

Quindos Measuring Report



3D-Application Center

Description	SHAFT GUIDE BLOCK	Customer	E. BONG
Drawing Number	PF-451-038-91 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	24462-21	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	10-MAR-2009, 09:08:15
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9005-R-
User Name	kcaban	WKP Name	PF45103891

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
DAT\$PLA_A		PLA					
	FORM	0.00016					
DAT\$PLA_B		PLA					
	FORM	0.00008	0.00000			0.00008	
DAT\$PLA_C		PLA					
	FORM	0.00004					
SQRNS_A		PLA					
	SQRNES	0.00017	0.00000	0.00300	0.00000	0.00017	
SQRNS_B		PLA					
	SQRNES	0.00267	0.00000	0.00500	0.00000	0.00267	
DIST_P622		AXI					
	X	0.62169	0.62200	0.00500	-0.00500	-0.00031	
DIST_2P78		PLA					
	X	-2.78682	2.78000	0.01500	0.00000	0.00682	
MINMAX_2P78		PLA					
	MIN_DIS	2.78666	2.78000	0.01500	0.00000	0.00666	
	MAX_DIS	2.78691	2.78000	0.01500	0.00000	0.00691	
DIST_4P00		AXI					
	DX	-3.99930	4.00000	0.01000	-0.01000	-0.00070	
DIST_P25		AXI					
	Y	-0.24997	0.25000	0.01000	-0.01000	-0.00003	
DIST_1P25		AXI					
	DY	1.25148	1.25000	0.01000	-0.01000	0.00148	
DIST_1P95		AXI					
	DY	1.94951	1.95000	0.01000	-0.01000	-0.00049	
ANG_45		AXI					
	PA_PXPY	45.00288	45.00000	0.05000	-0.05000	0.00288	

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
DIST_P40(1)			AXI				
	DX	-0.40148	0.40000	0.01000	-0.01000	0.00148	
ANG_45(1)			AXI				
	PA_PYMX	44.99162	45.00000	0.50000	-0.50000	-0.00838	
DIST_P40(2)			AXI				
	DX	0.40032	0.40000	0.01000	-0.01000	0.00032	
DIST_2P65			POI				
	Z	-2.64828	2.65000	0.01000	-0.01000	-0.00172	
THRD_716_20			CIR				
	X	-1.37648	1.37800	0.00500	-0.00500	-0.00152	
	Y	0.50047	0.50000	0.00500	-0.00500	0.00047	
M6(1)			CIR				
	X	-0.25573	0.25600	0.00500	-0.00500	-0.00027	
M6(2)			CIR				
	X	-0.25556	0.25600	0.00500	-0.00500	-0.00044	
DIST_1P772(1)			AXI				
	DZ	-1.77136	1.77200	0.00500	-0.00500	-0.00064	
DIST_1P772(2)			AXI				
	DZ	-1.77171	1.77200	0.00500	-0.00500	-0.00029	
DIST_2P244(1)			AXI				
	DX	-2.24580	2.24400	0.00500	-0.00500	0.00180	
DIST_2P244(2)			AXI				
	DX	-2.24435	2.24400	0.00500	-0.00500	0.00035	
DIST_P98(1)			AXI				
	DY	0.97989	0.98000	0.01000	-0.01000	-0.00011	
DIST_1P50			AXI				
	DZ	1.50013	1.50000	0.01000	-0.01000	0.00013	
DIST_P14			AXI				
	DY	-0.13941	0.14000	0.01000	-0.01000	-0.00059	
DIST_P40(3)			AXI				
	DZ	-0.39834	0.40000	0.01000	-0.01000	-0.00166	
DIA_P2504(2)			CIR				
	Z	-1.31953	1.32000	0.01000	-0.01000	-0.00047	
DIST_P98(2)			AXI				
	DY	0.98042	0.98000	0.01000	-0.01000	0.00042	
DIA_P2510			CIR				
	DM	0.25137	0.25100	0.00050	-0.00050	0.00037	
	X	1.74993	1.75000	0.00500	-0.00500	-0.00007	
	Y	0.87464	0.87500	0.00500	-0.00500	-0.00036	
THRD_516_18(1)			CIR				
	X	1.74967	1.75000	0.00500	-0.00500	-0.00033	
	Y	0.30006	0.30000	0.00500	-0.00500	0.00006	

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

THRD_516_18(2)		CIR					
X		1.74988	1.75000	0.00500	-0.00500	-0.00012	
Y		1.44989	1.45000	0.00500	-0.00500	-0.00011	

SLOT		AXI					
LA_DIS		0.38053	0.38000	0.01000	-0.01000	0.00053	
SM_DIS		0.25332	0.25100	0.00400	0.00000	0.00232	
X		-1.74996	1.75000	0.00500	-0.00500	-0.00004	
Y		0.87489	0.87500	0.00500	-0.00500	-0.00011	

DEPTH_P350		POI					
Z		-0.34661	0.35000	0.01000	-0.01000	-0.00339	

THRD_516_18(3)		CIR					
X		-1.74974	1.75000	0.00500	-0.00500	-0.00026	
Y		1.45010	1.45000	0.00500	-0.00500	0.00010	

THRD_516_18(4)		CIR					
X		-1.75025	1.75000	0.00500	-0.00500	0.00025	
Y		0.30003	0.30000	0.00500	-0.00500	0.00003	

DIST_3P500(1)		AXI					
DX		-3.49992	3.50000	0.00500	-0.00500	-0.00008	

DIST_3P500(2)		AXI					
DX		-3.49962	3.50000	0.00500	-0.00500	-0.00038	

DIST_3P500(3)		AXI					
DX		3.49989	3.50000	0.00500	-0.00500	-0.00011	

MANUAL MEASUREMENTS			
DIMENSION	TOLERANCE	ACTUAL	ACCEPTABLE/REJECT
DIA .2504	±0.0001	0.2505	ACCEPTABLE USING .2505 GAGE PIN
ALL CHAMFERS	-----	OK	ACCEPTABLE
ALL THRD DEPTHS	-----	OK	ACCEPTABLE USING
7/16-20 UNF-2B	-----	OK	ACCEPTABLE USING THRD GAGE
M6	-----	OK	ACCEPTABLE USING THRD GAGE
8-32 UNF-2B	-----	OK	ACCEPTABLE USING THRD GAGE
5/16-18 UNC-2B	-----	OK	ACCEPTABLE USING THRD GAGE

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