

Quindos Measuring Report



3D-Application Center

Description	COLD PLATE BASE	Customer	J. TICE
Drawing Number	PF-391-521-46	Serial Number	001 (TOP PROGRAM)
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	25236-5	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	04-NOV-2009, 14:07:51
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9294
User Name	kcaban	WKP Name	NO\$NAME

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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DATUM_A PLA

FORM 0.00285

DAT\$CIR_B CIR

FORM 0.00040
 DM 6.35764 6.36000 -0.00236
 X 0.00035
 Y 0.00009

! ----- 4X 5/16-18 UNC-2B checked OKAY with Thread Go-No-Go Gage

DIA_P625(1) CIR

FORM 0.00008
 DM 0.62486 0.62500 0.00500 -0.00500 -0.00014
 XY 4.94305 4.94350 -0.00045
 PP_PYPX 31.00009 31.00000 0.00009

POS_P625(1) POI

POSITN 0.01000
 POSMMC 0.00089 0.00000 0.01508 0.00000 0.00089

PLA_P124(1) PLA

FORM 0.00003
 Z 0.12357 0.12400 0.00200 -0.00200 -0.00043

DIA_P625(2) CIR

FORM 0.00011
 DM 0.62479 0.62500 0.00500 -0.00500 -0.00021
 XY 4.94300 4.94350 -0.00050
 PP_MXPY 31.00697 31.00000 0.00697

POS_P625(2) POI

POSITN 0.01000
 POSMMC 0.00156 0.00000 0.01513 0.00000 0.00156

PLA_P124(2) PLA

FORM 0.00001
 Z 0.12263 0.12400 0.00200 -0.00200 -0.00137

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 04-Nov-09, 14:07:51						NO\$NAME	Page 1 of 4

Date: 04-Nov-09, 14:07:51			NO\$NAME			Page 2 of 4	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

DIA_P625(3)		CIR					
FORM		0.00017					
DM		0.62490	0.62500	0.00500	-0.00500	-0.00010	
XY		4.94224	4.94350			-0.00126	
PP_MYMX		31.01411	31.00000			0.01411	

POS_P625(3)		POI					
POSITN				0.01000			
POSMMC		0.00351	0.00000	0.01494	0.00000	0.00351	

PLA_P124(3)		PLA					
FORM		0.00002					
Z		0.12208	0.12400	0.00200	-0.00200	-0.00192	

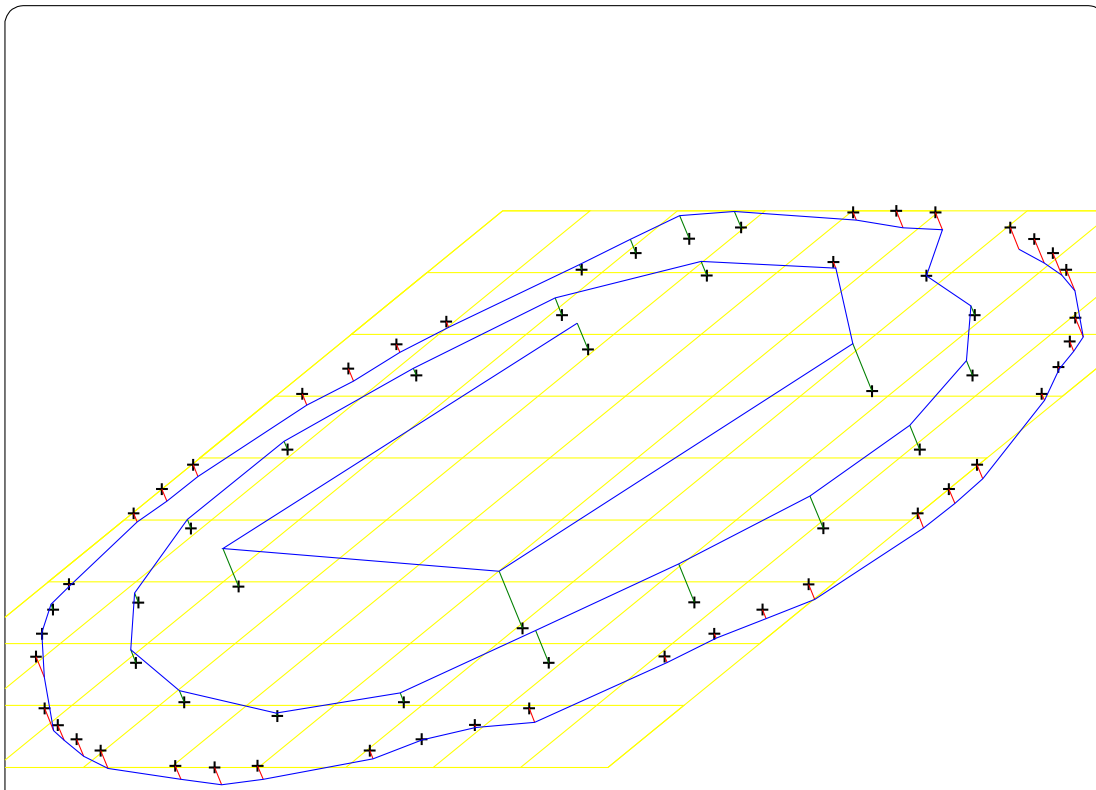
DIA_P625(4)		CIR					
FORM		0.00028					
DM		0.62490	0.62500	0.00500	-0.00500	-0.00010	
XY		4.94195	4.94350			-0.00155	
PP_PXMY		30.99152	31.00000			-0.00849	

POS_P625(4)		POI					
POSITN				0.01000			
POSMMC		0.00343	0.00000	0.01477	0.00000	0.00343	

PLA_P124(4)		PLA					
FORM		0.00006					
Z		0.12303	0.12400	0.00200	-0.00200	-0.00097	

PLA_P400		PLA					
FORM		0.00128					
Z		0.39919	0.40000	0.00500	-0.00500	-0.00081	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 04-Nov-09, 14:07:51			NO\$NAME			Page 2 of 4	



0.00279
Inch

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

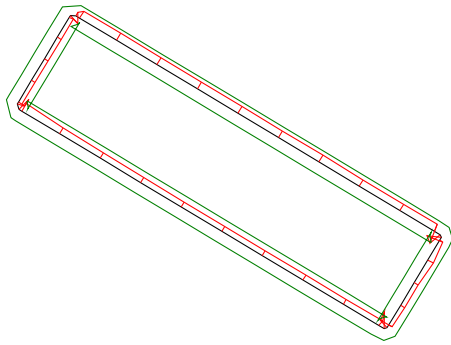
Notation : COLD PLATE BASE Producer : J. TICE Draw. No. : PF-391-521-46
 Ser. No. : 001 (TOP PROGRA Part No. : Department: MET. QUALITY IN
 Calcul. .: Bestfit (Gauss) Filtering: No Probe dia.: 3 mm
 Element : DATUM_A X Y Z No.
 Form: 0.0028 Neg. Deviat.: -0.0008 3.8557 -1.8806 0.0596 65
 Error Magnif.: 10 Pos. Deviat.: 0.0020 -2.1503 -1.5056 0.0629 3
 No. of points: 66



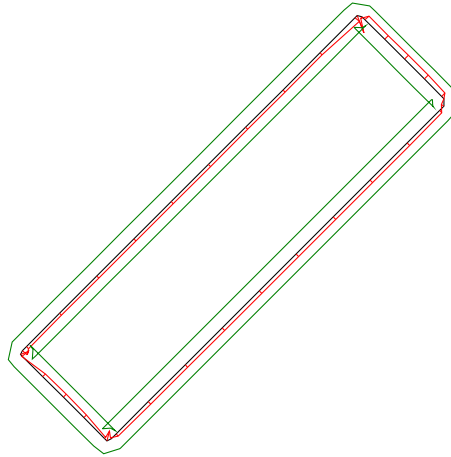
FLATNESS

ISO 1101

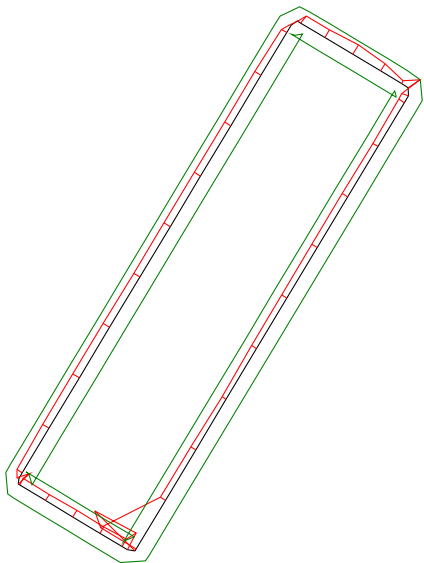
Inspector :kcaban
 Date:04-NOV-2009
 Time:14:07:51



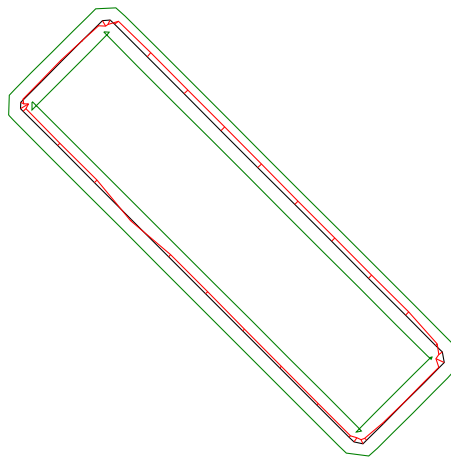
BOSS PROFILE @ QUADRANT II



BOSS PROFILE @ QUADRANT I



BOSS PROFILE @ QUADRANT III



BOSS PROFILE @ QUADRANT IV

MESSTECHNIK WETZLAR



BOSS PROFILES SAMPLES

DRAWING #: PF-391-521-46 REV 0
 SN: 001 (TOP PROGRAM)
 PART NAME: COLD PLATE BASE

BLK = NOMINAL
 RED = DEVIATIONS
 GRN = +/- .005 TOL
 DATE: 04-NOV-2009

Quindos Measuring Report



3D-Application Center

Description	COLD PLATE BASE	Customer	J. TICE
Drawing Number	PF-391-521-46	Serial Number	001 (BOTTOM PROGRA
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	25236-5	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	06-NOV-2009, 13:18:16
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9294
User Name	kcaban	WKP Name	NO\$NAME

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DATUM_A		PLA					
	FORM	0.00456	0.00000	0.00200	0.00000	0.00456	0.00256 ◀
DATUM_B		CIR					
	FORM	0.00098					
	DM	8.57851	8.58000	0.00500	0.00000	-0.00149	-0.00149 ◀
DAT\$CIR_C		CIR					
	FORM	0.00019					
	RA	0.12445	0.12500	0.00500	-0.00500	-0.00055	
DIA_AG		CIR					
	FORM	0.00119					
	DM	8.12346	8.12400	0.00500	-0.00500	-0.00054	
	X	0.00026	0.00000			0.00026	
	Y	0.00072	0.00000			0.00072	
DIA_AG_CAV		CIR					
	RA	0.06191	0.06200	0.00500	-0.00500	-0.00009	
	X	-1.39952	1.40000			-0.00048	
	XY	4.06179	4.06200			-0.00021	
DIA_P281(1)		CIR					
	DM	0.28358	0.28100	0.00500	-0.00200	0.00258	
	PP_PXPY	54.99927	55.00000			-0.00073	
	XY	2.84976	2.85000			-0.00024	
DIA_P281(2)		CIR					
	DM	0.28334	0.28100	0.00500	-0.00200	0.00234	
	PP_PXPY	144.98393	145.00000			-0.01607	
	XY	2.84953	2.85000			-0.00047	
DIA_P281(3)		CIR					
	DM	0.28291	0.28100	0.00500	-0.00200	0.00191	
	PP_PXPY	234.99183	235.00000			-0.00817	
	XY	2.84906	2.85000			-0.00094	
DIA_P281(4)		CIR					
	DM	0.28371	0.28100	0.00500	-0.00200	0.00271	


Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 06-Nov-09, 16:02:04		NO\$NAME				Page 1 of 6	

Date: 06-Nov-09, 16:02:04			NO\$NAME			Page 2 of 6	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

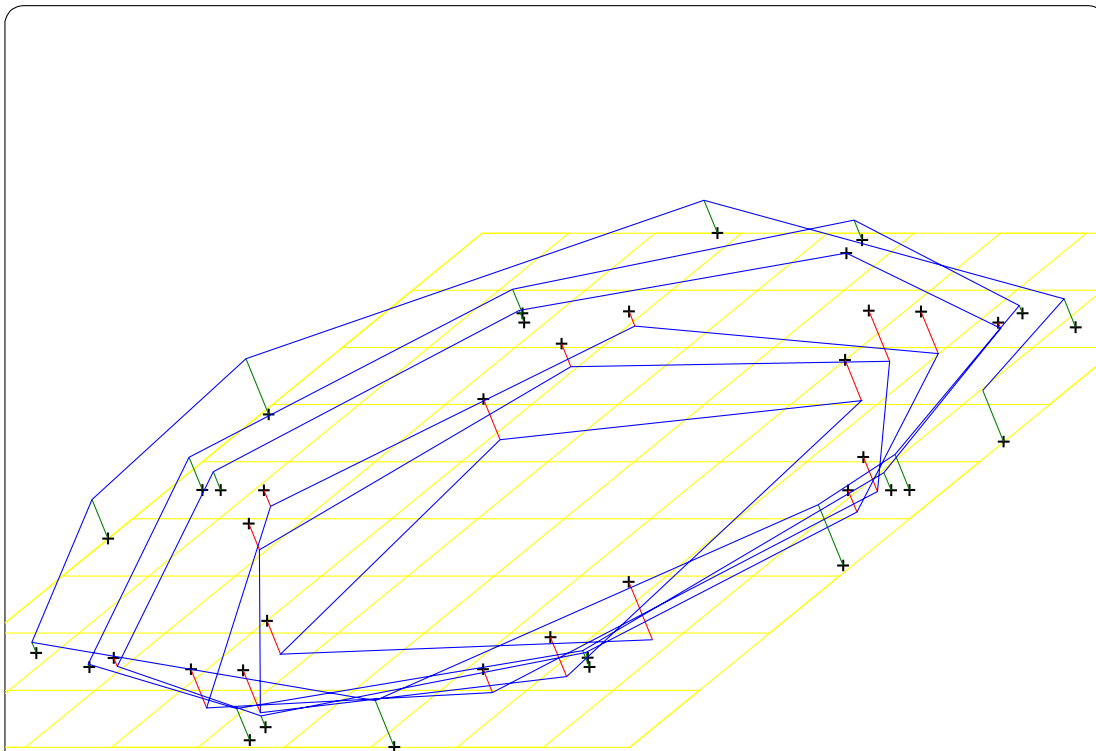
DIA_P281(4) CIR ◀

PP_PXPY	325.01908	325.00000				0.01907	
XY	2.84871	2.85000				-0.00130	

PLA_P030 PLA

FORM	0.00130						
Z	0.03057	0.03000	0.01000	0.00000	0.00057		

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 06-Nov-09, 16:02:04			NO\$NAME			Page 2 of 6	



0.00305
Inch

Actual points : * * *

Neg. Deviation : ———

Pos. Deviation : ———

Notation : COLD PLATE BASE Producer : J. TICE Draw. No. : PF-391-521-46
 Ser. No. : 001 (BOTTOM PRO Part No. : Department: MET. QUALITY IN
 Calcul. .: Bestfit (Gauss) Filtering: No Probe dia.: 1 mm
 Element : DATUM_A

	X	Y	Z	No.		
Form	0.0046	Neg. Deviat.: -0.0022	2.2015	-1.5415	0.0181	40
Error Magnif.:	10	Pos. Deviat.: 0.0023	4.5316	-1.2750	0.0223	8
No. of points:	40					

MESSTECHNIK WETZLAR



FLATNESS
ISO 1101

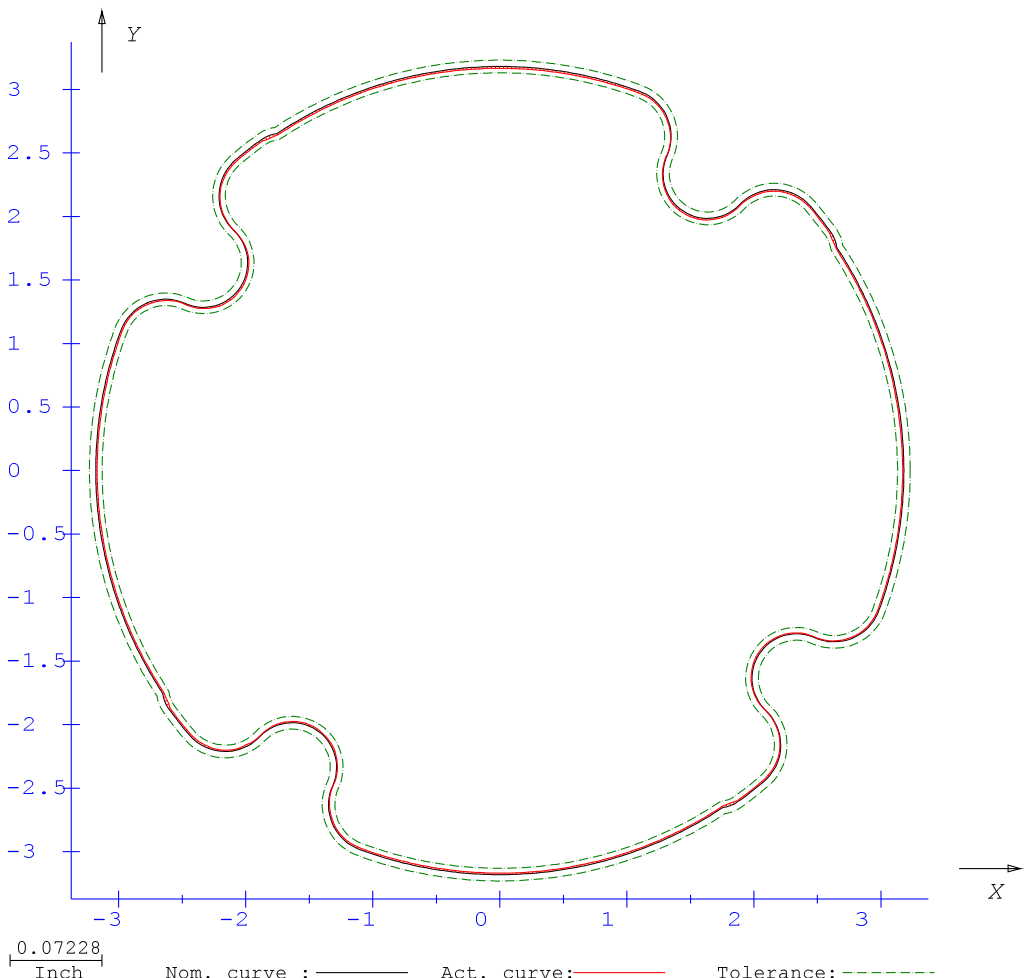
Inspector :kcaban
Date:06-NOV-2009
Time:13:18:16

PI\$Pages_3700

Date: 06-Nov-09, 16:02:04

NO\$NAME

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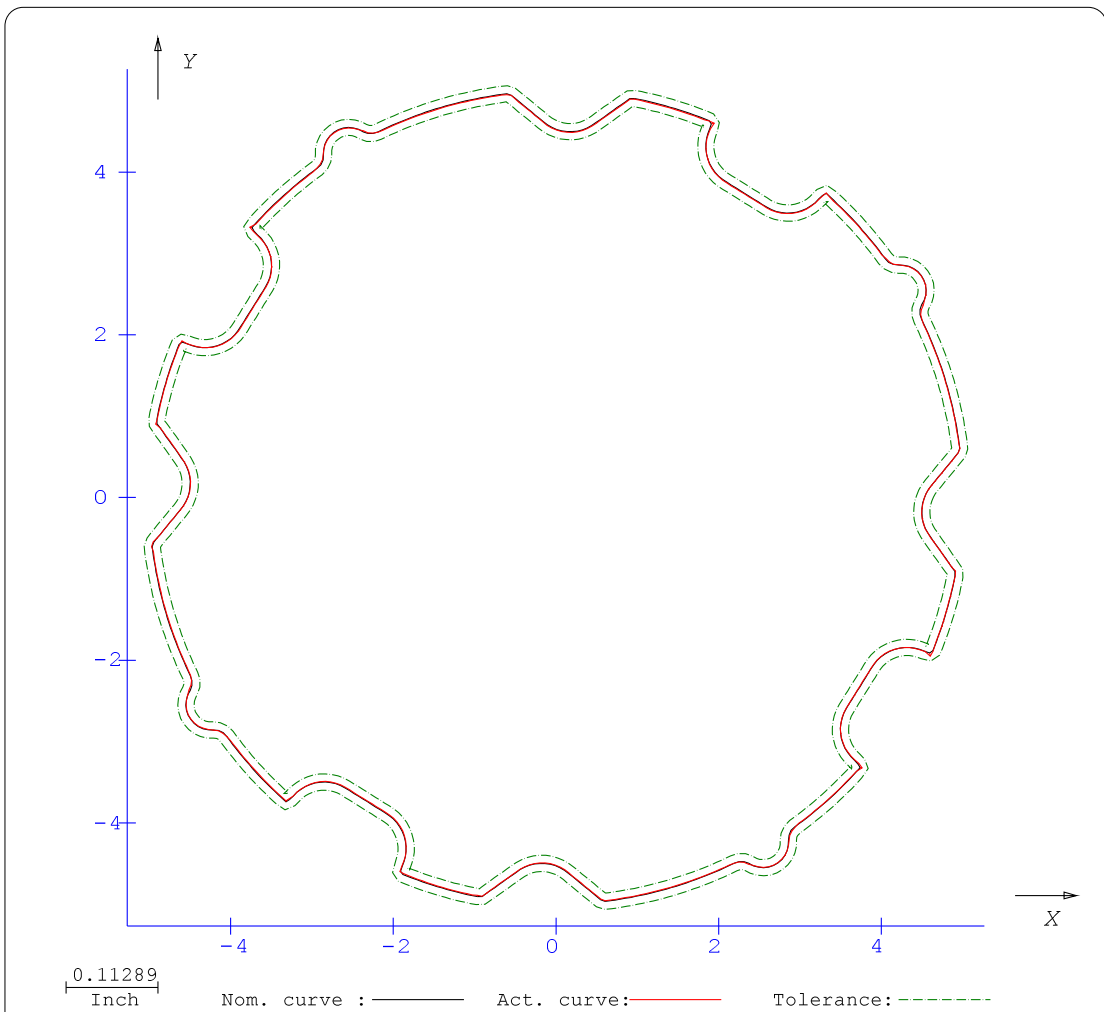
Notation : COLD PLATE BASE Producer : J. TICE Draw. No. : PF-391-521-46
 Ser. No. : 001 (BOTTOM PRO Part No. : Department: MET. QUALITY IN
 Element : ACNO_IN

		X	Y	Z	Nr.		
Form	0.00215	Min. Deviat.:	0.00016	1.32134	2.49201	-0.09400	122
Lower Toler. :	-0.00500	Max. Deviat.:	0.00231	-1.81607	2.63722	-0.09400	236
Upper Toler. :	0.00500						
Error Magnif.:	10						
No. of points:	700						



2D - CONTOUR

Inspector.:kcaban
 Date:06-NOV-2009
 Time:13:18:16



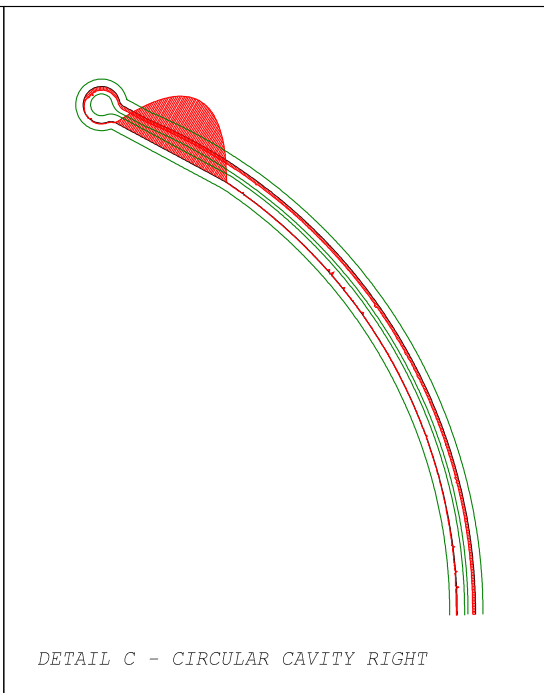
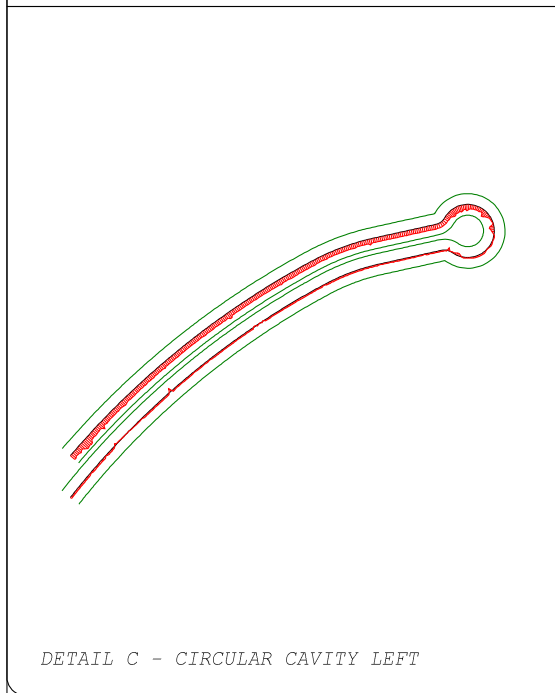
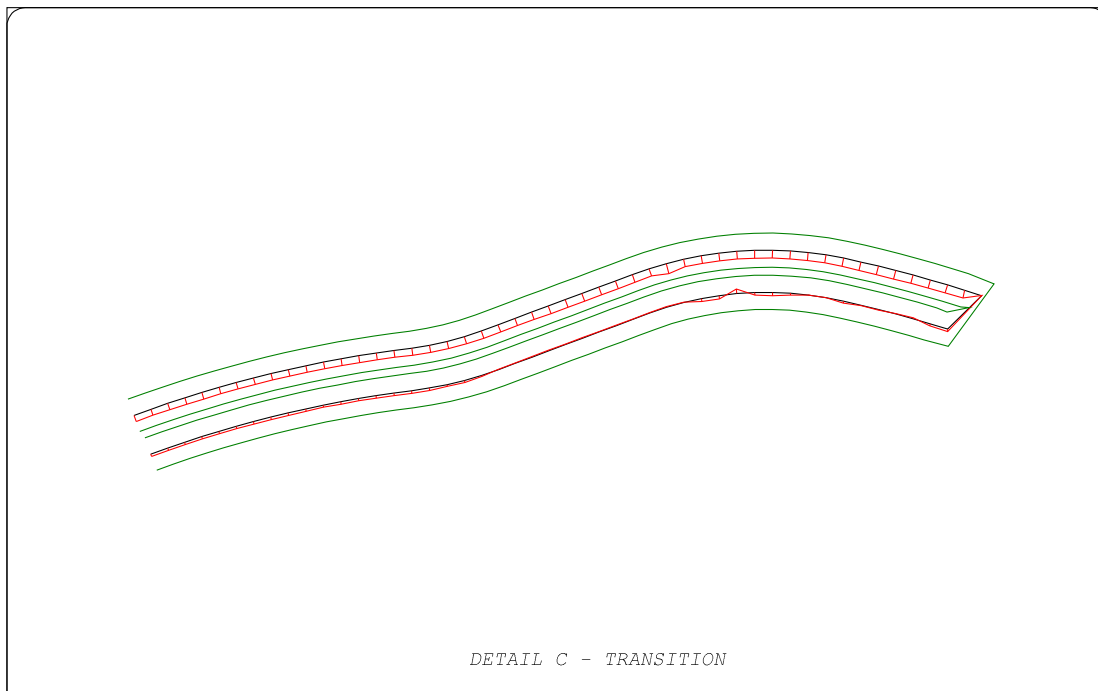
Notation : COLD PLATE BASE Producer : J. TICE Draw. No. : PF-391-521-46
 Ser. No. : 001 (BOTTOM PRO Part No. : Department: MET. QUALITY IN
 Element : ACNO_OUT

		X	Y	Z	Nr.	
Form	0.00532	Min. Deviat.:-0.00155	-0.96680	-4.90564	-0.14150	404
Lower Toler. :	0.01000	Max. Deviat.: 0.00377	4.59432	-1.91028	-0.14150	528
Upper Toler. :	-0.01000					
Error Magnif.:	10					
No. of points:	560					



2D - CONTOUR

Inspector.:kcaban
 Date:06-NOV-2009
 Time:13:18:16



MESSTECHNIK WETZLAR



COLD PLATE BASE

DRAWING #: PF-391-521-46 REV 0
 SERIAL NUMBER: 001 (BOTTOM PROGRAM)
 SHEET 2 DETAIL C PLOTS

BLK = NOMINAL
 RED = DEVIATIONS
 GRN = +/- .005 TOL
 DATE: 06-NOV-2009