

**National Center for Nuclear Research NCBJ Świerk-Otwock  
Department of Nuclear Equipment ZdAJ  
Metrology Report**



Part name	<b>Ring Wave Guide</b>	11-11-07	13:50
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Drawing No	<b>SPLACPMZ0016p8</b>	Part No	<b>551011_143</b>	PAGE 1 OF 1
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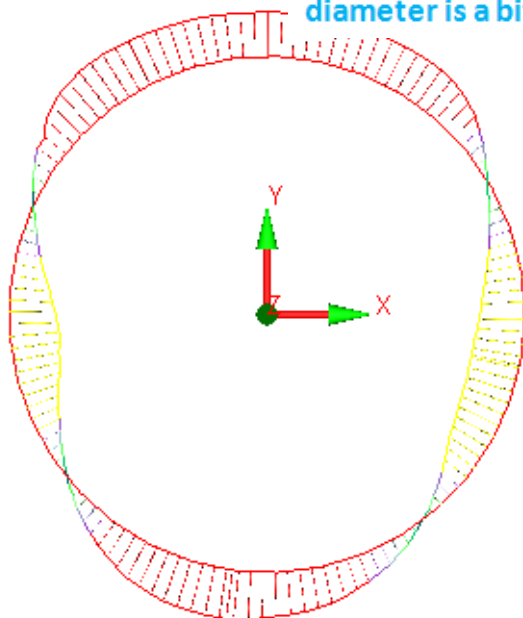
⌀	MM	DIAM 516.72 - IN DIAM 516.72
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AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL	Absolute value of mean diameter
D	516.720	0.500	0.500	515.455	-1.265	-0.765	

CIRC OF DIAM 516	MM	0.1
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Feature	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL	BONUS	ellipticity
IN DIAM 516.72	0.000	0.100		0.198	0.198	0.098		

ellipticity is ok (rough machining  $\pm 0.2$ , fine machining  $\pm 0.1$ )  
diameter is a bit too small => allowed to machine a bit more



←→	MM	DIST 301 - PLN REF D TO PNT1 (YAXIS)
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AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	301.000	0.010	0.010	301.010	0.010	0.000

LOC OF REF D Position	MM	0.1 A B
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Feature	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL	BONUS
PLN REF D	0.000	0.100		0.073	0.073	0.000	0.000

LOC OF REF D Datum Shift
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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	0.008

REF B TO REF A	MM	0.1 A
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Feature	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL	BONUS
PLN REF A	0.000	0.100	0.000	0.043	0.043	0.000	0.000