

Quindos Measuring Report



3D-Application Center

Description	LENS GROUND TUBE	Customer	R. ATKINSON
Drawing Number	PF-391-225-29	Serial Number	001
Remarks		Article Number	
Supplier	MFD (ROLAND)	Delivery Date	
Delivery Note		Delivery Volume	
Lot Number		Lot Size	
Test Schedule		Sample Size	
Production Machine		Production Tool	
Production Date		Production Time	
Order	24251-18	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	02-FEB-2009, 11:17:51
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.8350-B
User Name	kcaban	WKP Name	pf39122529

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DAT\$PLA_A		PLA					
FORM		0.00016	0.00000	0.00500	0.00000	0.00016	
DIST_P350		AXI					
DX		0.35074	0.35000	0.00500	-0.00500	0.00074	
POS_P350		AXI					
X		0.00167	0.00000	0.00500	-0.00500	0.00167	
DIA_P194(1)		CIR					
DM		0.19975	0.19400	0.01000	-0.00200	0.00575	
POS_P194(1)		POI					
POSITN		0.00307	0.00000	0.01400	0.00000	0.00307	
POS_P194(2)		POI					
POSITN		0.00363	0.00000	0.01400	0.00000	0.00363	
POS_P194(3)		POI					
POSITN		0.00503	0.00000	0.01400	0.00000	0.00503	
POS_P194(4)		POI					
POSITN		0.00373	0.00000	0.01400	0.00000	0.00373	
POS_632(1)		AXI					
POSITN		0.00445	0.00000	0.01500	0.00000	0.00445	
POS_632(2)		AXI					
POSITN		0.00389	0.00000	0.01500	0.00000	0.00389	
POS_632(3)		AXI					
POSITN		0.00578	0.00000	0.01500	0.00000	0.00578	
POS_632(4)		AXI					
POSITN		0.00605	0.00000	0.01500	0.00000	0.00605	
DIST_P030		POI					
Z		-0.02871	0.03000	0.00500	-0.00500	-0.00129	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 02-Feb-09, 12:00:25		pf39122529				Page 1 of 3	

Date: 02-Feb-09, 12:00:25		pf39122529				Page 2 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
DIST_P100			POI				
Z		-0.09915	0.10000	0.00500	-0.00500	-0.00085	
DIA_2P500			CIR				
DM		2.50080	2.50000	0.00500	-0.00500	0.00080	
PLA_45			PLA				
PA_MYPZ		44.92901	45.00000	0.50000	-0.50000	-0.07099	
DIA_P412			CIR				
FORM		0.00014					
DM		2.41342	2.41200	0.00500	0.00000	0.00142	
DIST_P46			AXI				
DY		0.46942	0.46000	0.02000	-0.02000	0.00942	
SQRNS_A			AXI				
SQRNES		0.00013	0.00000	0.02000	0.00000	0.00013	
DIA_P965			CIR				
DM		0.96857	0.96800	0.00500	-0.00500	0.00057	
MMCADD		0.00553					
POS_P965			POI				
POSMMC		0.00056	0.00000	0.00553		0.00056	
DIST_4P20			POI				
Z		-4.19916	4.20000	0.02000	-0.02000	-0.00084	
DIST_3P251			POI				
Z		-3.23524	3.25100	0.00000	-0.03000	-0.01576	
DIST_4P655			POI				
Z		-4.65007	4.65500	0.00500	-0.00500	-0.00493	
DIA_1P500			CIR				
DM		1.50052	1.50000	0.00500	-0.00500	0.00052	
DIA_1P063			CIR				
DM		1.06361	1.06300	0.00500	-0.00500	0.00061	
POS_M16			POI				
POSITN		0.00264	0.00000	0.00500	0.00000	0.00264	
DIST_P155			POI				
Z		0.15982	0.15500	0.00500	-0.00500	0.00482	
DIST_4P27			POI				
Z		4.27011	4.27000	0.02000	-0.02000	0.00011	
DIST_3P03			POI				
Z		3.03046	3.03000	0.02000	-0.02000	0.00046	

MANUAL MEASUREMENTS			
DIMENSION	TOLERANCE	ACTUAL	ACCEPTABLE/REJECT
DIA .709	± 0.005	-----	ACCEPTABLE
.118 X 45°	-----	-----	ACCEPTABLE

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 02-Feb-09, 12:00:25		pf39122529				Page 2 of 3	

Date: 02-Feb-09, 12:00:25			pf39122529			Page 3 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
!	4.517	± 0.002		4.515		ACCEPTABLE	!
!	45°	± 0.5°		-----		ACCEPTABLE	!
!							!
!-----							!

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 02-Feb-09, 12:00:25			pf39122529			Page 3 of 3	