

Quindos Measuring Report



3D-Application Center

Description	SHAFT GUIDE BLOCK	Customer	E. BONG
Drawing Number	PF-451-038-91 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	24462-21	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	10-MAR-2009, 09:26:17
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	0.00015					
DAT\$PLA_B		PLA					
	FORM	0.00008	0.00000			0.00008	
DAT\$PLA_C		PLA					
	FORM	0.00004					
SQRNS_A		PLA					
	SQRNES	0.00025	0.00000	0.00300	0.00000	0.00025	
SQRNS_B		PLA					
	SQRNES	0.00341	0.00000	0.00500	0.00000	0.00341	
DIST_P622		AXI					
	X	0.62170	0.62200	0.00500	-0.00500	-0.00030	
DIST_2P78		PLA					
	X	-2.78691	2.78000	0.01500	0.00000	0.00691	
MINMAX_2P78		PLA					
	MIN_DIS	2.78673	2.78000	0.01500	0.00000	0.00673	
	MAX_DIS	2.78702	2.78000	0.01500	0.00000	0.00702	
DIST_4P00		AXI					
	DX	-3.99941	4.00000	0.01000	-0.01000	-0.00059	
DIST_P25		AXI					
	Y	-0.25048	0.25000	0.01000	-0.01000	0.00048	
DIST_1P25		AXI					
	DY	1.25128	1.25000	0.01000	-0.01000	0.00128	
DIST_1P95		AXI					
	DY	1.94953	1.95000	0.01000	-0.01000	-0.00047	
ANG_45		AXI					
	PA_PXPY	45.00441	45.00000	0.05000	-0.05000	0.00441	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 10-Mar-09, 09:26:17		PF45103891				Page 1 of 3	

Date: 10-Mar-09, 09:26:17			PF45103891			Page 2 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
DIST_P40(1)			AXI				
DX		-0.40137	0.40000	0.01000	-0.01000	0.00137	
ANG_45(1)			AXI				
PA_PYMX		44.98695	45.00000	0.50000	-0.50000	-0.01305	
DIST_P40(2)			AXI				
DX		0.40012	0.40000	0.01000	-0.01000	0.00012	
DIST_2P65			POI				
Z		-2.64874	2.65000	0.01000	-0.01000	-0.00126	
THRD_716_20			CIR				
X		-1.37672	1.37800	0.00500	-0.00500	-0.00128	
Y		0.50070	0.50000	0.00500	-0.00500	0.00070	
M6(1)			CIR				
X		-0.25623	0.25600	0.00500	-0.00500	0.00023	
M6(2)			CIR				
X		-0.25469	0.25600	0.00500	-0.00500	-0.00131	
DIST_1P772(1)			AXI				
DZ		-1.77105	1.77200	0.00500	-0.00500	-0.00095	
DIST_1P772(2)			AXI				
DZ		-1.77111	1.77200	0.00500	-0.00500	-0.00089	
DIST_2P244(1)			AXI				
DX		-2.24535	2.24400	0.00500	-0.00500	0.00135	
DIST_2P244(2)			AXI				
DX		-2.24296	2.24400	0.00500	-0.00500	-0.00104	
DIST_P98(1)			AXI				
DY		0.98101	0.98000	0.01000	-0.01000	0.00101	
DIST_1P50			AXI				
DZ		1.50052	1.50000	0.01000	-0.01000	0.00052	
DIST_P14			AXI				
DY		-0.14029	0.14000	0.01000	-0.01000	0.00029	
DIST_P40(3)			AXI				
DZ		-0.39826	0.40000	0.01000	-0.01000	-0.00174	
DIA_P2504(2)			CIR				
Z		-1.31969	1.32000	0.01000	-0.01000	-0.00031	
DIST_P98(2)			AXI				
DY		0.98011	0.98000	0.01000	-0.01000	0.00011	
DIA_P2510			CIR				
DM		0.25147	0.25100	0.00050	-0.00050	0.00047	
X		1.74991	1.75000	0.00500	-0.00500	-0.00009	
Y		0.87426	0.87500	0.00500	-0.00500	-0.00074	
THRD_516_18(1)			CIR				
X		1.75007	1.75000	0.00500	-0.00500	0.00007	
Y		0.29919	0.30000	0.00500	-0.00500	-0.00081	

Date: 10-Mar-09, 09:26:17			PF45103891			Page 3 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

THRD_516_18(2)		CIR					
X		1.75050	1.75000	0.00500	-0.00500	0.00050	
Y		1.44854	1.45000	0.00500	-0.00500	-0.00146	

SLOT		AXI					
LA_DIS		0.38035	0.38000	0.01000	-0.01000	0.00035	
SM_DIS		0.25331	0.25100	0.00400	0.00000	0.00231	
X		-1.74984	1.75000	0.00500	-0.00500	-0.00016	
Y		0.87448	0.87500	0.00500	-0.00500	-0.00052	

DEPTH_P350		POI					
Z		-0.34756	0.35000	0.01000	-0.01000	-0.00244	

THRD_516_18(3)		CIR					
X		-1.74934	1.75000	0.00500	-0.00500	-0.00066	
Y		1.44929	1.45000	0.00500	-0.00500	-0.00071	

THRD_516_18(4)		CIR					
X		-1.74963	1.75000	0.00500	-0.00500	-0.00037	
Y		0.29974	0.30000	0.00500	-0.00500	-0.00026	

DIST_3P500(1)		AXI					
DX		-3.49970	3.50000	0.00500	-0.00500	-0.00030	

DIST_3P500(2)		AXI					
DX		-3.49984	3.50000	0.00500	-0.00500	-0.00016	

DIST_3P500(3)		AXI					
DX		3.49975	3.50000	0.00500	-0.00500	-0.00025	

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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Date: 10-Mar-09, 09:26:17			PF45103891			Page 3 of 3	