

# Quindos Measuring Report



3D-Application Center

Description	LENS GROUND TUBE	Customer	R. ATKINSON
Drawing Number	PF-391-225-29	Serial Number	004
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, 13:36:34
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		0.00023	0.00000	0.00500	0.00000	0.00023	
DIST_P350		AXI					
DX		0.35108	0.35000	0.00500	-0.00500	0.00108	
POS_P350		AXI					
X		0.00150	0.00000	0.00500	-0.00500	0.00150	
DIA_P194(1)		CIR					
DM		0.19968	0.19400	0.01000	-0.00200	0.00568	
POS_P194(1)		POI					
POSITN		0.00399	0.00000	0.01400	0.00000	0.00399	
POS_P194(2)		POI					
POSITN		0.00288	0.00000	0.01400	0.00000	0.00288	
POS_P194(3)		POI					
POSITN		0.00194	0.00000	0.01400	0.00000	0.00194	
POS_P194(4)		POI					
POSITN		0.00312	0.00000	0.01400	0.00000	0.00312	
POS_632(1)		AXI					
POSITN		0.00490	0.00000	0.01500	0.00000	0.00490	
POS_632(2)		AXI					
POSITN		0.00200	0.00000	0.01500	0.00000	0.00200	
POS_632(3)		AXI					
POSITN		0.00466	0.00000	0.01500	0.00000	0.00466	
POS_632(4)		AXI					
POSITN		0.00508	0.00000	0.01500	0.00000	0.00508	
DIST_P030		POI					
Z		-0.02892	0.03000	0.00500	-0.00500	-0.00108	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 02-Feb-09, 13:36:35		pf39122529				Page 1 of 3	

Date: 02-Feb-09, 13:36:35			pf39122529			Page 2 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>DIST_P100</b>			<b>POI</b>				
Z		-0.09846	0.10000	0.00500	-0.00500	-0.00154	
<b>DIA_2P500</b>			<b>CIR</b>				
DM		2.50058	2.50000	0.00500	-0.00500	0.00058	
<b>PLA_45</b>			<b>PLA</b>				
PA_MYPZ		44.88648	45.00000	0.50000	-0.50000	-0.11352	
<b>DIA_P412</b>			<b>CIR</b>				
FORM		0.00024					
DM		2.41330	2.41200	0.00500	0.00000	0.00130	
<b>DIST_P46</b>			<b>AXI</b>				
DY		0.46183	0.46000	0.02000	-0.02000	0.00183	
<b>SQRNS_A</b>			<b>AXI</b>				
SQRNES		0.00011	0.00000	0.02000	0.00000	0.00011	
<b>DIA_P965</b>			<b>CIR</b>				
DM		0.96865	0.96800	0.00500	-0.00500	0.00065	
MMCADD		0.00559					
<b>POS_P965</b>			<b>POI</b>				
POSMMC		0.00086	0.00000	0.00559		0.00086	
<b>DIST_4P20</b>			<b>POI</b>				
Z		-4.19924	4.20000	0.02000	-0.02000	-0.00076	
<b>DIST_3P251</b>			<b>POI</b>				
Z		-3.23560	3.25100	0.00000	-0.03000	-0.01540	
<b>DIST_4P655</b>			<b>POI</b>				
Z		-4.65072	4.65500	0.00500	-0.00500	-0.00428	
<b>DIA_1P500</b>			<b>CIR</b>				
DM		1.50056	1.50000	0.00500	-0.00500	0.00056	
<b>DIA_1P063</b>			<b>CIR</b>				
DM		1.06369	1.06300	0.00500	-0.00500	0.00069	
<b>POS_M16</b>			<b>POI</b>				
POSITN		0.00187	0.00000	0.00500	0.00000	0.00187	
<b>DIST_P155</b>			<b>POI</b>				
Z		0.15958	0.15500	0.00500	-0.00500	0.00458	
<b>DIST_4P27</b>			<b>POI</b>				
Z		4.27012	4.27000	0.02000	-0.02000	0.00012	
<b>DIST_3P03</b>			<b>POI</b>				
Z		3.03090	3.03000	0.02000	-0.02000	0.00090	

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

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Date: 02-Feb-09, 13:36:35			pf39122529			Page 2 of 3	

Date: 02-Feb-09, 13:36:35			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	!	
!	M16	-----	-----			ACCEPTABLE/FITS MATING PIECE	!	
!	4X 6-32 UNC-2B	-----	-----			ACCEPTABLE	!	
!							!	
!	-----							!

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 02-Feb-09, 13:36:35			pf39122529			Page 3 of 3	