

Quindos Measuring Report



3D-Application Center

Description	SHAFT GUIDE BLOCK	Customer	E. BONG
Drawing Number	PF-451-038-91 R0	Serial Number	003
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	24461-63	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	24-MAR-2009, 11:36:15
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	0.00011					
DAT\$PLA_B		PLA					
	FORM	0.00014	0.00000			0.00014	
DAT\$PLA_C		PLA					
	FORM	0.00006					
SQRNS_A		PLA					
	SQRNES	0.00045	0.00000	0.00300	0.00000	0.00045	
SQRNS_B		PLA					
	SQRNES	0.00033	0.00000	0.00500	0.00000	0.00033	
DIST_P622		AXI					
	X	0.62212	0.62200	0.00500	-0.00500	0.00012	
DIST_2P78		PLA					
	X	-2.78375	2.78000	0.01500	0.00000	0.00375	
MINMAX_2P78		PLA					
	MIN_DIS	2.78368	2.78000	0.01500	0.00000	0.00368	
	MAX_DIS	2.78389	2.78000	0.01500	0.00000	0.00389	
DIST_4P00		AXI					
	DX	-4.00006	4.00000	0.01000	-0.01000	0.00006	
DIST_P25		AXI					
	Y	-0.25014	0.25000	0.01000	-0.01000	0.00014	
DIST_1P25		AXI					
	DY	1.25142	1.25000	0.01000	-0.01000	0.00142	
DIST_1P95		AXI					
	DY	1.95066	1.95000	0.01000	-0.01000	0.00066	
ANG_45		AXI					
	PA_PXPY	45.01552	45.00000	0.05000	-0.05000	0.01552	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Date: 24-Mar-09, 11:36:15			PF45103891			Page 2 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
DIST_P40(1)			AXI				
	DX	-0.40515	0.40000	0.01000	-0.01000	0.00515	
ANG_45(1)			AXI				
	PA_PYMX	44.98000	45.00000	0.50000	-0.50000	-0.02000	
DIST_P40(2)			AXI				
	DX	0.40553	0.40000	0.01000	-0.01000	0.00553	
DIST_2P65			POI				
	Z	-2.64899	2.65000	0.01000	-0.01000	-0.00101	
THRD_716_20			CIR				
	X	-1.38060	1.37800	0.00500	-0.00500	0.00260	
	Y	0.49911	0.50000	0.00500	-0.00500	-0.00089	
M6(1)			CIR				
	X	-0.25788	0.25600	0.00500	-0.00500	0.00188	
M6(2)			CIR				
	X	-0.25796	0.25600	0.00500	-0.00500	0.00196	
DIST_1P772(1)			AXI				
	DZ	-1.77627	1.77200	0.00500	-0.00500	0.00427	
DIST_1P772(2)			AXI				
	DZ	-1.77273	1.77200	0.00500	-0.00500	0.00073	
DIST_2P244(1)			AXI				
	DX	-2.24863	2.24400	0.00500	-0.00500	0.00463	
DIST_2P244(2)			AXI				
	DX	-2.24830	2.24400	0.00500	-0.00500	0.00430	
DIST_P98(1)			AXI				
	DY	0.97655	0.98000	0.01000	-0.01000	-0.00345	
DIST_1P50			AXI				
	DZ	1.50085	1.50000	0.01000	-0.01000	0.00085	
DIST_P14			AXI				
	DY	-0.14128	0.14000	0.01000	-0.01000	0.00128	
DIST_P40(3)			AXI				
	DZ	-0.39733	0.40000	0.01000	-0.01000	-0.00267	
DIA_P2504(2)			CIR				
	Z	-1.32571	1.32000	0.01000	-0.01000	0.00571	
DIST_P98(2)			AXI				
	DY	0.97656	0.98000	0.01000	-0.01000	-0.00344	
DIA_P2510			CIR				
	DM	0.25184	0.25100	0.00050	-0.00050	0.00084	0.00034
	X	1.75045	1.75000	0.00500	-0.00500	0.00045	
	Y	0.87690	0.87500	0.00500	-0.00500	0.00190	
THRD_516_18(1)			CIR				
	X	1.74852	1.75000	0.00500	-0.00500	-0.00148	
	Y	0.30273	0.30000	0.00500	-0.00500	0.00273	

THRD_516_18(2)		CIR					
X		1.75003	1.75000	0.00500	-0.00500	0.00003	
Y		1.45166	1.45000	0.00500	-0.00500	0.00166	

SLOT		AXI					
LA_DIS		0.37973	0.38000	0.01000	-0.01000	-0.00027	
SM_DIS		0.25228	0.25100	0.00400	0.00000	0.00128	
X		-1.74976	1.75000	0.00500	-0.00500	-0.00024	
Y		0.87702	0.87500	0.00500	-0.00500	0.00202	

DEPTH_P350		POI					
Z		-0.34974	0.35000	0.01000	-0.01000	-0.00026	

THRD_516_18(3)		CIR					
X		-1.75154	1.75000	0.00500	-0.00500	0.00154	
Y		1.45163	1.45000	0.00500	-0.00500	0.00163	

THRD_516_18(4)		CIR					
X		-1.75104	1.75000	0.00500	-0.00500	0.00104	
Y		0.30219	0.30000	0.00500	-0.00500	0.00219	

DIST_3P500(1)		AXI					
DX		-3.49956	3.50000	0.00500	-0.00500	-0.00044	

DIST_3P500(2)		AXI					
DX		-3.50157	3.50000	0.00500	-0.00500	0.00157	

DIST_3P500(3)		AXI					
DX		3.50021	3.50000	0.00500	-0.00500	0.00021	

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