

Quindos Measuring Report



3D-Application Center

Description	55MM DIA STD CUP	Customer	L. GARCIA
Drawing Number	PF-380-606-01 Rev. 3	Serial Number	101 Heat Lot #K1959.9
Remarks		Article Number	
Supplier	L. GARCIA	Delivery Date	
Delivery Note		Delivery Volume	
Lot Number		Lot Size	
Test Schedule		Sample Size	
Production Machine		Production Tool	
Production Date		Production Time	
Order	7730028	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	26-OCT-2009, 11:32:49
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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! ---- Flatness of Datum A

DATUM_A		PLA					
FORM		0.00190	0.00000	0.00300	0.00000	0.00190	

! ---- Diameter 50.99 +0.000/-0.015 of Datum B and Perpendicularity to Datum A

DATUM_B		CYL					
FORM		0.00105					
DM		50.98443	50.99000	0.00000	-0.01500	-0.00557	

CYL\$FRM_B		CYL					
CYLFRM		0.00093	0.00000			0.00093	

SQRNS_A		AXI					
SQRNES		0.00014	0.00000	0.01500	0.00000	0.00014	

! ---- Distance 2.87 ± 0.100

PLA_2P87		PLA					
FORM		0.00197					
Z		-2.86818	2.87000	0.10000	-0.10000	-0.00182	

! ---- Diameter 55 ± 0.025 and Location

DIA_55		CYL					
FORM		0.00565					
DM		55.00241	55.00000	0.02500	-0.02500	0.00241	

POS_55		AXI					
POSITN		0.00054	0.00000	0.00500	0.00000	0.00054	

! ---- Diameter 10 ± 0.005 and Location

DIA_10		CIR					
FORM		0.00170					
DM		9.99984	10.00000	0.00500	-0.00500	-0.00016	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 26-Oct-09, 11:32:50						NO\$NAME	Page 1 of 4

POS_10		POI					
	POSITN	0.00154	0.00000	0.00500	0.00000	0.00154	

! ---- Profile 'x - y' |0.01|A|B| (bilateral)

ACNO(1)							
	MIN	-0.00331	0.00000	0.00500	-0.00500	0.00331	
	MAX	0.00416	0.00000	0.00500	-0.00500	0.00416	

ACNO(2)							
	MIN	-0.00374	0.00000	0.00500	-0.00500	0.00374	
	MAX	0.00293	0.00000	0.00500	-0.00500	0.00293	

ACNO(3)							
	MIN	-0.00443	0.00000	0.00500	-0.00500	0.00443	
	MAX	0.00234	0.00000	0.00500	-0.00500	0.00234	

ACNO(4)							
	MIN	-0.00120	0.00000	0.00500	-0.00500	0.00120	
	MAX	0.00512	0.00000	0.00500	-0.00500	0.00512	

! ---- Diameter 29.787 ± 0.005 and Location of Datum C

DATUM_C		CYL					
	FORM	0.00149					
	DM	29.78570	29.78700	0.00500	-0.00500	-0.00130	

POS_C		AXI					
	POSITN	0.00400	0.00000	0.00500	0.00000	0.00400	

! ---- Diameter 51.003 + 0.015/-0.000 and Location

DIA_51P003		CIR					
	FORM	0.00796					
	DM	51.00810	51.00300	0.01500	0.00000	0.00510	

POS_51P003		POI					
	POSITN	0.00510	0.00000	0.00500	0.00000	0.00510	

! ---- Distance 2.000 ± 0.005

PLA_2		PLA					
	FORM	0.00084					
	Z	-1.99631	2.00000	0.00500	-0.00500	-0.00369	

! ---- Distance 8.747 ± 0.005 and Parallelism to Datum A

PLA_8P747		PLA					
	FORM	0.00176					
	Z	-8.74050	8.74700	0.00500	-0.00500	-0.00650	

PAR_8P747		PLA					
	PARALL	0.00405	0.00000	0.00300	0.00000	0.00405	

! ---- Distance 10.747 ± 0.100

PLA_10P747		PLA					
	FORM	0.00212					
	DM	10.74437	10.74700	0.10000	-0.10000	-0.00263	

Date: 26-Oct-09, 11:32:50			NO\$NAME			Page 3 of 4	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

! ---- Radius 3.43 ± 0.130 and Location (measured to each other)

RAD_3P43(1)		CIR					
FORM		0.00060					
RA		3.42036	3.43000	0.13000	-0.13000	-0.00964	
X		-0.00014	0.00000			0.00014	
Y		12.52546	12.52350			0.00196	

POS_3P43(1)		POI					
POSITN		0.00393	0.00000	0.05000	0.00000	0.00393	

RAD_3P43(2)		CIR					
FORM		0.00107					
RA		3.43021	3.43000	0.13000	-0.13000	0.00021	
X		-0.01571	0.00000			0.01571	
Y		-12.52395	12.52350			0.00045	

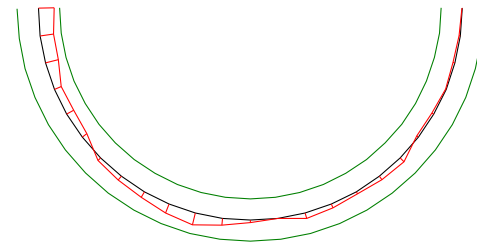
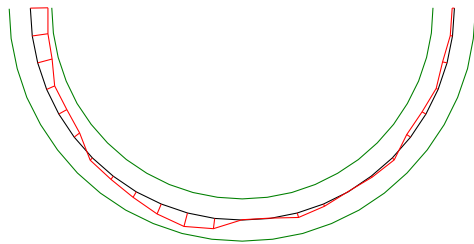
POS_3P43(2)		POI					
POSITN		0.03144	0.00000	0.05000	0.00000	0.03144	

! ---- Distance 0.1 ± 0.025

DIST_P1(1)		AXI					
DZ		0.09726	0.10000	0.02500	-0.02500	-0.00274	

DIST_P1(2)		AXI					
DZ		0.09356	0.10000	0.02500	-0.02500	-0.00644	

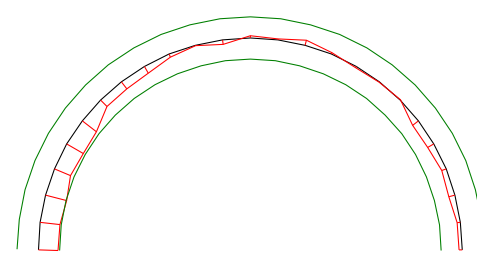
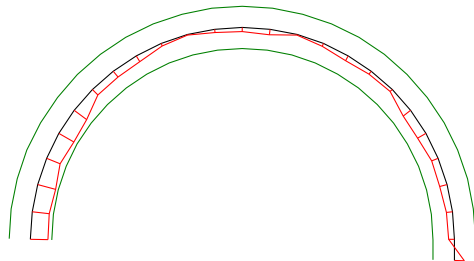
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 26-Oct-09, 11:32:50			NO\$NAME			Page 3 of 4	



AT 0 deg

AT 90 deg

BEAM →



AT 180 deg

AT 270 deg

MESSTECHNIK WETZLAR



55MM DIA STD CUP, IRIS PROFILE

DRAWING #: PF-380-606-01 REV 3

CELL NUMBER: 101 Heat Lot #K1959.9

CHARGE #: 7730028

BLK = NOMINAL

RED = DEVIATIONS

GRN = +/- .005 TOL

DATE: 26-OCT-2009