

# Quindos Measuring Report



3D-Application Center

|                    |                     |                   |                          |
|--------------------|---------------------|-------------------|--------------------------|
| Description        | SUPPORT, FLIGHT TUB | Customer          | R. ATKINSON              |
| Drawing Number     | PF-391-228-21 R0    | Serial Number     | 001                      |
| Remarks            |                     | Article Number    |                          |
| Supplier           | MFD                 | Delivery Date     |                          |
| Delivery Note      |                     | Delivery Volume   |                          |
| Lot Number         |                     | Lot Size          |                          |
| Test Schedule      |                     | Sample Size       |                          |
| Production Machine |                     | Production Tool   |                          |
| Production Date    |                     | Production Time   |                          |
| Order              | 24402-20            | Department        | MET. QUALITY INSPEC      |
| Inspector          | kcaban              | Inspection Date   | 17-FEB-2009, 09:12:00    |
| Measuring Device   | PMM 12 10 6 #496    | Measuring Program | Quindos7 - V 7.1.9005-R- |
| User Name          | kcaban              | WKP Name          | PF39122821               |

| Text          | Eval. | Actual  | Nominal | Up.To1. | Low.To1. | Act-Nom  | Graphic |
|---------------|-------|---------|---------|---------|----------|----------|---------|
| DAT\$PLA_A    |       | PLA     |         |         |          |          |         |
| FORM          |       | 0.00178 | 0.00000 | 0.00200 | 0.00000  | 0.00178  |         |
| DAT\$CIR_B    |       | CIR     |         |         |          |          |         |
| DM            |       | 5.04126 | 5.04000 | 0.00500 | 0.00000  | 0.00126  |         |
| DAT\$CIR_B(1) |       | CIR     |         |         |          |          |         |
| DM            |       | 0.31440 | 0.31300 | 0.00500 | -0.00500 | 0.00140  |         |
| DIA_4P830     |       | CIR     |         |         |          |          |         |
| DM            |       | 4.82966 | 4.83000 | 0.00500 | -0.00500 | -0.00034 |         |
| POS_4P830     |       | POI     |         |         |          |          |         |
| POSITN        |       | 0.00035 | 0.00000 | 0.00200 | 0.00000  | 0.00035  |         |
| DIA_8P125     |       | CIR     |         |         |          |          |         |
| DM            |       | 8.12325 | 8.12500 | 0.00500 | -0.00500 | -0.00175 |         |
| DIST_P80      |       | AXI     |         |         |          |          |         |
| DX            |       | 0.80009 | 0.80000 | 0.02000 | -0.02000 | 0.00009  |         |
| DIST_3P35     |       | AXI     |         |         |          |          |         |
| DXYZ          |       | 3.35099 | 3.35000 | 0.02000 | -0.02000 | 0.00099  |         |
| POS_P313      |       | POI     |         |         |          |          |         |
| POSITN        |       | 0.00127 | 0.00000 | 0.01500 | 0.00000  | 0.00127  |         |
| CBORE_P550    |       | CIR     |         |         |          |          |         |
| DM            |       | 0.54917 | 0.55000 | 0.00500 | -0.00500 | -0.00083 |         |
| POS_256(1)    |       | POI     |         |         |          |          |         |
| POSITN        |       | 0.00158 | 0.00000 | 0.00900 | 0.00000  | 0.00158  |         |
| POS_256(2)    |       | POI     |         |         |          |          |         |
| POSITN        |       | 0.00292 | 0.00000 | 0.00900 | 0.00000  | 0.00292  |         |
| POS_1032      |       | POI     |         |         |          |          |         |
| POSITN        |       | 0.00289 | 0.00000 | 0.01300 | 0.00000  | 0.00289  |         |

| 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 |
| <b>DEPTH_P125</b>         |       | <b>POI</b> |            |         |          |             |         |
| Z                         |       | -0.12693   | 0.12500    | 0.00500 | -0.00500 | 0.00193     |         |
| <b>DEPTH_P075</b>         |       | <b>POI</b> |            |         |          |             |         |
| Z                         |       | -0.07533   | 0.07500    | 0.00500 | -0.00500 | 0.00033     |         |
| <b>DIST_P280</b>          |       | <b>POI</b> |            |         |          |             |         |
| Z                         |       | -0.28488   | 0.28000    | 0.00500 | -0.00500 | 0.00488     |         |
| <b>THRD_256A</b>          |       | <b>CIR</b> |            |         |          |             |         |
| X                         |       | -1.67653   | 1.67600    | 0.00500 | -0.00500 | 0.00053     |         |
| Y                         |       | 0.12519    | 0.12500    | 0.00500 | -0.00500 | 0.00019     |         |
| <b>ANGLE</b>              |       | <b>ANG</b> |            |         |          |             |         |
| ANG                       |       | 80.00465   | 80.00000   |         |          | 0.00465     |         |

| MANUAL MEASUREMENTS |           |        |                   |
|---------------------|-----------|--------|-------------------|
| DIMENSION           | TOLERANCE | ACTUAL | ACCEPTABLE/REJECT |
| 12X 2-56 UNC-2B     | -----     | GO     | ACCEPTABLE        |
| 6X 2-56 UNC-2B      | -----     | GO     | ACCEPTABLE        |
| PARALLELISM         | 0.002     | 0.0013 | ACCEPTABLE        |
| 3X 10-32 UNC-2B     | -----     | GO     | ACCEPTABLE        |
| 12X 2-56 UNC-2B     | -----     | GO     | ACCEPTABLE        |

| Text                      | Eval. | Actual | Nominal    | Up.Tol. | Low.Tol. | Act-Nom     | Graphic |
|---------------------------|-------|--------|------------|---------|----------|-------------|---------|
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