pc-dmis	PART NAME : F10015802_10		June 08, 2015	10:12
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

LCLS-II PRE-PRODUCTION
HELIUM VESSEL WELDMENT

RF#98205 SAMPLE#10
SERIAL NUMBER:RFCG-HE-010
INSPECTOR: O. LIRA

⌖	MM	26 - DATUM_C_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.154	0.100	0.100	0.154	0.054
FL	0.000	0.138	0.000	0.000	0.138	0.138

⌖	MM	4 - DAT_C_PNT1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.341	3.000	0.000	0.341	0.000

⌖	MM	5 - DAT_C_PNT2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.309	3.000	0.000	0.309	0.000

⌖	MM	6 - DAT_C_PNT3				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.254	3.000	0.000	0.254	0.000

⌖	MM	7 - DAT_C_PNT4				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.102	3.000	0.000	0.102	0.000

⌖	MM	8 - DAT_C_PNT5				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.116	3.000	0.000	0.116	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	0.023	3.000	0.000	0.023	0.000

⌖	MM	11 - DAT_C_PNT8				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.000	0.089	3.000	0.000	0.089	0.000

⌖	MM	12 - LENGTH_PLN				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	962.089	0.300	0.300	-0.111	0.000

⌖	MM	13 - LENGTH_PNT1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.950	0.300	0.300	-0.250	0.000

⌖	MM	14 - LENGTH_PNT2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	962.235	0.300	0.300	0.035	0.000

⌖	MM	15 - LENGTH_PNT3				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	962.343	0.300	0.300	0.143	0.000

⌖	MM	16 - LENGTH_PNT4				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	962.296	0.300	0.300	0.096	0.000

⌖	MM	17 - LENGTH_PNT5				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.963	0.300	0.300	-0.237	0.000

⌖	MM	18 - LENGTH_PNT6				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	961.712	962.001	0.300	0.300	0.289	0.000

⌖	MM	19 - LENGTH_PNT7				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.934	0.300	0.300	-0.266	0.000

⌖	MM	20 - LENGTH_PNT8				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	962.200	961.993	0.300	0.300	-0.207	0.000

FCFPROF1_ZMINUS_PLATES	MM	⌓ .25 D	ASME_Y14_5

Feature	MEAS	OUTTOL
Set	0.313	0.188

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	0.042

FCFPROF1	MM	⌓ .25 AB	ASME_Y14_5

Feature	MEAS	OUTTOL
DATUM_D_PLN	0.256	0.131

FCFPROF1 Datum Shift

Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	Fixed	Fixed	Fixed	Fixed	-0.018	Fixed

FCFPARL1_ZMINUS_PADS	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD1_PLN1	0.021	0.000

FCFPARL3	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD2_PLN1	0.042	0.000

FCFPARL4	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD3_PLN1	0.087	0.000

FCFPARL5	MM	// .25 D

Feature	MEAS	OUTTOL
Z_MINUS_PAD4_PLN1	0.143	0.000

FCFPARL6	MM	// .25 D

Feature	MEAS	OUTTOL
Z_PLUS_PLATE1_PLN1	0.038	0.000

FCFPARL7	MM	// .25 D

Feature	MEAS	OUTTOL
Z_PLUS_PLATE2_PLN1	0.047	0.000

FCFPERP1	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_MINUS_PAD1_PLN1	0.026	0.000

FCFPERP2	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_MINUS_PAD2_PLN1	0.011	0.000

FCFPERP3	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_PLUS_PAD3_PLN1	0.015	0.000

FCFPERP4	MM	⊥ .25 D

Feature	MEAS	OUTTOL
X_PLUS_PAD4_PLN1	0.039	0.000

SIMUL1 Size	MM	Ø235.5 0.25/0

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
DATUM_A_CYL1	235.500	235.628	0.250	0.000	0.128	0.000
DATUM_B_CYL1	235.000	234.698	0.000	0.250	-0.302	0.052

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	0.066	0.500		0.066	0.000
DATUM_B_CYL1	0.000	0.045	0.500		0.045	0.000

SIMUL1 Datum Shift

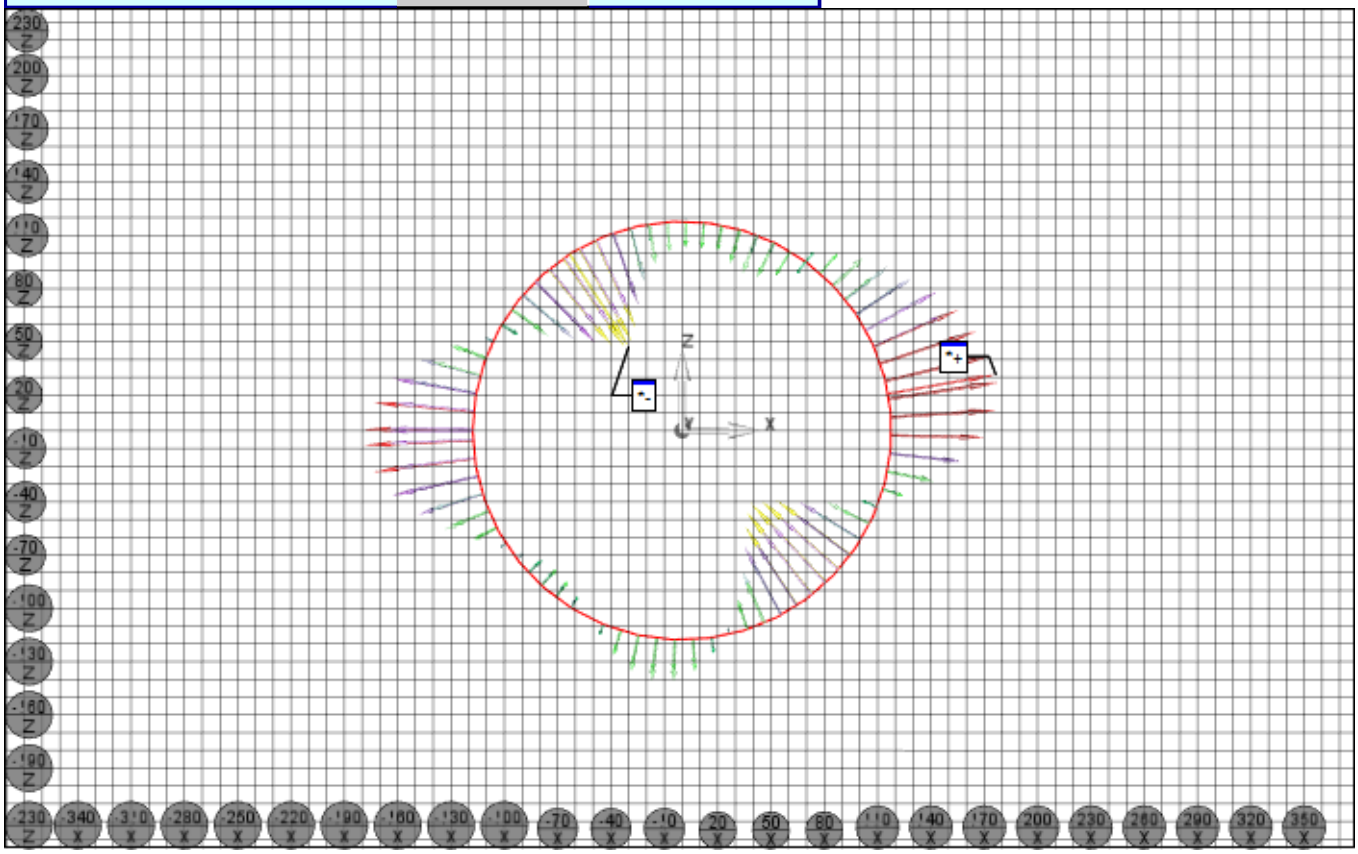
Segment	Shift X	Shift Y	Shift Z	Rotation X	Rotation Y	Rotation Z
Segment 1	0.000	0.000	0.000	0.000	0.000	0.000

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	-0.017	-0.017
	Z	0.000	-0.029	-0.029
DATUM_B_CYL1 (END PT)	X	0.000	0.009	0.009
	Z	0.000	0.020	0.020

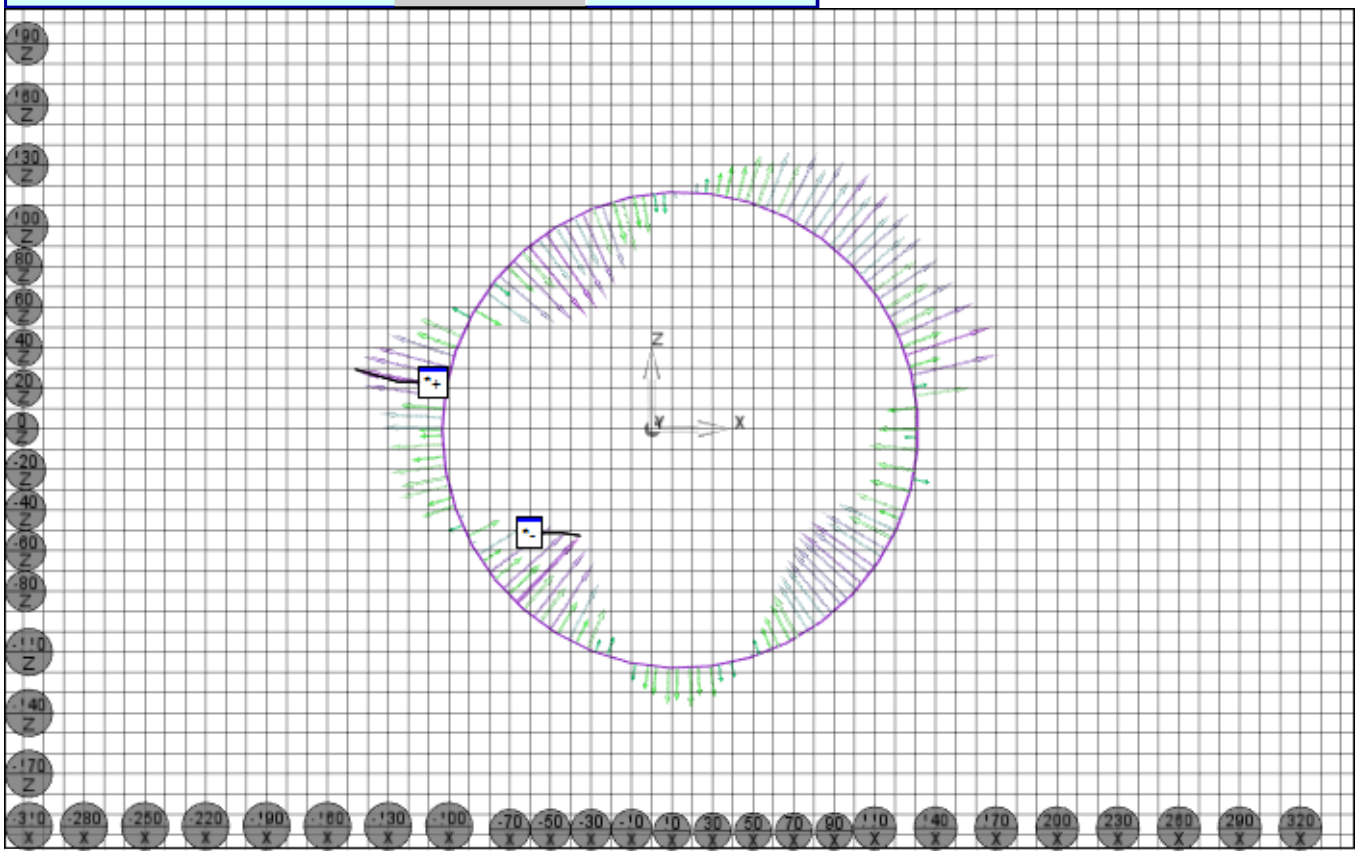
FCFCYLY1	MM	⌭ 1

Feature	MEAS	OUTTOL	MAX	MIN
DATUM_A_CYL1	1.230	0.230	0.615	-0.615



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

FCFCYLY2	MM	⌭ 1			
Feature	MEAS	OUTTOL		MAX	MIN
DATUM_B_CYL1	0.911	0.000		0.455	-0.455



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

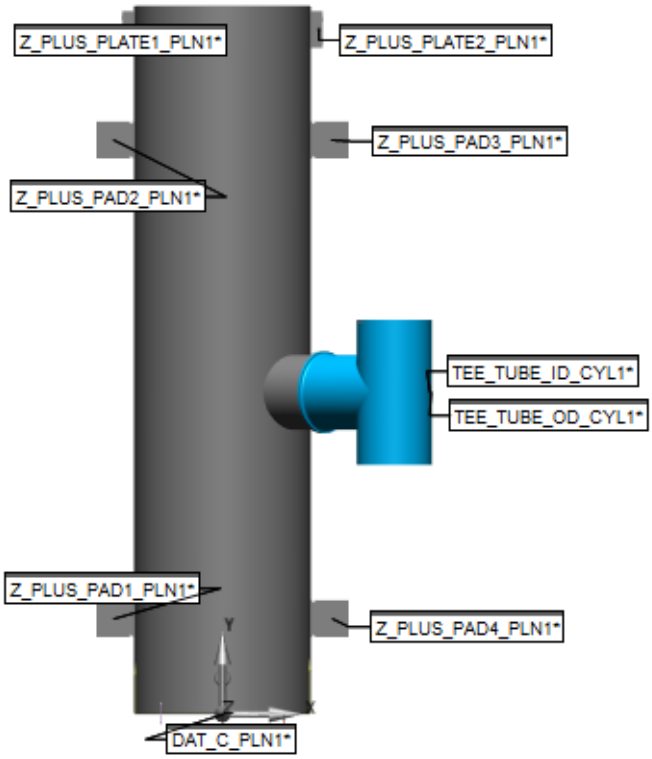
↔	MM	DIST1 - Z_MINUS_PAD1_PLN1 TO Z_PLUS_PAD1_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.729	0.000	0.300	-0.271	0.000
↔	MM	DIST2 - Z_MINUS_PAD2_PLN1 TO Z_PLUS_PAD2_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.812	0.000	0.300	-0.188	0.000
↔	MM	DIST3 - Z_MINUS_PAD3_PLN1 TO Z_PLUS_PAD3_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.808	0.000	0.300	-0.192	0.000
↔	MM	DIST4 - Z_MINUS_PAD4_PLN1 TO Z_PLUS_PAD4_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.690	0.000	0.300	-0.310	0.010
↔	MM	DIST5 - Z_MINUS_PLATE1_PLN1 TO Z_PLUS_PLATE1_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.900	0.000	0.300	-0.100	0.000
↔	MM	DIST6 - Z_MINUS_PLATE2_PLN1 TO Z_PLUS_PLATE2_PLN1 (ZAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	24.000	23.892	0.000	0.300	-0.108	0.000
↔	MM	DIST7 - X_MINUS_PLATE1_PLN1 TO X_PLUS_PLATE2_PLN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	272.000	271.856	0.000	0.300	-0.144	0.000
↔	MM	DIST8 - X_MINUS_PAD1_PLN1 TO X_PLUS_PAD4_PLN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	342.000	342.084	0.000	0.300	0.084	0.084
↔	MM	DIST9 - X_MINUS_PAD2_PLN1 TO X_PLUS_PAD3_PLN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	342.000	341.758	0.000	0.300	-0.242	0.000
⌖	MM	21 - TEE_TUBE_ID_CYL1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
PR	300.000	299.598	1.000	1.000	-0.402	0.000
PA	39.000	38.983	1.000	1.000	-0.017	0.000
D	97.384	97.206	0.500	0.550	-0.178	0.000
RN	0.000	0.697	0.100	0.000	0.697	0.597
⌖	MM	22 - TEE_TUBE_OD_CYL1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
PR	300.000	299.594	1.000	1.000	-0.406	0.000
PA	39.000	38.985	1.000	1.000	-0.015	0.000
D	101.600	101.437	0.500	0.550	-0.163	0.000
RN	0.000	0.688	0.100	0.000	0.688	0.588
↔	MM	DIST10 - DAT_C_PLN1 TO Y_MINUS_PAD1_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	104.681	104.656	0.300	0.300	-0.025	0.000
↔	MM	DIST11 - DAT_C_PLN1 TO Y_MINUS_PAD4_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	104.681	104.914	0.300	0.300	0.233	0.000

↔	MM	DIST12 - Y_MINUS_PAD1_PLN1 TO Y_MINUS_PAD2_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	650.000	649.707	0.300	0.300	-0.293	0.000

↔	MM	DIST13 - Y_MINUS_PAD4_PLN1 TO Y_MINUS_PAD3_PLN1 (YAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	650.000	649.491	0.300	0.300	-0.509	0.209

FCFPARL1	MM	// Ø.5 AB
Feature	MEAS	OUTTOL
TEE_TUBE_ID_CYL1	0.824	0.324

FCFPARL2	MM	// Ø.5 AB
Feature	MEAS	OUTTOL
TEE_TUBE_OD_CYL1	0.838	0.338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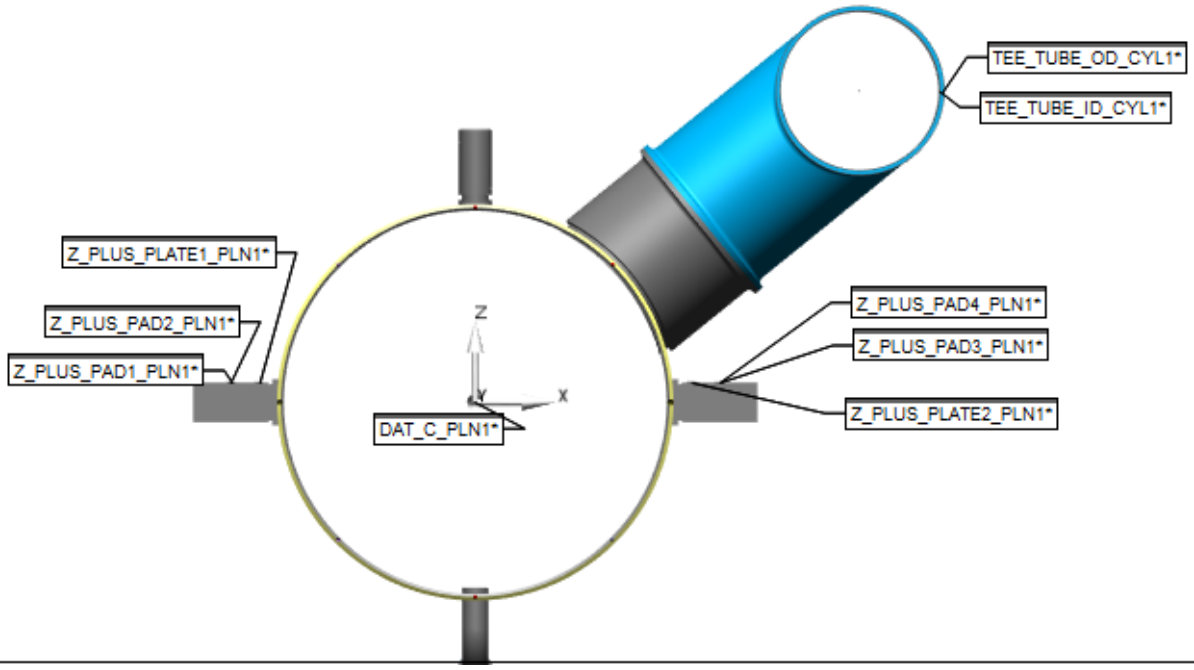
Z_PLUS_PLATE2_PLN1*
Z_PLUS_PAD3_PLN1*
Z_PLUS_PAD2_PLN1*
TEE_TUBE_ID_CYL1*
TEE_TUBE_OD_CYL1*
Z_PLUS_PAD1_PLN1*
Z_PLUS_PAD4_PLN1*
Y
DAT_C_PLN1*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TEE_TUBE_ID_CYL1*
Z_PLUS_PLATE1_PLN1*
Z_PLUS_PAD2_PLN1*
Z_PLUS_PAD1_PLN1*
Z
X
DAT_C_PLN1*
Z_PLUS_PAD4_PLN1*
Z_PLUS_PAD3_PLN1*
Z_PLUS_PLATE2_PLN1*