pc-dmis	PART NAME : F10015802_01		October 15, 2014	13:09
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

LCLS-II PRE-PRODUCTION
HELIUM VESSEL WELDMENT

RF#97348 SAMPLE#1
SERIAL NUMBER:RFCG-HE-001
INSPECTOR: O. LIRA

	MM	56 - DATUM_C_PLN							
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL		MAX	MIN
Y	0.000	0.116	0.300	0.000	0.116	0.000		0.248	0.000

	MM	38 - DAT_C_PNT1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.248	3.000	0.000	0.248	0.000

	MM	39 - DAT_C_PNT2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.218	3.000	0.000	0.218	0.000

	MM	40 - DAT_C_PNT3				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.172	3.000	0.000	0.172	0.000

	MM	41 - DAT_C_PNT4				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.052	3.000	0.000	0.052	0.000

	MM	42 - DAT_C_PNT5				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.091	3.000	0.000	0.091	0.000

	MM	43 - DAT_C_PNT6				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.000	3.000	0.000	0.000	0.000

	MM	44 - DAT_C_PNT7				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.058	3.000	0.000	0.058	0.000

	MM	45 - DAT_C_PNT8				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.091	3.000	0.000	0.091	0.000

⌖	MM	4 - LENGTH_PLN							
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL		MAX	MIN
Y	962.316	962.246	0.300	0.300	-0.070	0.000		962.401	962.044

⌖	MM	46 - LENGTH_PNT1					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.044	0.300	0.300	-0.156	0.000	

⌖	MM	47 - LENGTH_PNT2					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.183	0.300	0.300	-0.017	0.000	

⌖	MM	50 - LENGTH_PNT3					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.232	0.300	0.300	0.032	0.000	

⌖	MM	51 - LENGTH_PNT4					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.373	0.300	0.300	0.173	0.000	

⌖	MM	52 - LENGTH_PNT5					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.163	0.300	0.300	-0.037	0.000	

⌖	MM	53 - LENGTH_PNT6					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.401	0.300	0.300	0.201	0.000	

⌖	MM	54 - LENGTH_PNT7					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.270	0.300	0.300	0.070	0.000	

⌖	MM	55 - LENGTH_PNT8					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
Y	962.200	962.303	0.300	0.300	0.103	0.000	

FCFPROF1_ZMINUS_PLATES	MM	⌓ .25 D	ASME_Y14_5

Feature	MEAS	OUTTOL
Set	0.578	0.453

FCFPROF1_ZMINUS_PLATES 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	0.000	0.074

FCFPROF1	MM	⌓ .25 AB	ASME_Y14_5

Feature	MEAS	OUTTOL
DATUM_D_PLN	0.336	0.128

FCFPROF1 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	-0.004	0.000

FCFPARL1_ZMINUS_PADS	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD1_PLN1	0.435	0.185

FCFPARL3	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD2_PLN1	0.278	0.028

FCFPARL4	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD3_PLN1	0.098	0.000

FCFPARL5	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD4_PLN1	0.086	0.000

FCFPARL6	MM	// .25 D

Feature	MEAS	OUTTOL
Z_PLUS_PLATE1_PLN1	0.058	0.000

FCFPARL7	MM	// .25 D

Feature	MEAS	OUTTOL
Z_PLUS_PLATE2_PLN1	0.103	0.000

FCFPERP1	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_MINUS_PAD1_PLN1	0.071	0.000

FCFPERP2	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_MINUS_PAD2_PLN1	0.210	0.000

FCFPERP3	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_PLUS_PAD3_PLN1	0.206	0.000

FCFPERP4	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_PLUS_PAD4_PLN1	0.282	0.032

SIMUL1 Size	MM	Ø235.5 0.25/0

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
DATUM_A_CYL1	235.500	235.596	0.250	0.000	0.096	0.000
DAT_B_CYL1	235.000	234.896	0.000	0.250	-0.104	0.000

SIMUL1 : FCFLOC1 Position	MM	⌖ Ø0.5 Ⓢ AB
SIMUL1 : FCFLOC2 Position	MM	⌖ Ø0.5 Ⓢ AB

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
DATUM_A_CYL1	0.000	0.025	0.500		0.025	0.000
DAT_B_CYL1	0.000	0.069	0.500		0.069	0.000

SIMUL1 Datum Shift

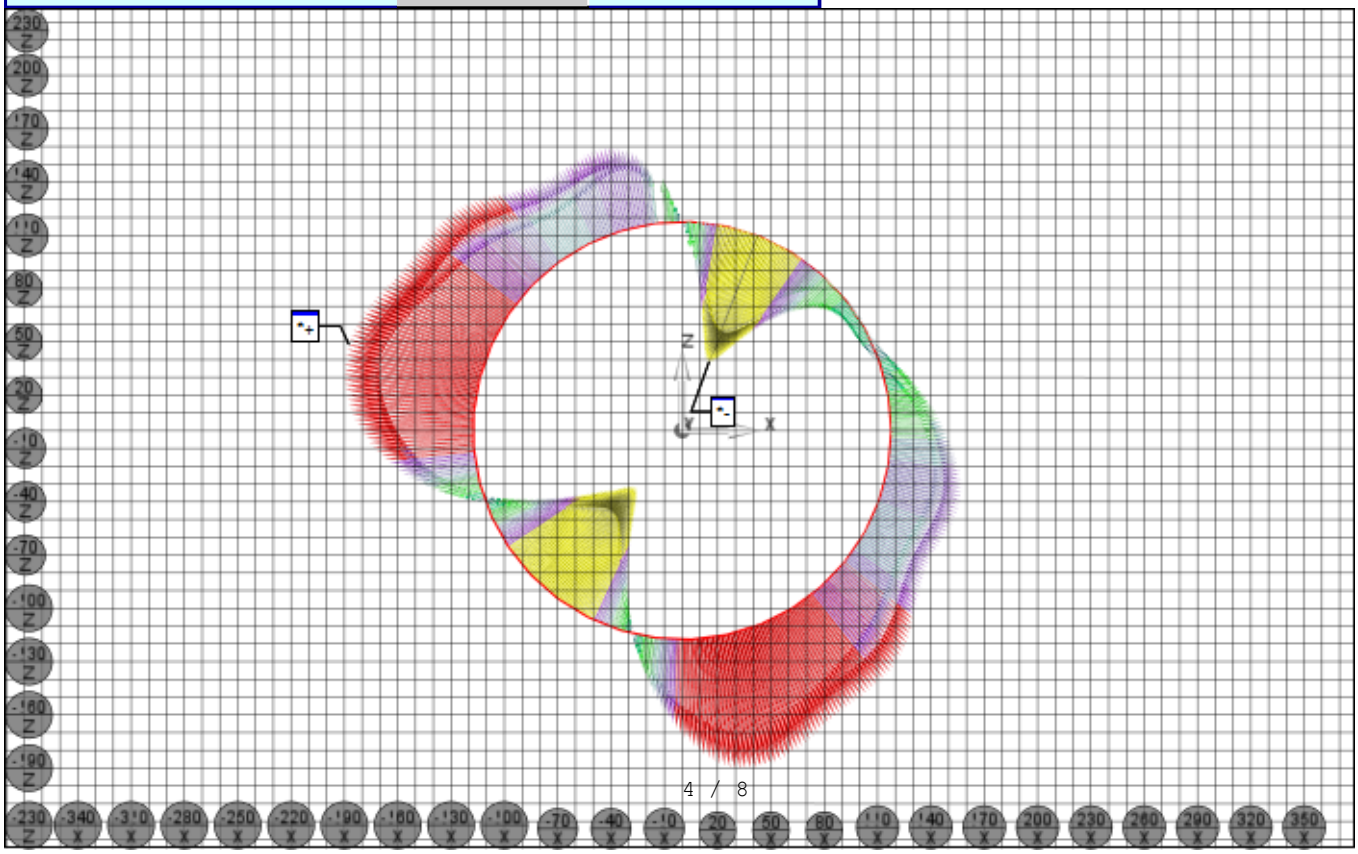
Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	0.000	0.000	0.000	0.000	0.000	0.000

SIMUL1 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON, USE AXIS=WORST

Feature	AX	NOMINAL	MEAS	DEV
DATUM_A_CYL1 (END PT)	X	0.000	-0.003	-0.003
	Z	0.000	0.012	0.012
DAT_B_CYL1 (END PT)	X	0.000	0.004	0.004
	Z	0.000	-0.035	-0.035

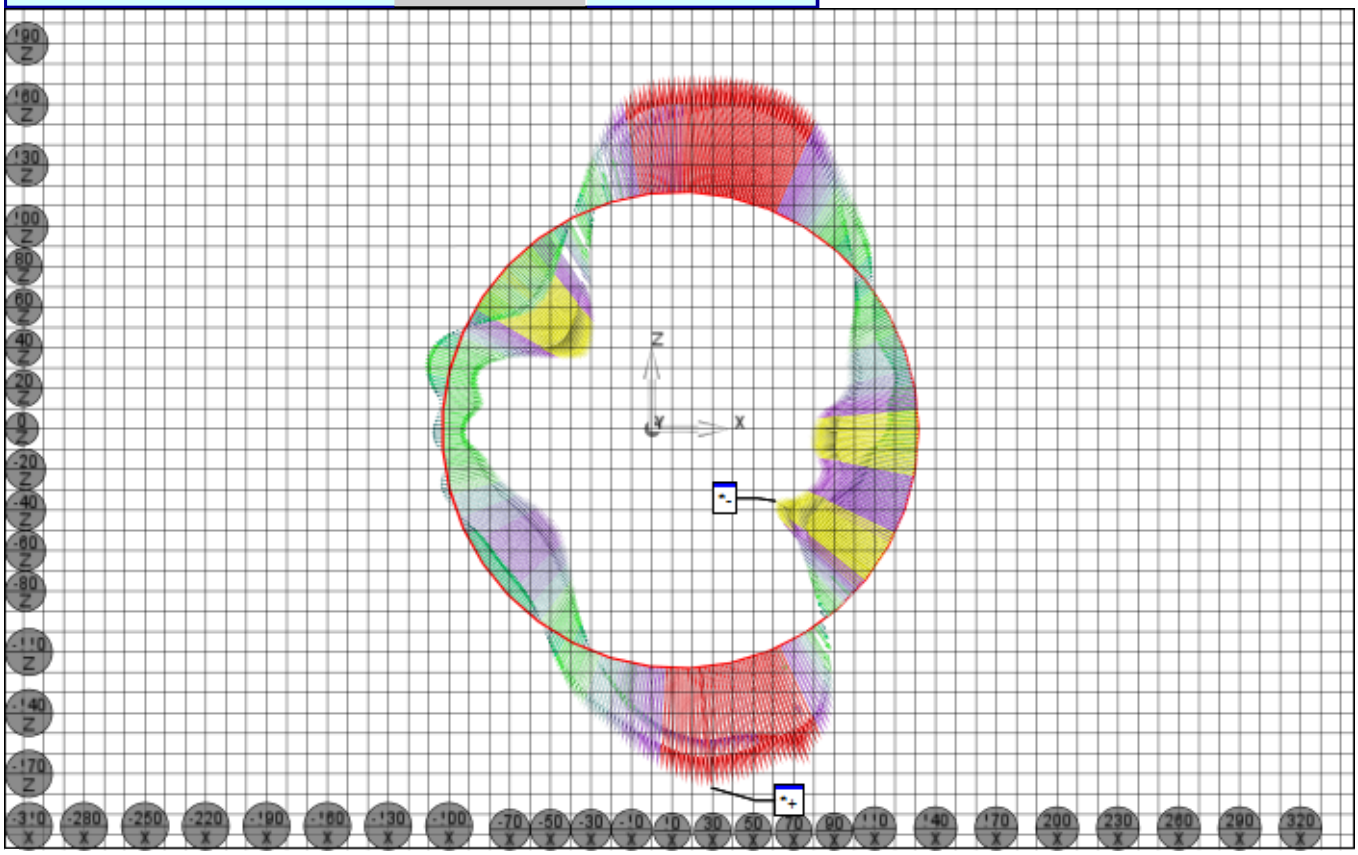
FCFCYLY1	MM	⌭ 1

Feature	MEAS	OUTTOL	MAX	MIN
DATUM_A_CYL1	1.531	0.531	0.765	-0.765



CYLINDRICITY OF DATUM A EXAGGERATION X 100 EACH SQUARE= .10

FCFCYLY2	MM	⌭ 1		
Feature	MEAS	OUTTOL	MAX	MIN
DATUM_B_CYL1	1.185	0.185	0.593	-0.593



CYLINDRICITY OF DATUM B EXAGGERATION X 100 EACH SQUARE= .10

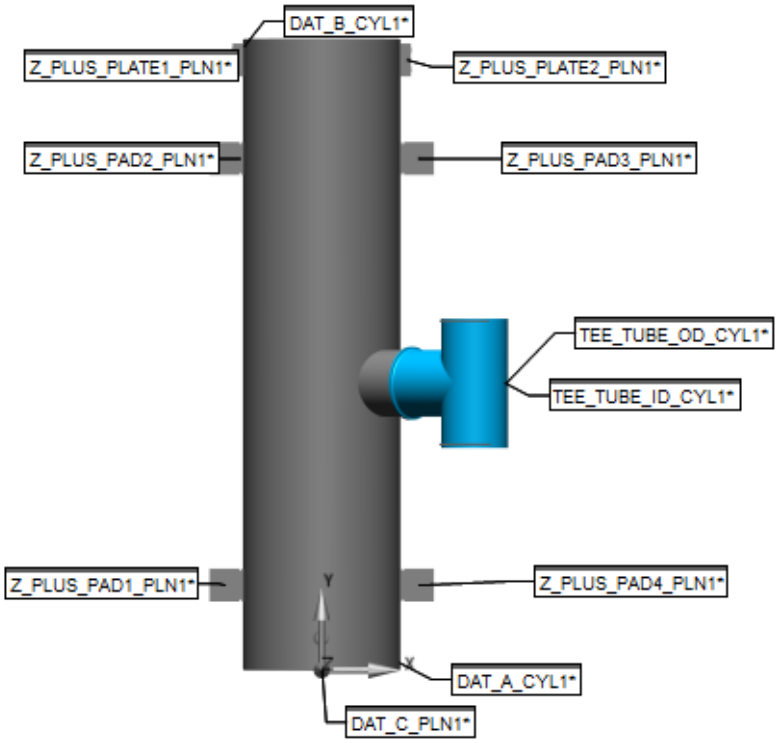
↔	MM	DIST1 - Z_MINUS_PAD1_PLN1 TO Z_PLUS_PAD1_PLN1 (ZAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	24.000	23.291	0.000	0.300	-0.709	0.409	
↔	MM	DIST2 - Z_MINUS_PAD2_PLN1 TO Z_PLUS_PAD2_PLN1 (ZAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	24.000	23.516	0.000	0.300	-0.484	0.184	
↔	MM	DIST3 - Z_MINUS_PAD3_PLN1 TO Z_PLUS_PAD3_PLN1 (ZAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	24.000	24.030	0.000	0.300	0.030	0.030	
↔	MM	DIST4 - Z_MINUS_PAD4_PLN1 TO Z_PLUS_PAD4_PLN1 (ZAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	24.000	23.770	0.000	0.300	-0.230	0.000	
↔	MM	DIST5 - Z_MINUS_PLATE1_PLN1 TO Z_PLUS_PLATE1_PLN1 (ZAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	24.000	23.665	0.000	0.300	-0.335	0.035	
↔	MM	DIST6 - Z_MINUS_PLATE2_PLN1 TO Z_PLUS_PLATE2_PLN1 (ZAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	24.000	24.155	0.000	0.300	0.155	0.155	
↔	MM	DIST7 - X_MINUS_PLATE1_PLN1 TO X_PLUS_PLATE2_PLN1 (XAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	272.000	270.701	0.000	0.300	-1.299	0.999	
↔	MM	DIST8 - X_MINUS_PAD1_PLN1 TO X_PLUS_PAD4_PLN1 (XAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	342.000	341.494	0.000	0.300	-0.506	0.206	
↔	MM	DIST9 - X_MINUS_PAD2_PLN1 TO X_PLUS_PAD3_PLN1 (XAXIS)					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
M	342.000	341.058	0.000	0.300	-0.942	0.642	
⊕	MM	48 - TEE_TUBE_ID_CYL1					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
PR	300.000	298.712	1.000	1.000	-1.288	0.288	
PA	39.000	39.607	1.000	1.000	0.607	0.000	
D	97.384	97.896	0.500	0.550	0.512	0.012	
RN	0.000	1.254	0.100	0.000	1.254	1.154	
⊕	MM	49 - TEE_TUBE_OD_CYL1					
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
PR	300.000	298.722	1.000	1.000	-1.278	0.278	
PA	39.000	39.607	1.000	1.000	0.607	0.000	
D	101.600	101.743	0.500	0.550	0.143	0.000	
RN	0.000	1.271	0.100	0.000	1.271	1.171	

FCFPARL1	MM	// Ø.5 AB

Feature	MEAS	OUTTOL
TEE_TUBE_ID_CYL1	0.461	0.000

FCFPARL2	MM	// Ø.5 AB

Feature	MEAS	OUTTOL
TEE_TUBE_OD_CYL1	0.468	0.000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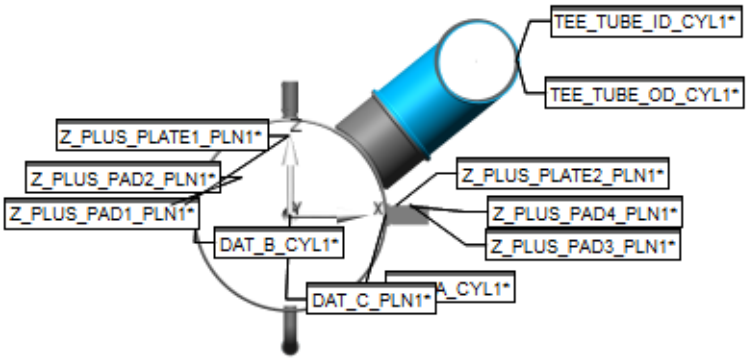
Z_PLUS_PLATE2_PLN1*
Z_PLUS_PAD2_PLN1*
Z_PLUS_PAD3_PLN1*
TEE_TUBE_OD_CYL1*
TEE_TUBE_ID_CYL1*
Z_PLUS_PAD1_PLN1*
Z_PLUS_PAD4_PLN1*
DAT_A_CYL1*
DAT_C_PLN1*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TEE_TUBE_OD_CYL1*
Z_PLUS_PLATE1_PLN1*
Z_PLUS_PAD2_PLN1*
Z_PLUS_PAD1_PLN1*
Z_PLUS_PLATE2_PLN1*
Z_PLUS_PAD4_PLN1*
Z_PLUS_PAD3_PLN1*
DAT_B_CYL1*
DAT_C_PLN1*