pc-dmis	PART NAME : F10015802_06		May 20, 2015	09:16
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

LCLS-II PRE-PRODUCTION
HELIUM VESSEL WELDMENT

RF#98126 SAMPLE#6
SERIAL NUMBER:RFCG-HE-006
INSPECTOR: O. LIRA

⌖	MM	3 - DATUM_C_PLN						
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	MAX	MIN
Y	0.000	0.304	0.300	0.000	0.304	0.004	0.614	0.000

⌖	MM	4 - DAT_C_PNT1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.422	3.000	0.000	0.422	0.000

⌖	MM	5 - DAT_C_PNT2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.442	3.000	0.000	0.442	0.000

⌖	MM	6 - DAT_C_PNT3				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.614	3.000	0.000	0.614	0.000

⌖	MM	7 - DAT_C_PNT4				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.457	3.000	0.000	0.457	0.000

⌖	MM	8 - DAT_C_PNT5				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.284	3.000	0.000	0.284	0.000

⌖	MM	9 - DAT_C_PNT6				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.000	3.000	0.000	0.000	0.000

⌖	MM	10 - DAT_C_PNT7				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.031	3.000	0.000	0.031	0.000

⌖	MM	11 - DAT_C_PNT8				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.178	3.000	0.000	0.178	0.000

⌖	MM	12 - LENGTH_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.884	0.300	0.300	-0.316	0.016

⌖	MM	13 - LENGTH_PNT1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.780	0.300	0.300	-0.420	0.120

⌖	MM	14 - LENGTH_PNT2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.988	0.300	0.300	-0.212	0.000

⌖	MM	15 - LENGTH_PNT3				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	962.001	0.300	0.300	-0.199	0.000

⌖	MM	16 - LENGTH_PNT4				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.837	0.300	0.300	-0.363	0.063

⌖	MM	17 - LENGTH_PNT5				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.628	0.300	0.300	-0.572	0.272

⌖	MM	18 - LENGTH_PNT6				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.905	0.300	0.300	-0.295	0.000

⌖	MM	19 - LENGTH_PNT7				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.968	0.300	0.300	-0.232	0.000

⌖	MM	20 - LENGTH_PNT8				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.964	0.300	0.300	-0.236	0.000

FCFPROF1_ZMINUS_PLATES	MM	⌓ .25 D	ASME_Y14_5

Feature	MEAS	OUTTOL
Set	0.230	0.105

FCFPROF1_ZMINUS_PLATES Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	0.000	0.000	Fixed	Fixed	Fixed	0.088

FCFPROF1	MM	⌓ .25 AB	ASME_Y14_5

Feature	MEAS	OUTTOL
DATUM_D_PLN	0.258	0.133

FCFPROF1 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	0.002	Fixed

FCFPARL1_ZMINUS_PADS	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD1_PLN1	0.077	0.000

FCFPARL3	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD2_PLN1	0.031	0.000

FCFPARL4	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD3_PLN1	0.124	0.000

FCFPARL5	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD4_PLN1	0.047	0.000

FCFPARL6	MM	// .25 D

Feature	MEAS	OUTTOL
Z_PLUS_PLATE1_PLN1	0.131	0.000

FCFPARL7	MM	// .25 D

Feature	MEAS	OUTTOL
Z_PLUS_PLATE2_PLN1	0.040	0.000

FCFPERP1	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_MINUS_PAD1_PLN1	0.025	0.000

FCFPERP2	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_MINUS_PAD2_PLN1	0.043	0.000

FCFPERP3	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_PLUS_PAD3_PLN1	0.049	0.000

FCFPERP4	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_PLUS_PAD4_PLN1	0.029	0.000

SIMUL1 Size	MM	Ø235.5 0.25/0

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
DATUM_A_CYL1	235.500	235.636	0.250	0.000	0.136	0.000
DATUM_B_CYL1	235.000	234.603	0.000	0.250	-0.397	0.147

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	0.092	0.500		0.092	0.000
DATUM_B_CYL1	0.000	0.088	0.500		0.088	0.000

SIMUL1 Datum Shift

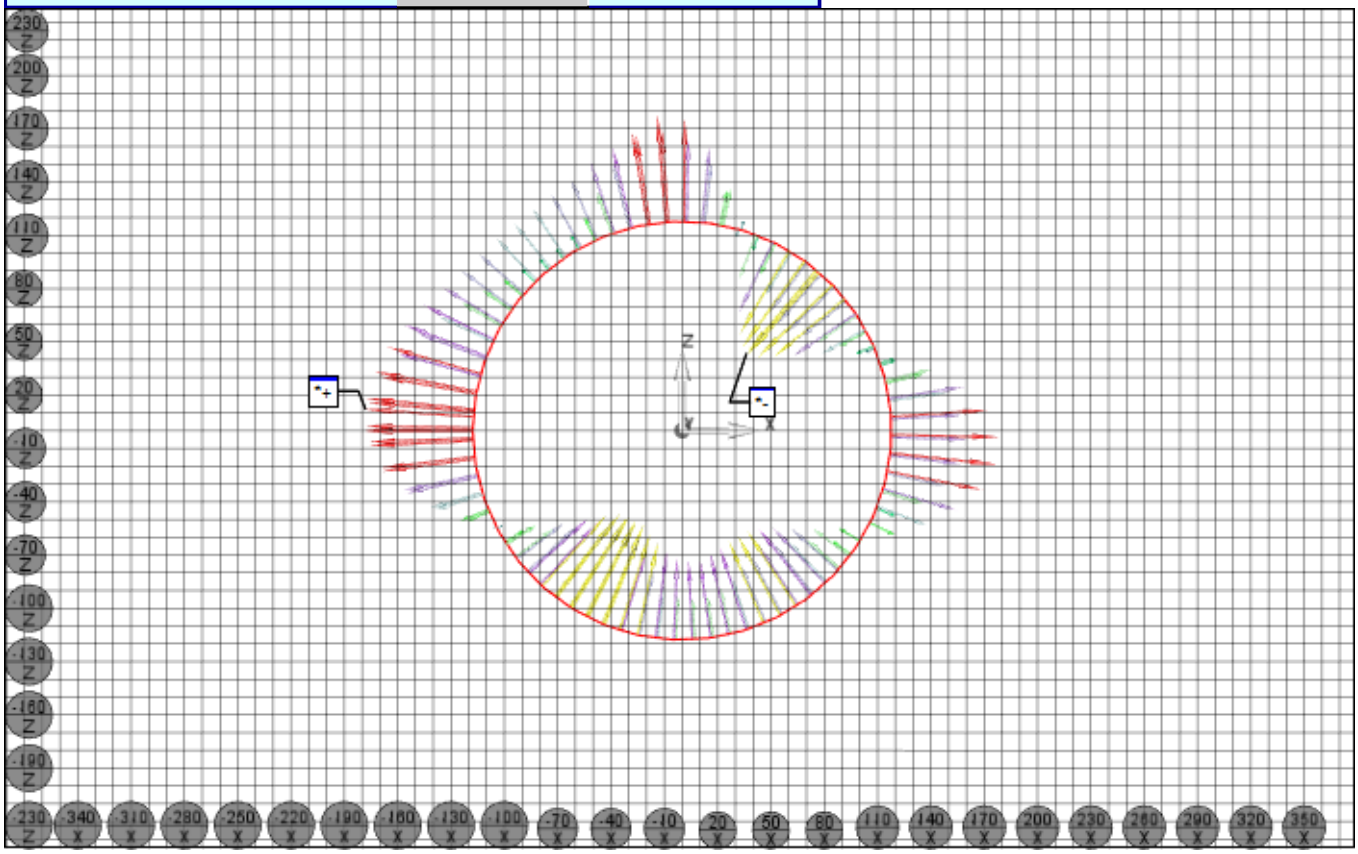
Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	0.000	0.000	0.000	0.000	0.000	0.000

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	0.010	0.010
	Z	0.000	-0.047	-0.047
DATUM_B_CYL1 (END PT)	X	0.000	0.042	0.042
	Z	0.000	-0.002	-0.002

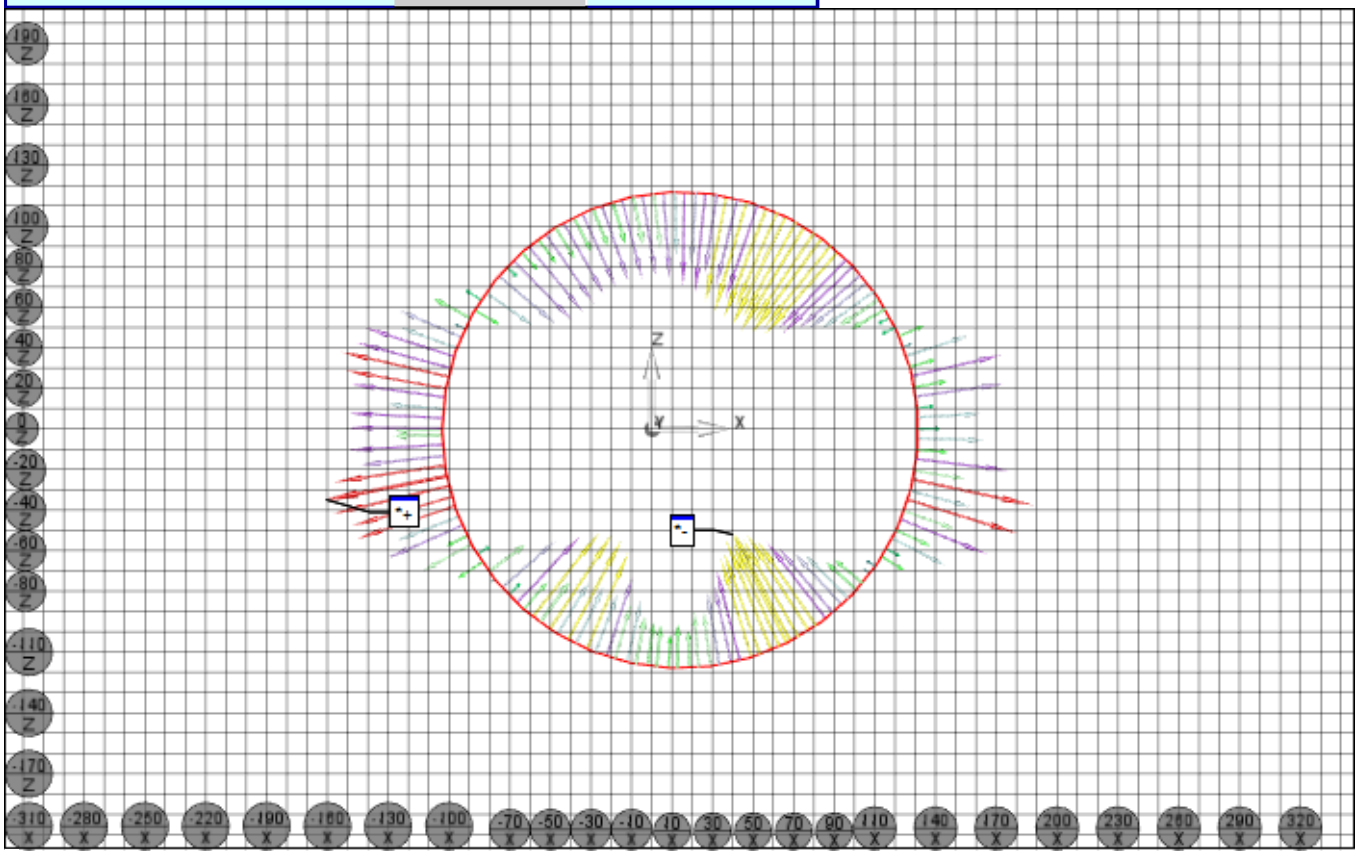
FCFCYLY1	MM	⌭ 1

Feature	MEAS	OUTTOL	MAX	MIN
DATUM_A_CYL1	1.225	0.225	0.613	-0.613



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

FCFCYLY2	MM	⌭ 1		
Feature	MEAS	OUTTOL	MAX	MIN
DATUM_B_CYL1	1.206	0.206	0.603	-0.603



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	23.838	0.000	0.300	-0.162	0.000
↔	MM	DIST2 - Z_MINUS_PAD2_PLN1 TO Z_PLUS_PAD2_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.907	0.000	0.300	-0.093	0.000
↔	MM	DIST3 - Z_MINUS_PAD3_PLN1 TO Z_PLUS_PAD3_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.905	0.000	0.300	-0.095	0.000
↔	MM	DIST4 - Z_MINUS_PAD4_PLN1 TO Z_PLUS_PAD4_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.834	0.000	0.300	-0.166	0.000
↔	MM	DIST5 - Z_MINUS_PLATE1_PLN1 TO Z_PLUS_PLATE1_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.852	0.000	0.300	-0.148	0.000
↔	MM	DIST6 - Z_MINUS_PLATE2_PLN1 TO Z_PLUS_PLATE2_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.850	0.000	0.300	-0.150	0.000
↔	MM	DIST7 - X_MINUS_PLATE1_PLN1 TO X_PLUS_PLATE2_PLN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	272.000	272.739	0.000	0.300	0.739	0.739
↔	MM	DIST8 - X_MINUS_PAD1_PLN1 TO X_PLUS_PAD4_PLN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	342.000	342.368	0.000	0.300	0.368	0.368
↔	MM	DIST9 - X_MINUS_PAD2_PLN1 TO X_PLUS_PAD3_PLN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	342.000	341.969	0.000	0.300	-0.031	0.000
⌖	MM	21 - TEE_TUBE_ID_CYL1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
PR	300.000	298.082	1.000	1.000	-1.918	0.918
PA	39.000	39.130	1.000	1.000	0.130	0.000
D	97.384	97.166	0.500	0.550	-0.218	0.000
RN	0.000	0.678	0.100	0.000	0.678	0.578
⌖	MM	22 - TEE_TUBE_OD_CYL1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
PR	300.000	298.081	1.000	1.000	-1.919	0.919
PA	39.000	39.131	1.000	1.000	0.131	0.000
D	101.600	101.485	0.500	0.550	-0.115	0.000
RN	0.000	0.656	0.100	0.000	0.656	0.556
↔	MM	DIST10 - DAT_C_PLN1 TO Y_MINUS_PAD1_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	104.700	105.058	0.300	0.300	0.358	0.058
↔	MM	DIST11 - DAT_C_PLN1 TO Y_MINUS_PAD4_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	104.700	104.686	0.300	0.300	-0.014	0.000

↔	MM	DIST12 - Y_MINUS_PAD1_PLN1 TO Y_MINUS_PAD2_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	650.000	649.579	0.300	0.300	-0.421	0.121

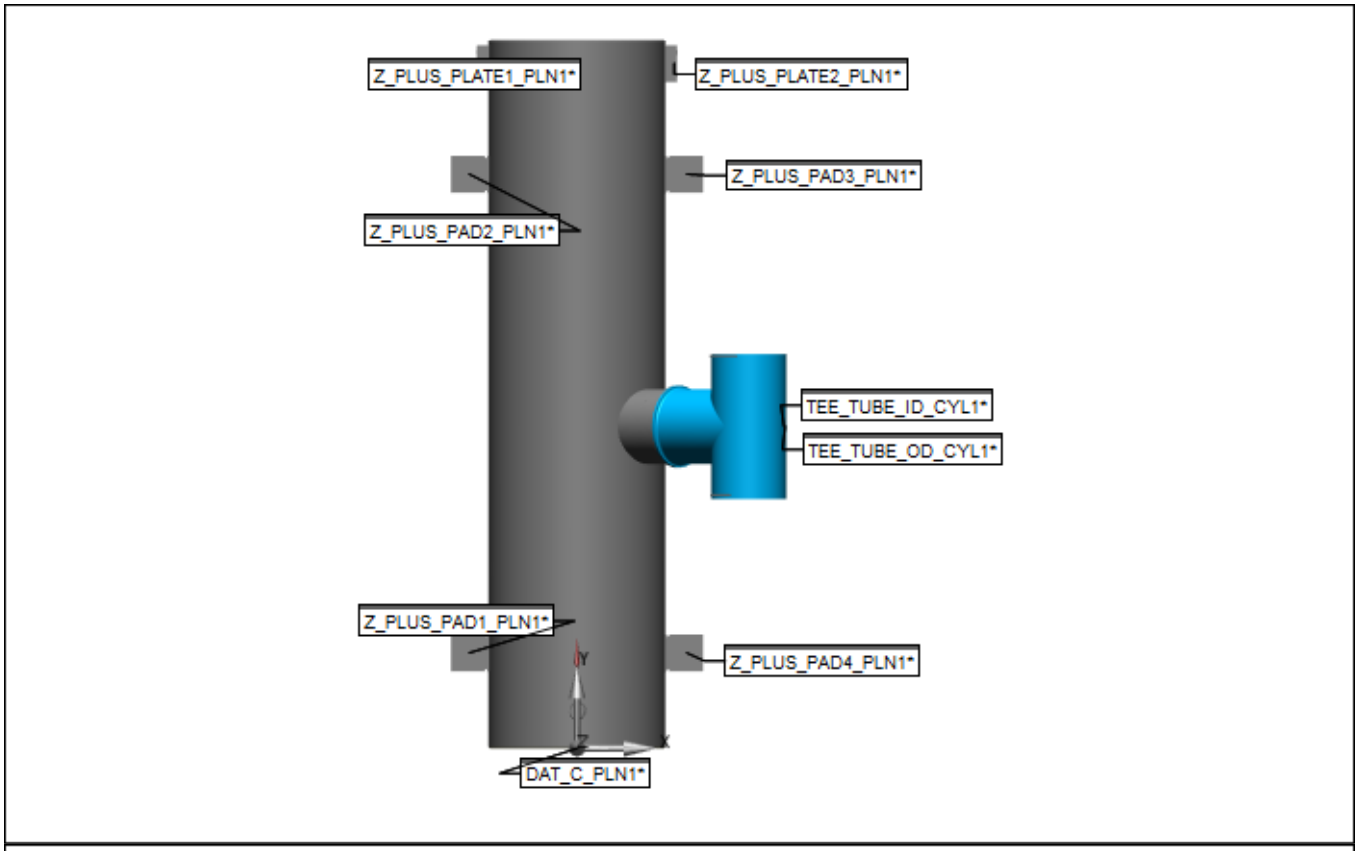
↔	MM	DIST13 - Y_MINUS_PAD4_PLN1 TO Y_MINUS_PAD3_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	650.000	648.268	0.300	0.300	-1.732	1.432

FCFPARL1	MM	// Ø.5 AB

Feature	MEAS	OUTTOL
TEE_TUBE_ID_CYL1	1.068	0.568

FCFPARL2	MM	// Ø.5 AB

Feature	MEAS	OUTTOL
TEE_TUBE_OD_CYL1	1.063	0.563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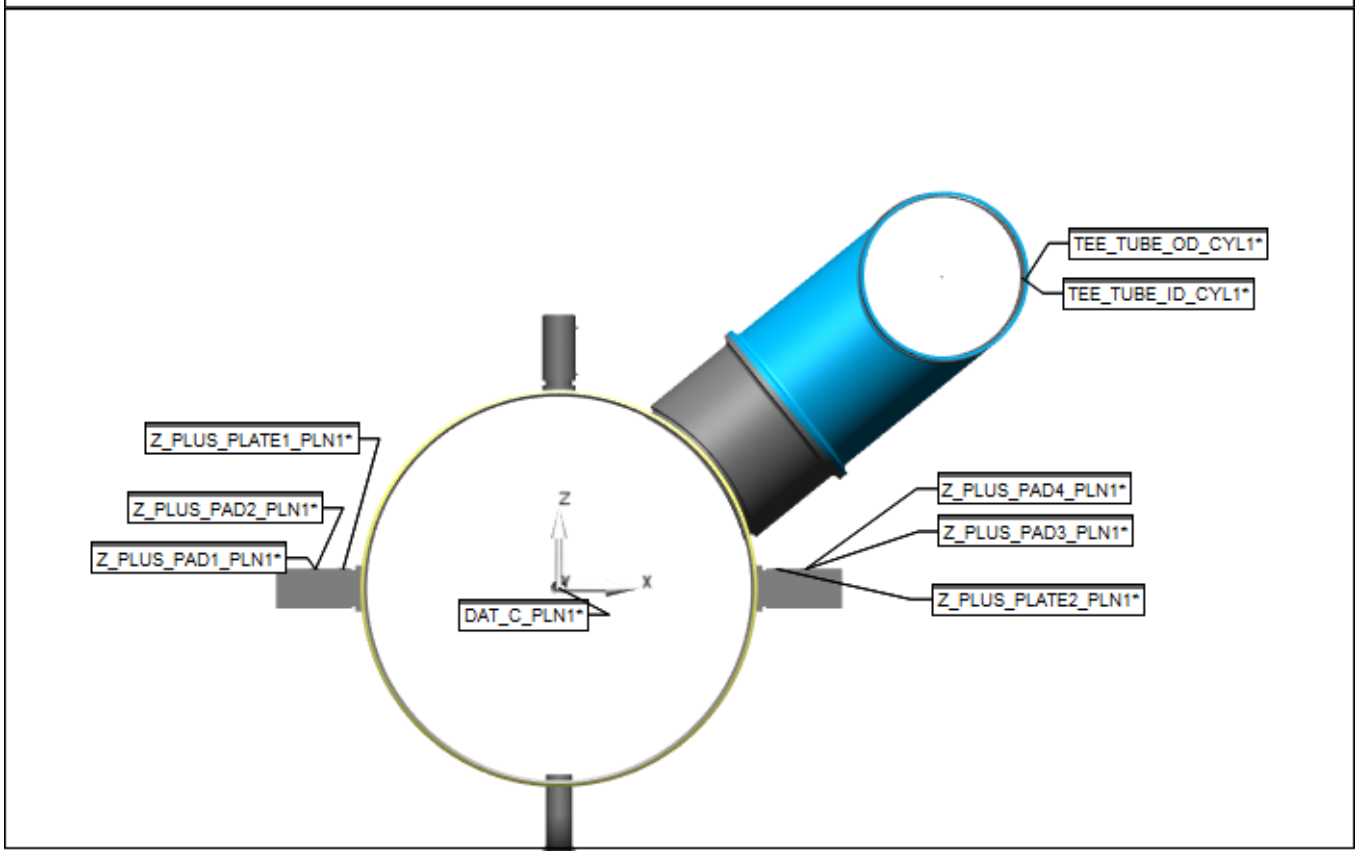
Z_PLUS_PLATE2_PLN1*
Z_PLUS_PAD3_PLN1*
Z_PLUS_PAD2_PLN1*
TEE_TUBE_ID_CYL1*
TEE_TUBE_OD_CYL1*
Z_PLUS_PAD1_PLN1*
Z_PLUS_PAD4_PLN1*
DAT_C_PLN1*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TEE_TUBE_ID_CYL1*
Z_PLUS_PLATE1_PLN1*
Z_PLUS_PAD2_PLN1*
Z_PLUS_PAD1_PLN1*
Z_PLUS_PAD4_PLN1*
Z_PLUS_PAD3_PLN1*
Z_PLUS_PLATE2_PLN1*
DAT_C_PLN1*