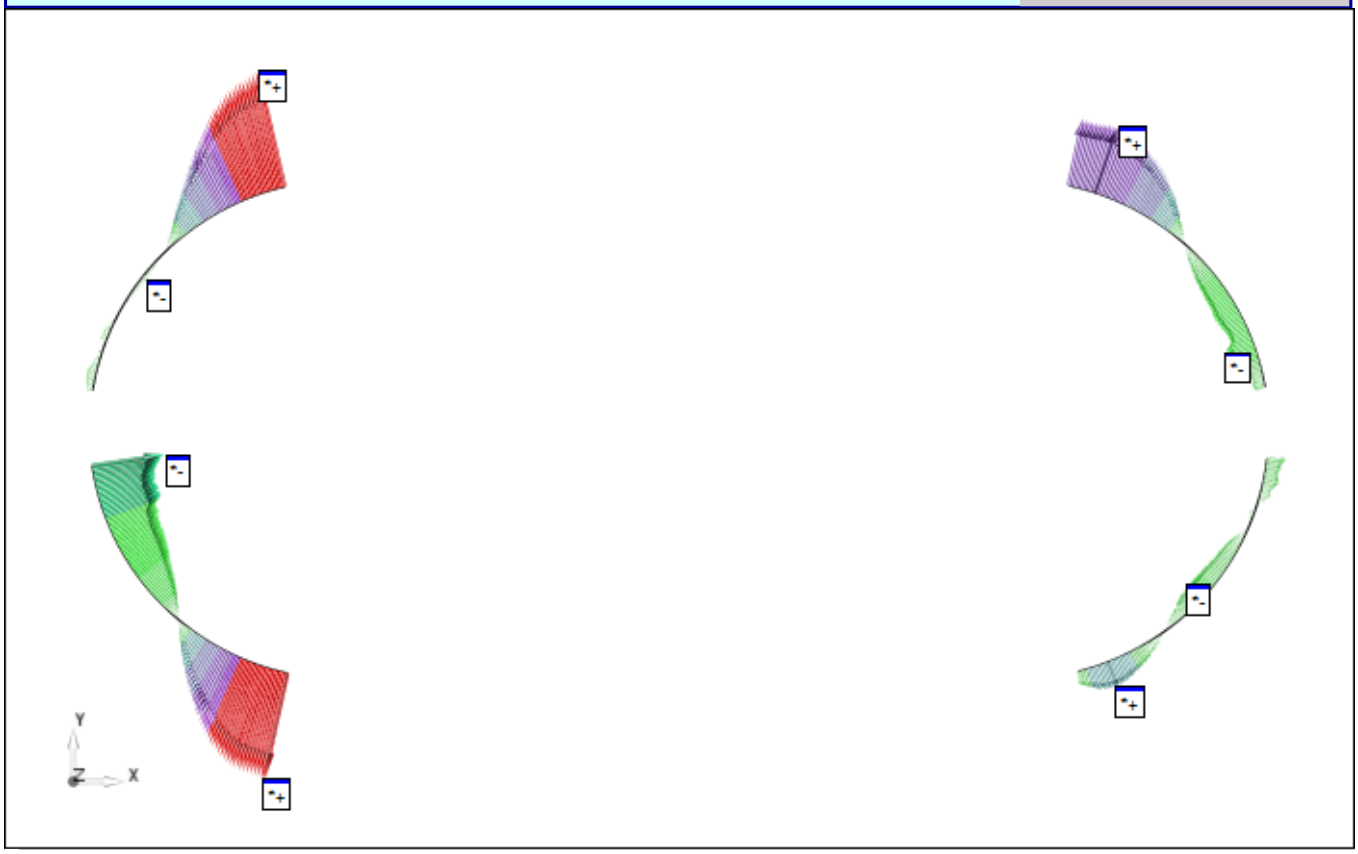
BESTFIT TO ALL 8 SCANS PROFILE OF RIGHT AND LEFT HALF CELLS 12'O' and 6'0'CLOCK -X100

⌒	MM	PROF12 - XPLUS_LEFT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.343	0.242	-0.101	

⌒	MM	PROF13 - XPLUS_RIGHT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.162	0.093	-0.070	

⌒	MM	PROF16 - XMINUS_RIGHT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.633	0.378	-0.255	

⌒	MM	PROF17 - XMINUS_LEFT_SCN1 FORMANDLOCATION		
AX	MEAS	MAX	MIN	
M	0.435	0.417	-0.018	



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