

# Quindos Measuring Report



3D-Application Center

Description	SLITS SUPPORT	Customer	R. ATKINSON
Drawing Number	PF-391-940-63 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	24629-12	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	28-APR-2009, 06:25:00
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9110-B
User Name	kcaban	WKP Name	PF39194063

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DAT\$PLA_B		PLA					
	FORM	0.00024	0.00000			0.00024	
DAT\$PLA_C		PLA					
	FORM	0.00013	0.00000			0.00013	
PLA_1P50		PLA					
	Y	1.50115	1.50000	0.02000	-0.02000	0.00115	
	FORM	0.00015					
PLA_6P45		PLA					
	X	-6.45089	6.45000	0.02000	-0.02000	0.00089	
	FORM	0.00006					
PLA_1P00		PLA					
	Z	0.99976	1.00000	0.02000	-0.02000	-0.00024	
PLA_P90		PLA					
	Z	0.89996	0.90000	0.02000	-0.02000	-0.00004	
PLA_P48		PLA					
	Z	0.47950	0.48000	0.02000	-0.02000	-0.00050	
PLA_P45		PLA					
	X	-0.45054	0.45000	0.02000	-0.02000	0.00054	
PLA_1P58		PLA					
	X	-1.58057	1.58000	0.02000	-0.02000	0.00057	
PLA_P56		PLA					
	Y	0.56074	0.56000	0.02000	-0.02000	0.00074	
DIST_P38		AXI					
	DY	0.37972	0.38000	0.02000	-0.02000	-0.00028	
ANG_26		PLA					
	PA_PZMX	25.96578	26.00000	1.00000	-1.00000	-0.03422	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Date: 28-Apr-09, 06:25:04			PF39194063			Page 2 of 5	
Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>DISTANCE</b>			<b>AXI</b>				
DZ		0.22225	0.22000	0.02000	-0.02000	0.00225	
<b>DIST_2P02</b>			<b>AXI</b>				
DX		2.02448	2.02000	0.02000	-0.02000	0.00448	
<b>DIST_P75</b>			<b>AXI</b>				
DX		0.74890	0.75000	0.02000	-0.02000	-0.00110	
<b>RAD_P38(1)</b>			<b>CIR</b>				
RA		0.37558	0.38000	0.02000	-0.02000	-0.00442	
<b>RAD_P38(2)</b>			<b>CIR</b>				
RA		0.37535	0.38000	0.02000	-0.02000	-0.00465	
<b>ANG_110</b>			<b>PLA</b>				
PA_PYPX		109.99543	110.00000	1.00000	-1.00000	-0.00457	
<b>PLA_P500(1)</b>			<b>PLA</b>				
FORM		0.00005	0.00000	0.00200	0.00000	0.00005	
Z		0.50005	0.50000	0.00500	-0.00500	0.00005	
<b>PLA_P500(2)</b>			<b>PLA</b>				
FORM		0.00007	0.00000	0.00200	0.00000	0.00007	
Z		0.49897	0.50000	0.00500	-0.00500	-0.00103	
<b>DIA_P50</b>			<b>CIR</b>				
DM		0.50183	0.50000	0.02000	-0.02000	0.00183	
X		-4.05137	4.05100			0.00037	
Y		0.75042	0.75000			0.00042	
<b>POS_P50</b>			<b>POI</b>				
POSITN		0.00111	0.00000	0.01400	0.00000	0.00111	
<b>RAD_P12</b>			<b>CIR</b>				
RA		0.12685	0.12000	0.02000	-0.02000	0.00685	
<b>THRD_440T(1)</b>			<b>CYL</b>				
X		-4.05152	4.05100			0.00052	
Y		0.09977	0.10000			-0.00023	
<b>POS_440T(1)</b>			<b>AXI</b>				
POSITN		0.00123	0.00000	0.01100	0.00000	0.00123	
<b>THRD_440T(4)</b>			<b>CYL</b>				
X		-4.05213	4.05100			0.00113	
Y		1.40036	1.40000			0.00036	
<b>POS_440T(4)</b>			<b>AXI</b>				
POSITN		0.00244	0.00000	0.01100	0.00000	0.00244	
<b>THRD_440T(2)</b>			<b>CYL</b>				
X		-4.05154	4.05100			0.00054	
Y		0.37544	0.37500			0.00044	
<b>POS_440T(2)</b>			<b>AXI</b>				
POSITN		0.00142	0.00000	0.01100	0.00000	0.00142	
<b>THRD_440T(3)</b>			<b>CYL</b>				
X		-4.05173	4.05100			0.00073	

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>THRD_440T(3)</b>			<b>CYL</b>				◀
Y		1.12515	1.12500			0.00015	
<b>POS_440T(3)</b>			<b>AXI</b>				
POSITN		0.00156	0.00000	0.01100	0.00000	0.00156	
<b>THRD_440NS(1)</b>			<b>CIR</b>				
X		-1.15079	1.15000			0.00079	
Z		0.34899	0.35000			-0.00102	
<b>POS_440NS(1)</b>			<b>AXI</b>				
POSITN		0.00257	0.00000	0.01100	0.00000	0.00257	
<b>THRD_440NS(2)</b>			<b>CIR</b>				
X		-3.45044	3.45000			0.00044	
Z		0.34883	0.35000			-0.00117	
<b>POS_440NS(2)</b>			<b>AXI</b>				
POSITN		0.00250	0.00000	0.01100	0.00000	0.00250	
<b>THRD_440FS(1)</b>			<b>CIR</b>				
X		-1.15077	1.15000	0.00197	-0.00197	0.00077	
Z		0.34984	0.35000	0.00197	-0.00197	-0.00016	
<b>POS_440FS(1)</b>			<b>AXI</b>				
POSITN		0.00157	0.00000	0.01100	0.00000	0.00157	
<b>THRD_440FS(2)</b>			<b>CIR</b>				
X		-3.45035	3.45000			0.00035	
Z		0.34956	0.35000			-0.00044	
<b>POS_440FS(2)</b>			<b>AXI</b>				
POSITN		0.00112	0.00000	0.01100	0.00000	0.00112	
<b>DIA_P138(1)</b>			<b>CIR</b>				
DM		0.14239	0.13800	0.01000	0.00000	0.00439	
X		-2.08320	2.08200			0.00120	
Y		0.36036	0.36000			0.00036	
<b>POS_P138(1)</b>			<b>POI</b>				
POSITN		0.00251	0.00000	0.01500	0.00000	0.00251	
<b>DIA_P138(2)</b>			<b>CIR</b>				
DM		0.14229	0.13800	0.01000	0.00000	0.00429	
X		-2.86969	2.86900			0.00069	
Y		0.36055	0.36000			0.00055	
<b>POS_P138(2)</b>			<b>POI</b>				
POSITN		0.00176	0.00000	0.01500	0.00000	0.00176	
<b>DIA_P138(3)</b>			<b>CIR</b>				
DM		0.14231	0.13800	0.01000	0.00000	0.00431	
X		-5.23057	5.23000			0.00057	
Y		0.36073	0.36000			0.00073	
<b>POS_P138(3)</b>			<b>POI</b>				
POSITN		0.00184	0.00000	0.01500	0.00000	0.00184	
<b>DIA_P138(4)</b>			<b>CIR</b>				▶
DM		0.14247	0.13800	0.01000	0.00000	0.00447	

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

<b>DIA_P138(4)</b>		<b>CIR</b>					
X		-6.01722	6.01700			0.00022	
Y		0.36073	0.36000			0.00073	

<b>POS_P138(4)</b>		<b>POI</b>					
POSITN		0.00152	0.00000	0.01500	0.00000	0.00152	

<b>DIA_P138(5)</b>		<b>CIR</b>					
DM		0.14216	0.13800	0.01000	0.00000	0.00416	
X		-6.01760	6.01700			0.00060	
Y		1.14771	1.14700			0.00071	

<b>POS_P138(5)</b>		<b>POI</b>					
POSITN		0.00187	0.00000	0.01500	0.00000	0.00187	

<b>DIA_P138(6)</b>		<b>CIR</b>					
DM		0.14216	0.13800	0.01000	0.00000	0.00416	
X		-5.23073	5.23000			0.00073	
Y		1.14767	1.14700			0.00067	

<b>POS_P138(6)</b>		<b>POI</b>					
POSITN		0.00199	0.00000	0.01500	0.00000	0.00199	

<b>DIA_P138(7)</b>		<b>CIR</b>					
DM		0.14234	0.13800	0.01000	0.00000	0.00434	
X		-2.86941	2.86900			0.00041	
Y		1.14742	1.14700			0.00042	

<b>POS_P138(7)</b>		<b>POI</b>					
POSITN		0.00117	0.00000	0.01500	0.00000	0.00117	

<b>DIA_P138(8)</b>		<b>CIR</b>					
DM		0.14232	0.13800	0.01000	0.00000	0.00432	
X		-2.08293	2.08200			0.00093	
Y		1.14740	1.14700			0.00040	

<b>POS_P138(8)</b>		<b>POI</b>					
POSITN		0.00203	0.00000	0.01500	0.00000	0.00203	

<b>DIST_P075</b>		<b>AXI</b>					
DX		0.07603	0.07500	0.00500	-0.00500	0.00103	

<b>SYMAXI_P075</b>		<b>AXI</b>					
X		-2.08256	2.08200			0.00056	

<b>DIST_P04</b>		<b>AXI</b>					
DX		0.03736	0.04000	0.02000	-0.02000	-0.00264	

<b>DIA_P30</b>		<b>CIR</b>					
FORM		0.00003					
DM		0.29914	0.30000	0.02000	-0.02000	-0.00086	
X		-2.08262	2.08200			0.00062	
Y		0.36053	0.36000			0.00053	

<b>CHAM\$PT(1)</b>		<b>POI</b>					
Y		0.24635	0.25000	0.02000	-0.02000	-0.00365	

<b>CHAM\$PT(2)</b>		<b>POI</b>					
Z		0.24541	0.25000	0.02000	-0.02000	-0.00459	

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

**DIA\_P216(1)**

**CIR**

DM		0.22096	0.21600	0.01000	0.00000	0.00496	
Y		0.25091	0.25000			0.00091	
Z		0.75071	0.75000			0.00071	

**POS\_P216(1)**

**POI**

POSITN		0.00230	0.00000	0.01400	0.00000	0.00230	
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**DIA\_P216(2)**

**CIR**

DM		0.22116	0.21600	0.01000	0.00000	0.00516	
Y		1.25021	1.25000			0.00021	
Z		0.75028	0.75000			0.00028	

**POS\_P216(2)**

**POI**

POSITN		0.00070	0.00000	0.01400	0.00000	0.00070	
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MANUAL MEASUREMENTS			
DIMENSION	TOLERANCE	ACTUAL	ACCEPTABLE/REJECT
ALL 4-40 UNC-2B THREADS ARE OKAY CHECKED W/ JO PLUG/GAGE			
CBORE .276	± 0.005	0.276	ACCEPTABLE
DEPTH .22	± 0.020	0.218	ACCEPTABLE

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