

# 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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Date: 10-Mar-09, 09:08:15			PF45103891			Page 2 of 3	
Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>DIST_P40(1)</b>			<b>AXI</b>				
DX		-0.40148	0.40000	0.01000	-0.01000	0.00148	
<b>ANG_45(1)</b>			<b>AXI</b>				
PA_PYMX		44.99162	45.00000	0.50000	-0.50000	-0.00838	
<b>DIST_P40(2)</b>			<b>AXI</b>				
DX		0.40032	0.40000	0.01000	-0.01000	0.00032	
<b>DIST_2P65</b>			<b>POI</b>				
Z		-2.64828	2.65000	0.01000	-0.01000	-0.00172	
<b>THRD_716_20</b>			<b>CIR</b>				
X		-1.37648	1.37800	0.00500	-0.00500	-0.00152	
Y		0.50047	0.50000	0.00500	-0.00500	0.00047	
<b>M6(1)</b>			<b>CIR</b>				
X		-0.25573	0.25600	0.00500	-0.00500	-0.00027	
<b>M6(2)</b>			<b>CIR</b>				
X		-0.25556	0.25600	0.00500	-0.00500	-0.00044	
<b>DIST_1P772(1)</b>			<b>AXI</b>				
DZ		-1.77136	1.77200	0.00500	-0.00500	-0.00064	
<b>DIST_1P772(2)</b>			<b>AXI</b>				
DZ		-1.77171	1.77200	0.00500	-0.00500	-0.00029	
<b>DIST_2P244(1)</b>			<b>AXI</b>				
DX		-2.24580	2.24400	0.00500	-0.00500	0.00180	
<b>DIST_2P244(2)</b>			<b>AXI</b>				
DX		-2.24435	2.24400	0.00500	-0.00500	0.00035	
<b>DIST_P98(1)</b>			<b>AXI</b>				
DY		0.97989	0.98000	0.01000	-0.01000	-0.00011	
<b>DIST_1P50</b>			<b>AXI</b>				
DZ		1.50013	1.50000	0.01000	-0.01000	0.00013	
<b>DIST_P14</b>			<b>AXI</b>				
DY		-0.13941	0.14000	0.01000	-0.01000	-0.00059	
<b>DIST_P40(3)</b>			<b>AXI</b>				
DZ		-0.39834	0.40000	0.01000	-0.01000	-0.00166	
<b>DIA_P2504(2)</b>			<b>CIR</b>				
Z		-1.31953	1.32000	0.01000	-0.01000	-0.00047	
<b>DIST_P98(2)</b>			<b>AXI</b>				
DY		0.98042	0.98000	0.01000	-0.01000	0.00042	
<b>DIA_P2510</b>			<b>CIR</b>				
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	
<b>THRD_516_18(1)</b>			<b>CIR</b>				
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

<b>THRD_516_18(2)</b>		<b>CIR</b>					
X		1.74988	1.75000	0.00500	-0.00500	-0.00012	
Y		1.44989	1.45000	0.00500	-0.00500	-0.00011	

<b>SLOT</b>		<b>AXI</b>					
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	

<b>DEPTH_P350</b>		<b>POI</b>					
Z		-0.34661	0.35000	0.01000	-0.01000	-0.00339	

<b>THRD_516_18(3)</b>		<b>CIR</b>					
X		-1.74974	1.75000	0.00500	-0.00500	-0.00026	
Y		1.45010	1.45000	0.00500	-0.00500	0.00010	

<b>THRD_516_18(4)</b>		<b>CIR</b>					
X		-1.75025	1.75000	0.00500	-0.00500	0.00025	
Y		0.30003	0.30000	0.00500	-0.00500	0.00003	

<b>DIST_3P500(1)</b>		<b>AXI</b>					
DX		-3.49992	3.50000	0.00500	-0.00500	-0.00008	

<b>DIST_3P500(2)</b>		<b>AXI</b>					
DX		-3.49962	3.50000	0.00500	-0.00500	-0.00038	

<b>DIST_3P500(3)</b>		<b>AXI</b>					
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
!-----!			

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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# 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
<b>DIST_P40(1)</b>			<b>AXI</b>				
	DX	-0.40137	0.40000	0.01000	-0.01000	0.00137	
<b>ANG_45(1)</b>			<b>AXI</b>				
	PA_PYMX	44.98695	45.00000	0.50000	-0.50000	-0.01305	
<b>DIST_P40(2)</b>			<b>AXI</b>				
	DX	0.40012	0.40000	0.01000	-0.01000	0.00012	
<b>DIST_2P65</b>			<b>POI</b>				
	Z	-2.64874	2.65000	0.01000	-0.01000	-0.00126	
<b>THRD_716_20</b>			<b>CIR</b>				
	X	-1.37672	1.37800	0.00500	-0.00500	-0.00128	
	Y	0.50070	0.50000	0.00500	-0.00500	0.00070	
<b>M6(1)</b>			<b>CIR</b>				
	X	-0.25623	0.25600	0.00500	-0.00500	0.00023	
<b>M6(2)</b>			<b>CIR</b>				
	X	-0.25469	0.25600	0.00500	-0.00500	-0.00131	
<b>DIST_1P772(1)</b>			<b>AXI</b>				
	DZ	-1.77105	1.77200	0.00500	-0.00500	-0.00095	
<b>DIST_1P772(2)</b>			<b>AXI</b>				
	DZ	-1.77111	1.77200	0.00500	-0.00500	-0.00089	
<b>DIST_2P244(1)</b>			<b>AXI</b>				
	DX	-2.24535	2.24400	0.00500	-0.00500	0.00135	
<b>DIST_2P244(2)</b>			<b>AXI</b>				
	DX	-2.24296	2.24400	0.00500	-0.00500	-0.00104	
<b>DIST_P98(1)</b>			<b>AXI</b>				
	DY	0.98101	0.98000	0.01000	-0.01000	0.00101	
<b>DIST_1P50</b>			<b>AXI</b>				
	DZ	1.50052	1.50000	0.01000	-0.01000	0.00052	
<b>DIST_P14</b>			<b>AXI</b>				
	DY	-0.14029	0.14000	0.01000	-0.01000	0.00029	
<b>DIST_P40(3)</b>			<b>AXI</b>				
	DZ	-0.39826	0.40000	0.01000	-0.01000	-0.00174	
<b>DIA_P2504(2)</b>			<b>CIR</b>				
	Z	-1.31969	1.32000	0.01000	-0.01000	-0.00031	
<b>DIST_P98(2)</b>			<b>AXI</b>				
	DY	0.98011	0.98000	0.01000	-0.01000	0.00011	
<b>DIA_P2510</b>			<b>CIR</b>				
	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	
<b>THRD_516_18(1)</b>			<b>CIR</b>				
	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

<b>THRD_516_18(2)</b>		<b>CIR</b>					
X		1.75050	1.75000	0.00500	-0.00500	0.00050	
Y		1.44854	1.45000	0.00500	-0.00500	-0.00146	

<b>SLOT</b>		<b>AXI</b>					
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	

<b>DEPTH_P350</b>		<b>POI</b>					
Z		-0.34756	0.35000	0.01000	-0.01000	-0.00244	

<b>THRD_516_18(3)</b>		<b>CIR</b>					
X		-1.74934	1.75000	0.00500	-0.00500	-0.00066	
Y		1.44929	1.45000	0.00500	-0.00500	-0.00071	

<b>THRD_516_18(4)</b>		<b>CIR</b>					
X		-1.74963	1.75000	0.00500	-0.00500	-0.00037	
Y		0.29974	0.30000	0.00500	-0.00500	-0.00026	

<b>DIST_3P500(1)</b>		<b>AXI</b>					
DX		-3.49970	3.50000	0.00500	-0.00500	-0.00030	

<b>DIST_3P500(2)</b>		<b>AXI</b>					
DX		-3.49984	3.50000	0.00500	-0.00500	-0.00016	

<b>DIST_3P500(3)</b>		<b>AXI</b>					
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

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

# 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
Date: 24-Mar-09, 11:36:15		PF45103891				Page 1 of 3	

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



<b>THRD_516_18(2)</b>		<b>CIR</b>					
X		1.75003	1.75000	0.00500	-0.00500	0.00003	
Y		1.45166	1.45000	0.00500	-0.00500	0.00166	

<b>SLOT</b>		<b>AXI</b>					
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	

<b>DEPTH_P350</b>		<b>POI</b>					
Z		-0.34974	0.35000	0.01000	-0.01000	-0.00026	

<b>THRD_516_18(3)</b>		<b>CIR</b>					
X		-1.75154	1.75000	0.00500	-0.00500	0.00154	
Y		1.45163	1.45000	0.00500	-0.00500	0.00163	

<b>THRD_516_18(4)</b>		<b>CIR</b>					
X		-1.75104	1.75000	0.00500	-0.00500	0.00104	
Y		0.30219	0.30000	0.00500	-0.00500	0.00219	

<b>DIST_3P500(1)</b>		<b>AXI</b>					
DX		-3.49956	3.50000	0.00500	-0.00500	-0.00044	

<b>DIST_3P500(2)</b>		<b>AXI</b>					
DX		-3.50157	3.50000	0.00500	-0.00500	0.00157	

<b>DIST_3P500(3)</b>		<b>AXI</b>					
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

# 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
<b>DIST_P40(1)</b>			<b>AXI</b>				
	DX	-0.40515	0.40000	0.01000	-0.01000	0.00515	
<b>ANG_45(1)</b>			<b>AXI</b>				
	PA_PYMX	44.97995	45.00000	0.50000	-0.50000	-0.02005	
<b>DIST_P40(2)</b>			<b>AXI</b>				
	DX	0.40577	0.40000	0.01000	-0.01000	0.00577	
<b>DIST_2P65</b>			<b>POI</b>				
	Z	-2.65020	2.65000	0.01000	-0.01000	0.00020	
<b>THRD_716_20</b>			<b>CIR</b>				
	X	-1.37917	1.37800	0.00500	-0.00500	0.00117	
	Y	0.49931	0.50000	0.00500	-0.00500	-0.00069	
<b>M6(1)</b>			<b>CIR</b>				
	X	-0.25800	0.25600	0.00500	-0.00500	0.00200	
<b>M6(2)</b>			<b>CIR</b>				
	X	-0.25852	0.25600	0.00500	-0.00500	0.00252	
<b>DIST_1P772(1)</b>			<b>AXI</b>				
	DZ	-1.77136	1.77200	0.00500	-0.00500	-0.00064	
<b>DIST_1P772(2)</b>			<b>AXI</b>				
	DZ	-1.77382	1.77200	0.00500	-0.00500	0.00182	
<b>DIST_2P244(1)</b>			<b>AXI</b>				
	DX	-2.24823	2.24400	0.00500	-0.00500	0.00423	
<b>DIST_2P244(2)</b>			<b>AXI</b>				
	DX	-2.24932	2.24400	0.00500	-0.00500	0.00532	<b>0.00032</b>
<b>DIST_P98(1)</b>			<b>AXI</b>				
	DY	0.97670	0.98000	0.01000	-0.01000	-0.00330	
<b>DIST_1P50</b>			<b>AXI</b>				
	DZ	1.50086	1.50000	0.01000	-0.01000	0.00086	
<b>DIST_P14</b>			<b>AXI</b>				
	DY	-0.13994	0.14000	0.01000	-0.01000	-0.00006	
<b>DIST_P40(3)</b>			<b>AXI</b>				
	DZ	-0.39858	0.40000	0.01000	-0.01000	-0.00142	
<b>DIA_P2504(2)</b>			<b>CIR</b>				
	Z	-1.32604	1.32000	0.01000	-0.01000	0.00604	
<b>DIST_P98(2)</b>			<b>AXI</b>				
	DY	0.97635	0.98000	0.01000	-0.01000	-0.00365	
<b>DIA_P2510</b>			<b>CIR</b>				
	DM	0.25190	0.25100	0.00050	-0.00050	0.00090	<b>0.00040</b>
	X	1.75050	1.75000	0.00500	-0.00500	0.00050	
	Y	0.87720	0.87500	0.00500	-0.00500	0.00220	
<b>THRD_516_18(1)</b>			<b>CIR</b>				
	X	1.74886	1.75000	0.00500	-0.00500	-0.00114	
	Y	0.30170	0.30000	0.00500	-0.00500	0.00170	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
Date: 24-Mar-09, 13:28:53			PF45103891			Page 2 of 3	

<b>THRD_516_18(2)</b>		<b>CIR</b>					
X		1.74847	1.75000	0.00500	-0.00500	-0.00153	
Y		1.45245	1.45000	0.00500	-0.00500	0.00245	

<b>SLOT</b>		<b>AXI</b>					
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	

<b>DEPTH_P350</b>		<b>POI</b>					
Z		-0.34968	0.35000	0.01000	-0.01000	-0.00032	

<b>THRD_516_18(3)</b>		<b>CIR</b>					
X		-1.75158	1.75000	0.00500	-0.00500	0.00158	
Y		1.45093	1.45000	0.00500	-0.00500	0.00093	

<b>THRD_516_18(4)</b>		<b>CIR</b>					
X		-1.75196	1.75000	0.00500	-0.00500	0.00196	
Y		0.30207	0.30000	0.00500	-0.00500	0.00207	

<b>DIST_3P500(1)</b>		<b>AXI</b>					
DX		-3.50082	3.50000	0.00500	-0.00500	0.00082	

<b>DIST_3P500(2)</b>		<b>AXI</b>					
DX		-3.50005	3.50000	0.00500	-0.00500	0.00005	

<b>DIST_3P500(3)</b>		<b>AXI</b>					
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