

Quindos Measuring Report



3D-Application Center

Description	LENS GROUND TUBE	Customer	R. ATKINSON
Drawing Number	PF-391-225-29	Serial Number	005
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, 14:04:27
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		0.00027	0.00000	0.00500	0.00000	0.00027	
DIST_P350		AXI					
DX		0.35105	0.35000	0.00500	-0.00500	0.00105	
POS_P350		AXI					
X		0.00151	0.00000	0.00500	-0.00500	0.00151	
DIA_P194(1)		CIR					
DM		0.19978	0.19400	0.01000	-0.00200	0.00578	
POS_P194(1)		POI					
POSITN		0.00401	0.00000	0.01400	0.00000	0.00401	
POS_P194(2)		POI					
POSITN		0.00216	0.00000	0.01400	0.00000	0.00216	
POS_P194(3)		POI					
POSITN		0.00081	0.00000	0.01400	0.00000	0.00081	
POS_P194(4)		POI					
POSITN		0.00269	0.00000	0.01400	0.00000	0.00269	
POS_632(1)		AXI					
POSITN		0.00432	0.00000	0.01500	0.00000	0.00432	
POS_632(2)		AXI					
POSITN		0.00228	0.00000	0.01500	0.00000	0.00228	
POS_632(3)		AXI					
POSITN		0.00937	0.00000	0.01500	0.00000	0.00937	
POS_632(4)		AXI					
POSITN		0.00551	0.00000	0.01500	0.00000	0.00551	
DIST_P030		POI					
Z		-0.02893	0.03000	0.00500	-0.00500	-0.00107	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
DIST_P100			POI				
Z		-0.10057	0.10000	0.00500	-0.00500	0.00057	
DIA_2P500			CIR				
DM		2.50069	2.50000	0.00500	-0.00500	0.00069	
PLA_45			PLA				
PA_MYPZ		44.97003	45.00000	0.50000	-0.50000	-0.02997	
DIA_P412			CIR				
FORM		0.00021					
DM		2.41392	2.41200	0.00500	0.00000	0.00192	
DIST_P46			AXI				
DY		0.46161	0.46000	0.02000	-0.02000	0.00161	
SQRNS_A			AXI				
SQRNES		0.00015	0.00000	0.02000	0.00000	0.00015	
DIA_P965			CIR				
DM		0.96857	0.96800	0.00500	-0.00500	0.00057	
MMCADD		0.00551					
POS_P965			POI				
POSMMC		0.00066	0.00000	0.00551		0.00066	
DIST_4P20			POI				
Z		-4.19989	4.20000	0.02000	-0.02000	-0.00011	
DIST_3P251			POI				
Z		-3.23576	3.25100	0.00000	-0.03000	-0.01524	
DIST_4P655			POI				
Z		-4.65057	4.65500	0.00500	-0.00500	-0.00443	
DIA_1P500			CIR				
DM		1.50017	1.50000	0.00500	-0.00500	0.00017	
DIA_1P063			CIR				
DM		1.06336	1.06300	0.00500	-0.00500	0.00036	
POS_M16			POI				
POSITN		0.00523	0.00000	0.00500	0.00000	0.00523	0.00023 ◀
DIST_P155			POI				
Z		0.15984	0.15500	0.00500	-0.00500	0.00484	
DIST_4P27			POI				
Z		4.27036	4.27000	0.02000	-0.02000	0.00036	
DIST_3P03			POI				
Z		3.03080	3.03000	0.02000	-0.02000	0.00080	

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

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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	!	
!							!	
!	-----							!

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