

Quindos Measuring Report



3D-Application Center

Description		Customer	D. WALZ
Drawing Number		Serial Number	09
Remarks		Article Number	
Supplier		Delivery Date	
Delivery Note		Delivery Volume	
Lot Number		Lot Size	
Test Schedule		Sample Size	
Production Machine		Production Tool	
Production Date		Production Time	
Order	8540022	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	11-NOV-2009, 14:18:39
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9294
User Name	kcaban	WKP Name	NO\$NAME

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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DAT\$PLA_YN PLA

FORM	0.00033
MIN	-0.00008
MAX	0.00025

DAT\$PLA_YP PLA

FORM	0.00018
MIN	-0.00007
MAX	0.00011

PAR_POLES PLA

PARALL	0.00097
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DYAVG_P600 AXI

DY	0.60169	0.60000	0.00169
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DY_P600(1) AXI

DY	0.60200	0.60000	0.00200
X	-1.12496		
Z	-1.37495		

DY_P600(2) AXI

DY	0.60179	0.60000	0.00179
X	1.12505		
Z	-1.37492		

DY_P600(3) AXI

DY	0.60172	0.60000	0.00172
X	0.00003		
Z	0.00007		

DY_P600(4) AXI

DY	0.60162	0.60000	0.00162
X	-1.12496		
Z	1.37508		

DY_P600(5) AXI

DY	0.60129	0.60000	0.00129
X	1.12504		



Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 11-Nov-09, 14:18:39						NO\$NAME	Page 1 of 3

Date: 11-Nov-09, 14:18:39			NO\$NAME			Page 2 of 3	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

DY_P600(5) AXI ◀
 Z 1.37510

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 ! TOOLING BALL DATA IN CNC\$CSY !
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TBA_PLA(1) PLA
 FORM 0.00033 0.00000 0.00033

TBA_CYL(1) CYL
 FORM 0.00081
 DM 0.25031 0.25000 0.00031

PLA_BORE(1) PLA
 SQRNES 0.00065 0.00000 0.00065

TB_CALC(1) POI
 X 3.48867
 Y 5.48663
 Z 1.61746

TBA_PLA(2) PLA
 FORM 0.00028 0.00000 0.00028

TBA_CYL(2) CYL
 FORM 0.00031
 DM 0.25037 0.25000 0.00037

PLA_BORE(2) PLA
 SQRNES 0.00039 0.00000 0.00039

TB_CALC(2) POI
 X 3.48173
 Y 5.48593
 Z -1.64198

TBA_PLA(3) PLA
 FORM 0.00012 0.00000 0.00012

TBA_CYL(3) CYL
 FORM 0.00080
 DM 0.25033 0.25000 0.00033

PLA_BORE(3) PLA
 SQRNES 0.00054 0.00000 0.00054

TB_CALC(3) POI
 X -3.50671
 Y 5.48645
 Z -1.61422

TBA_PLA(4) PLA
 FORM 0.00010 0.00000 0.00010

TBA_CYL(4) CYL
 FORM 0.00033
 DM 0.25031 0.25000 0.00031

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 11-Nov-09, 14:18:39			NO\$NAME			Page 2 of 3	

Date: 11-Nov-09, 14:18:39			NO\$NAME			Page 3 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

PLA_BORE(4)

			PLA				
SQRNES		0.00034	0.00000			0.00034	

TB_CALC(4)

			POI				
X		-3.49745					
Y		5.48930					
Z		1.64349					

TBA_PLA(5)

			PLA				
FORM		0.00011	0.00000			0.00011	

TBA_CYL(5)

			CYL				
FORM		0.00096					
DM		0.25003	0.25000			0.00003	

PLA_BORE(5)

			PLA				
SQRNES		0.00021	0.00000			0.00021	

TB_CALC(5)

			POI				
X		-6.24530					
Y		0.00633					
Z		1.63996					

TBA_PLA(6)

			PLA				
FORM		0.00025	0.00000			0.00025	

TBA_CYL(6)

			CYL				
FORM		0.00083					
DM		0.24975	0.25000			-0.00025	

PLA_BORE(6)

			PLA				
SQRNES		0.00059	0.00000			0.00059	

TB_CALC(6)

			POI				
X		-6.25224					
Y		-0.01640					
Z		-1.62145					

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 11-Nov-09, 14:18:39			NO\$NAME			Page 3 of 3	