









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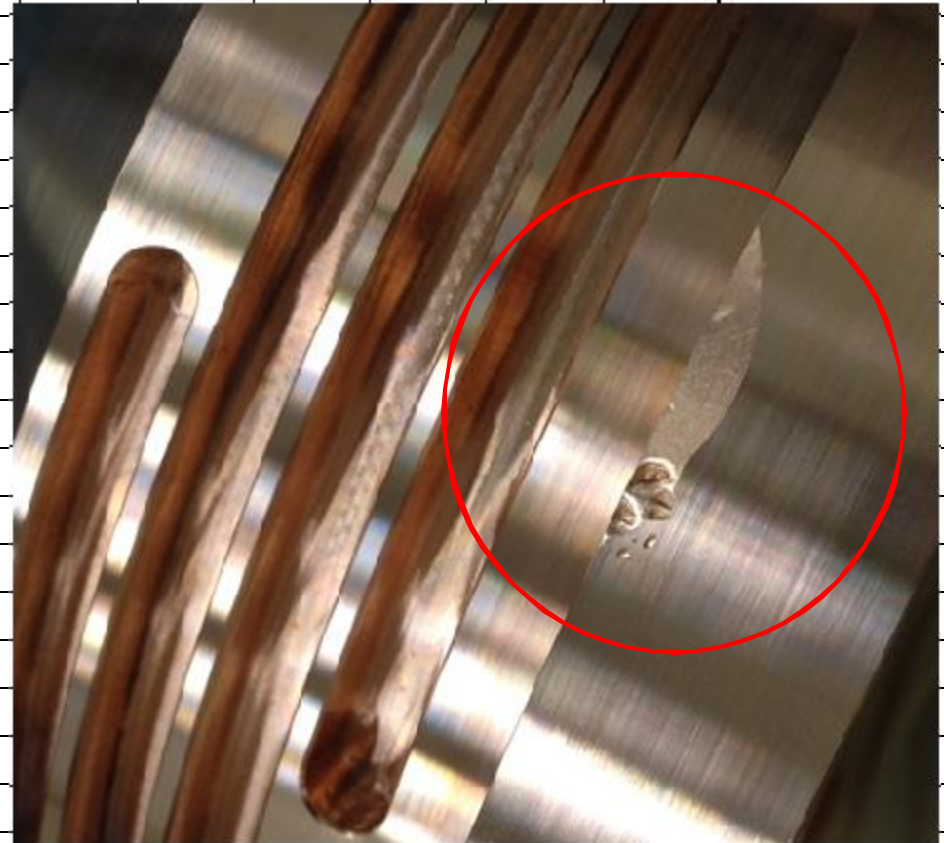
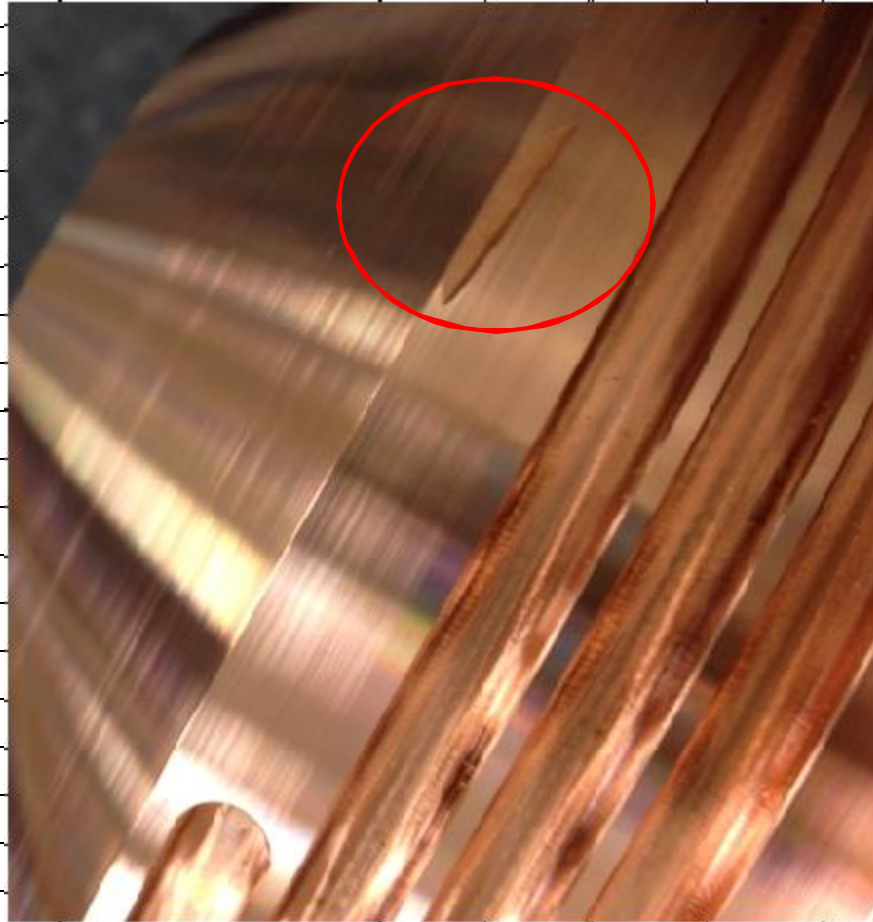
PART NAME:	HALF SPHERE LOWER ROUGH			REC'D:	2	ENGR.:	HAASE	DATE:	February 9, 2015
DRAWING NO.:	PF-380-616-19	REV:	0	INSP'D:	2	EXT.:	8612	INSP.:	K. CABAN
VENDOR:	KLYSTRON MACHINE SHOP			ACC'D:	0	NCR PDF	BALLOON DRAWING		Adobe Acrobat Document
WORK ORDER/SHOP NO.:	M-24799	SEQ ID:	30-FF	REJ'D:	2				
CHARGE NO.:	12664-A8001	Heat Lot #:	K2497.2	NCR:	YES				

		SERIAL NO.		101	102					INSPECTION METHOD
Dim #	Nominal	USL	LSL							
1	Ø5.750	5.755	5.745	5.74942	5.74978					CMM
2	 .002	0.002	0.000	0.00007	0.00005					CMM
3	Ø.970	0.975	0.965	0.96980	0.96991					CMM
4	 Ø.014 A B	0.014	0.000	0.00012	0.00021					CMM
5	SR2.284 ±.003	2.287	2.281	2.28381	2.28377					CMM
6	 Ø.009 A B	0.009	0.000	0.00064	0.00051					CMM
7	.101	0.106	0.096	0.10073	0.10081					CMM
8	.524 ±.001	0.525	0.523	0.52426	0.52424					CMM
9	1.674	1.679	1.669	1.67446	1.67429					CMM
10	1.076	1.081	1.071	1.07592	1.07602					CMM
11	.227	0.232	0.222	0.22707	0.22706					CMM
12	Ø5.250 ±.001	5.251	5.249	5.25018	5.25022					CMM
13	 Ø.014 A B	0.014	0.000	0.00015	0.00044					CMM
14	Ø1.410	1.415	1.405	1.41126	1.41126					CMM
15	 Ø.014 A B	0.014	0.000	0.00020	0.00049					CMM
16	R.020	0.025	0.015	0.01880	0.01650					FormTracer
17	R.012 ±.002	0.014	0.010	0.01090	0.01150					FormTracer
18	R.020	0.025	0.015	0.02050	0.01650					FormTracer
19	15.0°	16.5	15.5	15.60096	16.27843					CMM
20	1.074 ±.002	1.076	1.072	1.07775	1.07730					CMM
21	.250 PITCH	0.255	0.245	0.25000	0.25000					CMM
22	.137	0.192	0.182	0.18770	0.18840					CMM


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Dim #	Nominal	SERIAL NO. 		101	102						INSPECTION METHOD
		USL	LSL								
23	.052	0.067	0.057	0.05900	0.06250						CMM
24	.188	0.193	0.183	0.18750	0.18750						CMM
25	37.0°	37.5	36.5	37.00218	37.05873						CMM
26		32	0	10.58700	13.33800						FormTracer
27	R 1.125	1.130	1.120	1.12505	1.12507						CMM

SURFACE DINGS SN 102 ONLY



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		SERIAL NO. 		101		102							INSPECTION METHOD
Dim #	Nominal	USL	LSL										
Notes:													