

Quindos Measuring Report



3D-Application Center

Description	FLNG, LASER TABLE F	Customer	R. ATKINSON
Drawing Number	PF-391-255-61 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	24623-4	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	15-APR-2009, 08:36:00
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9099-B
User Name	kcaban	WKP Name	pf39125561

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DAT\$PLA_A		PLA					
FORM		0.00265	0.00000	0.00500	0.00000	0.00265	
DIST_5P00		POI					
X		4.99979	5.00000	0.02000	-0.02000	-0.00021	
DIST_4P50		POI					
Y		-4.49889	4.50000	0.02000	-0.02000	-0.00111	
CHAM_P25xP25		AXI					
DX		-0.25009	0.25000	0.02000	-0.02000	0.00009	
DY		-0.24958	0.25000	0.02000	-0.02000	-0.00042	
CHAM_75xP75		AXI					
DX		0.74884	0.75000	0.02000	-0.02000	-0.00116	
DY		-0.74959	0.75000	0.02000	-0.02000	-0.00041	
DIA_P281		CIR					
DM		0.28152	0.28100	0.01500	-0.00200	0.00052	
X		2.49987	2.50000			-0.00013	
Y		-3.49907	3.50000			-0.00093	
DEPTH_P300		POI					
Z		-0.30284	0.30000	0.03000	-0.03000	0.00284	
CBORE_P438		CIR					
DM		0.43995	0.43800	0.01600	-0.01600	0.00195	
X		2.50086	2.50000			0.00086	
Y		-1.00063	1.00000			0.00063	
BDIS_2P500		AXI					
DY		2.49845	2.50000			-0.00155	
POS_P281(1)		POI					
POSITN		0.00187	0.00000	0.01400	0.00000	0.00187	
POS_P281(2)		POI					
POSITN		0.00213	0.00000	0.01400	0.00000	0.00213	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 15-Apr-09, 08:36:00		pf39125561				Page 1 of 4	

Date: 15-Apr-09, 08:36:00			pf39125561			Page 2 of 4	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

SLOT(1)		AXI					
LA_DIS	0.81378	0.81200	0.01500	-0.00200	0.00178		
SM_DIS	0.31060	0.31000	0.02000	-0.02000	0.00060		
X	0.49860	0.50000			-0.00140		
Y	-0.49885	0.50000			-0.00115		

SLOT(2)		AXI					
LA_DIS	0.81364	0.81200	0.01500	-0.00200	0.00164		
SM_DIS	0.31120	0.31000	0.02000	-0.02000	0.00120		
X	0.49830	0.50000			-0.00170		
Y	-3.49868	3.50000			-0.00132		

SLOT(3)		AXI					
LA_DIS	0.81411	0.81200	0.01500	-0.00200	0.00211		
SM_DIS	0.31117	0.31000	0.02000	-0.02000	0.00117		
X	4.49861	4.50000			-0.00139		
Y	-3.49900	3.50000			-0.00100		

SLOT(4)		AXI					
LA_DIS	0.81387	0.81200	0.01500	-0.00200	0.00187		
SM_DIS	0.31089	0.31000	0.02000	-0.02000	0.00089		
X	4.49911	4.50000			-0.00089		
Y	-0.49930	0.50000			-0.00070		

BDIS_4P000		AXI					
DX	4.00030	4.00000			0.00030		

BDIS_3P000		AXI					
DY	-2.99970	3.00000			-0.00030		

POS\$SLOT(1)		POI					
POSITN	0.00362	0.00000	0.01400	0.00000	0.00362		

POS\$SLOT(2)		POI					
POSITN	0.00430	0.00000	0.01400	0.00000	0.00430		

POS\$SLOT(3)		POI					
POSITN	0.00343	0.00000	0.01400	0.00000	0.00343		

POS\$SLOT(4)		POI					
POSITN	0.00226	0.00000	0.01400	0.00000	0.00226		

DIST_P50		POI					
Z	-0.50863	0.50000			0.00863		

THRD(1)		CYL					
X	3.64895	3.65000			-0.00105		
Z	0.25163	0.25000			0.00163		

THRD(2)		CYL					
X	1.34825	1.35000			-0.00175		
Z	0.25033	0.25000			0.00033		

POS\$THRD(1)		AXI					
POSITN	0.00401	0.00000	0.01400	0.00000	0.00401		

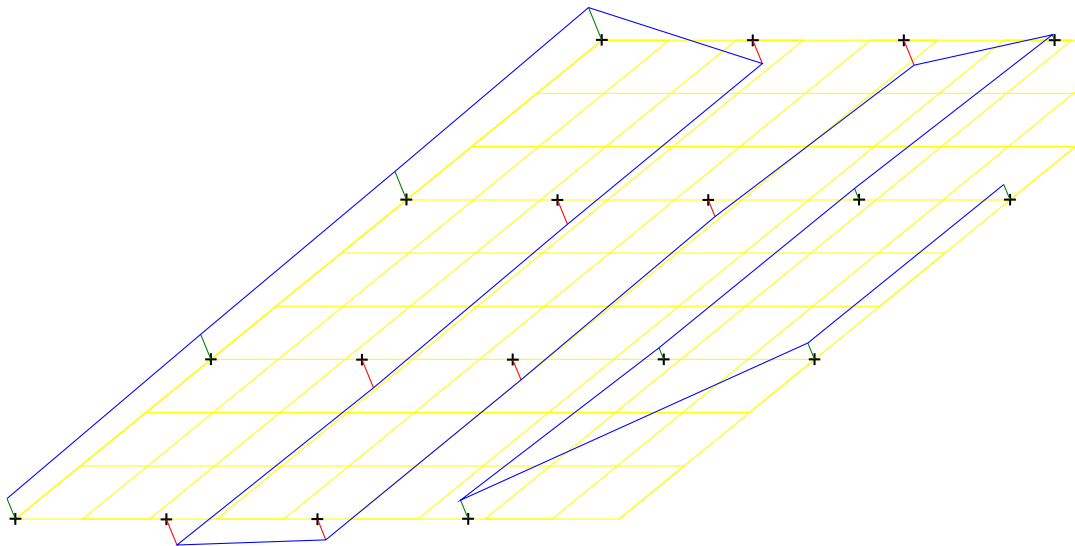
POS\$THRD(2)		AXI					
POSITN	0.00360	0.00000	0.01400	0.00000	0.00360		

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 15-Apr-09, 08:36:00			pf39125561			Page 2 of 4	

Date: 15-Apr-09, 08:36:00			pf39125561			Page 3 of 4	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

!-----!							
! MANUAL MEASUREMENTS !							
!-----!							
! DIMENSION		! TOLERANCE		! ACTUAL		! ACCEPTABLE/REJECT	
!-----!							
! 2X 1/4-20 UNC-2B		! -----		! OK		! ACCEPTABLE	
!-----!							

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 15-Apr-09, 08:36:00			pf39125561			Page 3 of 4	



0.00347
Inch

Actual points : * * * Neg. Deviation : ———— Pos. Deviation : ————

Notation : FLNG, LASER TAB Producer : R. ATKINSON Draw. No. : PF-391-255-61 R
 Ser. No. : 001 Part No. : Department: MET. QUALITY IN
 Calcul. .: Bestfit (Gauss) Filtering: No Probe dia.: 1 mm
 Element : DAT\$PLA_A X Y Z No.
 Form: 0.0026 Neg. Deviat.: -0.0012 1.7334 -1.2253 0.0174 12
 Error Magnif.: 5 Pos. Deviat.: 0.0014 4.8000 -0.2002 0.0198 15
 No. of points: 18

MESSTECHNIK WETZLAR



FLATNESS
ISO 1101

Inspector :kcaban
Date:15-APR-2009
Time:08:36:00

Quindos Measuring Report



3D-Application Center

Description	FLNG, LASER TABLE F	Customer	R. ATKINSON
Drawing Number	PF-391-255-61 R0	Serial Number	002
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	24623-4	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	15-APR-2009, 08:48:11
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9099-B
User Name	kcaban	WKP Name	pf39125561

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DAT\$PLA_A		PLA					
FORM		0.00330	0.00000	0.00500	0.00000	0.00330	
DIST_5P00		POI					
X		4.99960	5.00000	0.02000	-0.02000	-0.00040	
DIST_4P50		POI					
Y		-4.49904	4.50000	0.02000	-0.02000	-0.00096	
CHAM_P25xP25		AXI					
DX		-0.25013	0.25000	0.02000	-0.02000	0.00013	
DY		-0.24976	0.25000	0.02000	-0.02000	-0.00024	
CHAM_75xP75		AXI					
DX		0.74872	0.75000	0.02000	-0.02000	-0.00128	
DY		-0.74942	0.75000	0.02000	-0.02000	-0.00058	
DIA_P281		CIR					
DM		0.28134	0.28100	0.01500	-0.00200	0.00034	
X		2.50061	2.50000			0.00061	
Y		-3.49990	3.50000			-0.00010	
DEPTH_P300		POI					
Z		-0.30216	0.30000	0.03000	-0.03000	0.00216	
CBORE_P438		CIR					
DM		0.43992	0.43800	0.01600	-0.01600	0.00192	
X		2.50048	2.50000			0.00048	
Y		-1.00067	1.00000			0.00067	
BDIS_2P500		AXI					
DY		2.49923	2.50000			-0.00077	
POS_P281(1)		POI					
POSITN		0.00125	0.00000	0.01400	0.00000	0.00125	
POS_P281(2)		POI					
POSITN		0.00165	0.00000	0.01400	0.00000	0.00165	

Date: 15-Apr-09, 08:48:13			pf39125561			Page 2 of 4	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

SLOT(1)

AXI

LA_DIS	0.81384	0.81200	0.01500	-0.00200	0.00184	
SM_DIS	0.31023	0.31000	0.02000	-0.02000	0.00023	
X	0.49866	0.50000			-0.00134	
Y	-0.49896	0.50000			-0.00104	

SLOT(2)

AXI

LA_DIS	0.81422	0.81200	0.01500	-0.00200	0.00222	
SM_DIS	0.31090	0.31000	0.02000	-0.02000	0.00090	
X	0.49843	0.50000			-0.00157	
Y	-3.49904	3.50000			-0.00096	

SLOT(3)

AXI

LA_DIS	0.81436	0.81200	0.01500	-0.00200	0.00236	
SM_DIS	0.31103	0.31000	0.02000	-0.02000	0.00103	
X	4.49866	4.50000			-0.00134	
Y	-3.49928	3.50000			-0.00072	

SLOT(4)

AXI

LA_DIS	0.81414	0.81200	0.01500	-0.00200	0.00214	
SM_DIS	0.31093	0.31000	0.02000	-0.02000	0.00093	
X	4.49894	4.50000			-0.00106	
Y	-0.49957	0.50000			-0.00043	

BDIS_4P000

AXI

DX	4.00022	4.00000			0.00022	
----	---------	---------	--	--	---------	--

BDIS_3P000

AXI

DY	-2.99970	3.00000			-0.00030	
----	----------	---------	--	--	----------	--

POS\$SLOT(1)

POI

POSITN	0.00339	0.00000	0.01400	0.00000	0.00339	
--------	---------	---------	---------	---------	---------	--

POS\$SLOT(2)

POI

POSITN	0.00368	0.00000	0.01400	0.00000	0.00368	
--------	---------	---------	---------	---------	---------	--

POS\$SLOT(3)

POI

POSITN	0.00305	0.00000	0.01400	0.00000	0.00305	
--------	---------	---------	---------	---------	---------	--

POS\$SLOT(4)

POI

POSITN	0.00228	0.00000	0.01400	0.00000	0.00228	
--------	---------	---------	---------	---------	---------	--

DIST_P50

POI

Z	-0.51039	0.50000			0.01039	
---	----------	---------	--	--	---------	--

THRD(1)

CYL

X	3.64957	3.65000			-0.00043	
Z	0.25650	0.25000			0.00650	

THRD(2)

CYL

X	1.34836	1.35000			-0.00164	
Z	0.25569	0.25000			0.00569	

POS\$THRD(1)

AXI

POSITN	0.01358	0.00000	0.01400	0.00000	0.01358	
--------	---------	---------	---------	---------	---------	--

POS\$THRD(2)

AXI

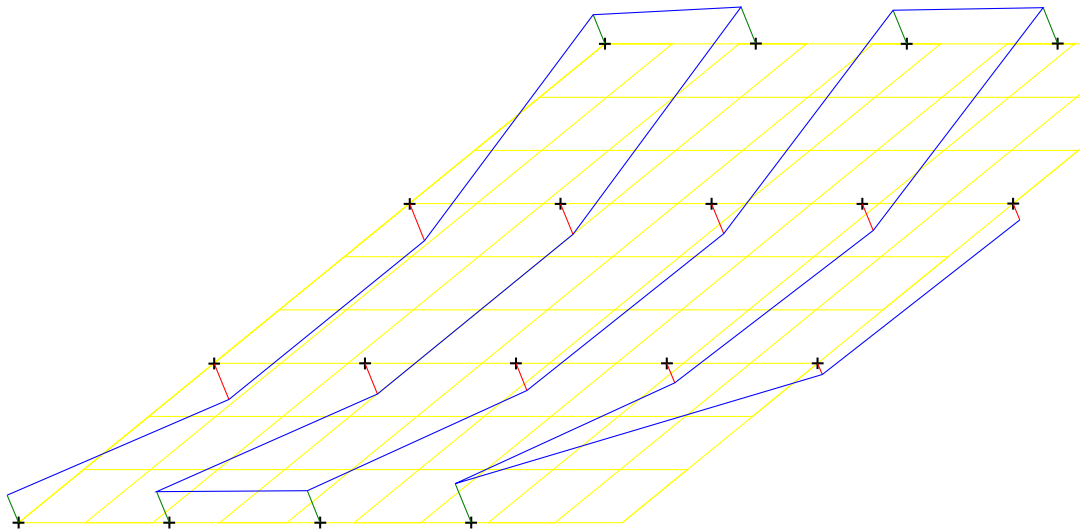
POSITN	0.01224	0.00000	0.01400	0.00000	0.01224	
--------	---------	---------	---------	---------	---------	--

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 15-Apr-09, 08:48:13			pf39125561			Page 2 of 4	

Date: 15-Apr-09, 08:48:13			pf39125561			Page 3 of 4	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic

!-----!							
! MANUAL MEASUREMENTS !							
!-----!							
! DIMENSION		! TOLERANCE		! ACTUAL		! ACCEPTABLE/REJECT	
!-----!							
! 2X 1/4-20 UNC-2B		! -----		! OK		! ACCEPTABLE	
!-----!							

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 15-Apr-09, 08:48:13			pf39125561			Page 3 of 4	



0.00347
Inch

Actual points : * * *

Neg. Deviation : —

Pos. Deviation : —

Notation : FLNG, LASER TAB	Producer : R. ATKINSON	Draw. No. : PF-391-255-61 R
Ser. No. : 002	Part No. :	Department: MET. QUALITY IN
Calcul. .: Bestfit (Gauss)	Filtering: No	Probe dia.: 1 mm
Element : DAT\$PLA_A		
Form: 0.0033	Neg. Deviat.: -0.0016	3.2667 -0.2003 0.0199 16
Error Magnif.: 5	Pos. Deviat.: 0.0017	0.2001 -3.2752 0.0210 3
No. of points: 18		

MESSTECHNIK WETZLAR



FLATNESS
ISO 1101

Inspector : **kcaban**
Date: **15-APR-2009**
Time: **08:48:11**