

Quindos Measuring Report



3D-Application Center

Description	SLITS SUPPORT	Customer	R. ATKINSON
Drawing Number	PF-391-940-63 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	24629-12	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	28-APR-2009, 08:31:11
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	0.00028	0.00000			0.00028	
DAT\$PLA_C		PLA					
	FORM	0.00007	0.00000			0.00007	
PLA_1P50		PLA					
	Y	1.50131	1.50000	0.02000	-0.02000	0.00131	
	FORM	0.00025					
PLA_6P45		PLA					
	X	-6.45112	6.45000	0.02000	-0.02000	0.00112	
	FORM	0.00015					
PLA_1P00		PLA					
	Z	0.99809	1.00000	0.02000	-0.02000	-0.00191	
PLA_P90		PLA					
	Z	0.89853	0.90000	0.02000	-0.02000	-0.00147	
PLA_P48		PLA					
	Z	0.47866	0.48000	0.02000	-0.02000	-0.00134	
PLA_P45		PLA					
	X	-0.45062	0.45000	0.02000	-0.02000	0.00062	
PLA_1P58		PLA					
	X	-1.58061	1.58000	0.02000	-0.02000	0.00061	
PLA_P56		PLA					
	Y	0.56099	0.56000	0.02000	-0.02000	0.00099	
DIST_P38		AXI					
	DY	0.37973	0.38000	0.02000	-0.02000	-0.00027	
ANG_26		PLA					
	PA_PZMX	25.96347	26.00000	1.00000	-1.00000	-0.03653	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
DISTANCE			AXI				
DZ		0.22212	0.22000	0.02000	-0.02000	0.00212	
DIST_2P02			AXI				
DX		2.02459	2.02000	0.02000	-0.02000	0.00459	
DIST_P75			AXI				
DX		0.74894	0.75000	0.02000	-0.02000	-0.00106	
RAD_P38(1)			CIR				
RA		0.37576	0.38000	0.02000	-0.02000	-0.00424	
RAD_P38(2)			CIR				
RA		0.37492	0.38000	0.02000	-0.02000	-0.00508	
ANG_110			PLA				
PA_PYPX		109.99500	110.00000	1.00000	-1.00000	-0.00500	
PLA_P500(1)			PLA				
FORM		0.00006	0.00000	0.00200	0.00000	0.00006	
Z		0.49913	0.50000	0.00500	-0.00500	-0.00087	
PLA_P500(2)			PLA				
FORM		0.00016	0.00000	0.00200	0.00000	0.00016	
Z		0.49820	0.50000	0.00500	-0.00500	-0.00180	
DIA_P50			CIR				
DM		0.50167	0.50000	0.02000	-0.02000	0.00167	
X		-4.05151	4.05100			0.00051	
Y		0.75038	0.75000			0.00038	
POS_P50			POI				
POSITN		0.00128	0.00000	0.01400	0.00000	0.00128	
RAD_P12			CIR				
RA		0.12745	0.12000	0.02000	-0.02000	0.00745	
THRD_440T(1)			CYL				
X		-4.05216	4.05100			0.00116	
Y		0.10091	0.10000			0.00091	
POS_440T(1)			AXI				
POSITN		0.00298	0.00000	0.01100	0.00000	0.00298	
THRD_440T(4)			CYL				
X		-4.05185	4.05100			0.00085	
Y		1.40134	1.40000			0.00134	
POS_440T(4)			AXI				
POSITN		0.00342	0.00000	0.01100	0.00000	0.00342	
THRD_440T(2)			CYL				
X		-4.05271	4.05100			0.00171	
Y		0.37354	0.37500			-0.00146	
POS_440T(2)			AXI				
POSITN		0.00519	0.00000	0.01100	0.00000	0.00519	
THRD_440T(3)			CYL				
X		-4.05172	4.05100			0.00072	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
THRD_440T(3)			CYL				◀
	Y	1.12608	1.12500			0.00108	
POS_440T(3)			AXI				
	POSITN	0.00273	0.00000	0.01100	0.00000	0.00273	
THRD_440NS(1)			CIR				
	X	-1.15037	1.15000			0.00037	
	Z	0.35081	0.35000			0.00081	
POS_440NS(1)			AXI				
	POSITN	0.00178	0.00000	0.01100	0.00000	0.00178	
THRD_440NS(2)			CIR				
	X	-3.45100	3.45000			0.00100	
	Z	0.34999	0.35000			-0.00001	
POS_440NS(2)			AXI				
	POSITN	0.00200	0.00000	0.01100	0.00000	0.00200	
THRD_440FS(1)			CIR				
	X	-1.15050	1.15000	0.00197	-0.00197	0.00050	
	Z	0.34986	0.35000	0.00197	-0.00197	-0.00014	
POS_440FS(1)			AXI				
	POSITN	0.00103	0.00000	0.01100	0.00000	0.00103	
THRD_440FS(2)			CIR				
	X	-3.45037	3.45000			0.00037	
	Z	0.34972	0.35000			-0.00028	
POS_440FS(2)			AXI				
	POSITN	0.00092	0.00000	0.01100	0.00000	0.00092	
DIA_P138(1)			CIR				
	DM	0.14220	0.13800	0.01000	0.00000	0.00420	
	X	-2.08293	2.08200			0.00093	
	Y	0.36058	0.36000			0.00058	
POS_P138(1)			POI				
	POSITN	0.00220	0.00000	0.01500	0.00000	0.00220	
DIA_P138(2)			CIR				
	DM	0.14240	0.13800	0.01000	0.00000	0.00440	
	X	-2.87000	2.86900			0.00100	
	Y	0.36040	0.36000			0.00040	
POS_P138(2)			POI				
	POSITN	0.00215	0.00000	0.01500	0.00000	0.00215	
DIA_P138(3)			CIR				
	DM	0.14256	0.13800	0.01000	0.00000	0.00456	
	X	-5.23014	5.23000			0.00014	
	Y	0.36049	0.36000			0.00049	
POS_P138(3)			POI				
	POSITN	0.00102	0.00000	0.01500	0.00000	0.00102	
DIA_P138(4)			CIR				▶
	DM	0.14196	0.13800	0.01000	0.00000	0.00396	

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Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DIA_P138(4)		CIR					
X		-6.01775	6.01700			0.00075	◀
Y		0.36040	0.36000			0.00040	
POS_P138(4)		POI					
POSITN		0.00169	0.00000	0.01500	0.00000	0.00169	
DIA_P138(5)		CIR					
DM		0.14215	0.13800	0.01000	0.00000	0.00415	
X		-6.01752	6.01700			0.00052	
Y		1.14769	1.14700			0.00069	
POS_P138(5)		POI					
POSITN		0.00172	0.00000	0.01500	0.00000	0.00172	
DIA_P138(6)		CIR					
DM		0.14208	0.13800	0.01000	0.00000	0.00408	
X		-5.23054	5.23000			0.00054	
Y		1.14728	1.14700			0.00028	
POS_P138(6)		POI					
POSITN		0.00121	0.00000	0.01500	0.00000	0.00121	
DIA_P138(7)		CIR					
DM		0.14225	0.13800	0.01000	0.00000	0.00425	
X		-2.86941	2.86900			0.00041	
Y		1.14781	1.14700			0.00081	
POS_P138(7)		POI					
POSITN		0.00182	0.00000	0.01500	0.00000	0.00182	
DIA_P138(8)		CIR					
DM		0.14227	0.13800	0.01000	0.00000	0.00427	
X		-2.08203	2.08200			0.00003	
Y		1.14766	1.14700			0.00066	
POS_P138(8)		POI					
POSITN		0.00131	0.00000	0.01500	0.00000	0.00131	
DIST_P075		AXI					
DX		0.07618	0.07500	0.00500	-0.00500	0.00118	
SYMAXI_P075		AXI					
X		-2.08267	2.08200			0.00067	
DIST_P04		AXI					
DX		0.03782	0.04000	0.02000	-0.02000	-0.00218	
DIA_P30		CIR					
FORM		0.00003					
DM		0.29919	0.30000	0.02000	-0.02000	-0.00081	
X		-2.08274	2.08200			0.00074	
Y		0.36066	0.36000			0.00066	
CHAM\$PT(1)		POI					
Y		0.25164	0.25000	0.02000	-0.02000	0.00164	
CHAM\$PT(2)		POI					
Z		0.25112	0.25000	0.02000	-0.02000	0.00112	

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DIA_P216(1)

CIR

DM		0.22110	0.21600	0.01000	0.00000	0.00510	
Y		0.24916	0.25000			-0.00084	
Z		0.75022	0.75000			0.00022	

POS_P216(1)

POI

POSITN		0.00173	0.00000	0.01400	0.00000	0.00173	
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DIA_P216(2)

CIR

DM		0.22118	0.21600	0.01000	0.00000	0.00518	
Y		1.24883	1.25000			-0.00117	
Z		0.75025	0.75000			0.00025	

POS_P216(2)

POI

POSITN		0.00239	0.00000	0.01400	0.00000	0.00239	
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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

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