

Quindos Measuring Report



3D-Application Center

Description	SHAFT GUIDE BLOCK	Customer	E. BONG
Drawing Number	PF-451-038-91 R0	Serial Number	004
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, 13:28:51
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	0.00012					
DAT\$PLA_B		PLA					
	FORM	0.00008	0.00000			0.00008	
DAT\$PLA_C		PLA					
	FORM	0.00003					
SQRNS_A		PLA					
	SQRNES	0.00019	0.00000	0.00300	0.00000	0.00019	
SQRNS_B		PLA					
	SQRNES	0.00022	0.00000	0.00500	0.00000	0.00022	
DIST_P622		AXI					
	X	0.62214	0.62200	0.00500	-0.00500	0.00014	
DIST_2P78		PLA					
	X	-2.78364	2.78000	0.01500	0.00000	0.00364	
MINMAX_2P78		PLA					
	MIN_DIS	2.78362	2.78000	0.01500	0.00000	0.00362	
	MAX_DIS	2.78369	2.78000	0.01500	0.00000	0.00369	
DIST_4P00		AXI					
	DX	-4.00030	4.00000	0.01000	-0.01000	0.00030	
DIST_P25		AXI					
	Y	-0.24986	0.25000	0.01000	-0.01000	-0.00014	
DIST_1P25		AXI					
	DY	1.25112	1.25000	0.01000	-0.01000	0.00112	
DIST_1P95		AXI					
	DY	1.95022	1.95000	0.01000	-0.01000	0.00022	
ANG_45		AXI					
	PA_PXPY	45.02122	45.00000	0.05000	-0.05000	0.02122	

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
Date: 24-Mar-09, 13:28:53				PF45103891		Page 1 of 3	

Date: 24-Mar-09, 13:28:53			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		44.97995	45.00000	0.50000	-0.50000	-0.02005	
DIST_P40(2)			AXI				
DX		0.40577	0.40000	0.01000	-0.01000	0.00577	
DIST_2P65			POI				
Z		-2.65020	2.65000	0.01000	-0.01000	0.00020	
THRD_716_20			CIR				
X		-1.37917	1.37800	0.00500	-0.00500	0.00117	
Y		0.49931	0.50000	0.00500	-0.00500	-0.00069	
M6(1)			CIR				
X		-0.25800	0.25600	0.00500	-0.00500	0.00200	
M6(2)			CIR				
X		-0.25852	0.25600	0.00500	-0.00500	0.00252	
DIST_1P772(1)			AXI				
DZ		-1.77136	1.77200	0.00500	-0.00500	-0.00064	
DIST_1P772(2)			AXI				
DZ		-1.77382	1.77200	0.00500	-0.00500	0.00182	
DIST_2P244(1)			AXI				
DX		-2.24823	2.24400	0.00500	-0.00500	0.00423	
DIST_2P244(2)			AXI				
DX		-2.24932	2.24400	0.00500	-0.00500	0.00532	0.00032
DIST_P98(1)			AXI				
DY		0.97670	0.98000	0.01000	-0.01000	-0.00330	
DIST_1P50			AXI				
DZ		1.50086	1.50000	0.01000	-0.01000	0.00086	
DIST_P14			AXI				
DY		-0.13994	0.14000	0.01000	-0.01000	-0.00006	
DIST_P40(3)			AXI				
DZ		-0.39858	0.40000	0.01000	-0.01000	-0.00142	
DIA_P2504(2)			CIR				
Z		-1.32604	1.32000	0.01000	-0.01000	0.00604	
DIST_P98(2)			AXI				
DY		0.97635	0.98000	0.01000	-0.01000	-0.00365	
DIA_P2510			CIR				
DM		0.25190	0.25100	0.00050	-0.00050	0.00090	0.00040
X		1.75050	1.75000	0.00500	-0.00500	0.00050	
Y		0.87720	0.87500	0.00500	-0.00500	0.00220	
THRD_516_18(1)			CIR				
X		1.74886	1.75000	0.00500	-0.00500	-0.00114	
Y		0.30170	0.30000	0.00500	-0.00500	0.00170	

Date: 24-Mar-09, 13:28:53			PF45103891			Page 3 of 3	
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THRD_516_18(2)		CIR					
X		1.74847	1.75000	0.00500	-0.00500	-0.00153	
Y		1.45245	1.45000	0.00500	-0.00500	0.00245	

SLOT		AXI					
LA_DIS		0.37973	0.38000	0.01000	-0.01000	-0.00027	
SM_DIS		0.25233	0.25100	0.00400	0.00000	0.00133	
X		-1.74959	1.75000	0.00500	-0.00500	-0.00041	
Y		0.87708	0.87500	0.00500	-0.00500	0.00208	

DEPTH_P350		POI					
Z		-0.34968	0.35000	0.01000	-0.01000	-0.00032	

THRD_516_18(3)		CIR					
X		-1.75158	1.75000	0.00500	-0.00500	0.00158	
Y		1.45093	1.45000	0.00500	-0.00500	0.00093	

THRD_516_18(4)		CIR					
X		-1.75196	1.75000	0.00500	-0.00500	0.00196	
Y		0.30207	0.30000	0.00500	-0.00500	0.00207	

DIST_3P500(1)		AXI					
DX		-3.50082	3.50000	0.00500	-0.00500	0.00082	

DIST_3P500(2)		AXI					
DX		-3.50005	3.50000	0.00500	-0.00500	0.00005	

DIST_3P500(3)		AXI					
DX		3.50009	3.50000	0.00500	-0.00500	0.00009	

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: 24-Mar-09, 13:28:53			PF45103891			Page 3 of 3	