

Measurement Plan

QC-CALC Database

Order number
A69139

[-]_20

QC-CALC Database Path
I:\PROLINK\RAW_DATA\

Part Number

Workpiece Rev.

Comment
Rev Date 01-27-20

Page
Page 1 of 3



































Operator
Master G2-2

Time/Date
1/28/20 2:05 PM

No. measured values
55

No. values: red
0

Part ident
3

Name	Value	Nominal Value	Upper Allowance	Lower Allowance	Deviation	+/-
 Ref X Value1 QCC	0.5161	0.5150			0.0011	
 Ref Y Value1 QCC	0.5160	0.5150			0.0010	
 Ref #1,1d2 Flat_.002 Datum A	0.0001	0.0000	0.0020	0.0000	0.0001	
 Ref #2,1d2 1.365 ±.010	-1.3660	-1.3650	0.0100	-0.0100	-0.0010	
 Ref #3,1d2 .965 ±.010	-0.9650	-0.9650	0.0100	-0.0100	0.0000	
 Ref #5.01,1d2 Ø.075 ±.010	0.0741	0.0750	0.0100	-0.0100	-0.0009	
 Ref #5.02,1d2 Ø.075 ±.010	0.0741	0.0750	0.0100	-0.0100	-0.0009	
 Ref #5.03,1d2 Ø.075 ±.010	0.0735	0.0750	0.0100	-0.0100	-0.0015	
 #7.01,1d2 TP_Ø.014M_A_B	0.0049	0.0000	0.0249	0.0000	0.0049	
 Y Value	-0.6500	-0.6500			0.0000	
 Z Value	-1.1626	-1.1650			0.0024	
 #7.02,1d2 TP_Ø.014M_A_B	0.0058	0.0000	0.0249	0.0000	0.0058	
 Y Value	0.6471	0.6500			-0.0029	
 Z Value	-1.1653	-1.1650			-0.0003	
 #7.03,1d2 TP_Ø.014M_A_B	0.0045	0.0000	0.0255	0.0000	0.0045	
 Z Value	-1.1628	-1.1650			0.0022	
 X Value	0.6504	0.6500			0.0004	























ZEISS CALYPSO

6.4.08

Part name
Part ident
Operator
Time/Date

██████████ -_20_01-27-20
3
Master G2-2
1/28/20 2:05 PM

Name	Value	Nominal Value	Upper Allowance	Lower Allowance	Deviation	+/-
 #8.01,1c2 .075 Basic	0.0763	0.0750			0.0013	
 #8.02,1c2 .075 Basic	0.0790	0.0750			0.0040	
 #8.03,1c2 .075 Basic	0.0758	0.0750			0.0008	
 #9.01,1c2 .200 Basic	0.2021	0.2000			0.0021	
 #9.02,1c2 .200 Basic	0.2019	0.2000			0.0019	
 #9.03,1c2 .200 Basic	0.2019	0.2000			0.0019	
 Ref #10,1c2 Ø1.450 ±.010	1.4530	1.4500	0.0100	-0.0100	0.0030	
 Ref #12,1c2 Per_.002M_A No modifier applied	0.0006	0.0000	0.0020	0.0000	0.0006	
 X Value	0.0004	0.0009			-0.0004	
 Y Value	-0.0001	0.0002			-0.0003	
 Ref #13,1c2 Ø1.3636-1.3750	1.3733	1.3693	0.0057	-0.0057	0.0040	
 Ref #16.01,1c1 1.269-1.312	1.2931	1.2906	0.0215	-0.0215	0.0025	
 Ref #16.02,1c1 1.269-1.312	1.2932	1.2906	0.0215	-0.0215	0.0026	
 Ref #16.03,1c1 1.269-1.312	1.2925	1.2906	0.0215	-0.0215	0.0019	
 #17.01,1c1 EQ SP Ref 60°	59.9695	60.0000			-0.0305	
 #17.02,1c1 EQ SP Ref 60°	60.0514	60.0000			0.0514	
 #17.03,1c1 EQ SP Ref 60°	60.0267	60.0000			0.0267	
 #18.01,1c1 TP_.030M_A_B@M No modifier for Datum B applied	0.0010	0.0000	0.0490	0.0000	0.0010	
 Y Value	-0.0005	0.0000			-0.0005	
 #18.02,1c1 TP_.030M_A_B@M No modifier for Datum B applied	0.0005	0.0000	0.0300	0.0000	0.0005	
 Y Value	-0.0003	0.0000			-0.0003	



ZEISS CALYPSO

6.4.08

Part name 2 [REDACTED] -_20_01-27-20
 Part ident 3
 Operator Master G2-2
 Time/Date 1/28/20 2:05 PM

Name	Value	Nominal Value	Upper Allowance	Lower Allowance	Deviation	+/-
#18.03,1c1 TP_.030M_A_B@M	0.0010	0.0000	0.0490	0.0000	0.0010	
Y Value	-0.0005	0.0000			-0.0005	
Ref #19,1b2 1.260-1.270	-1.2629	-1.2650	0.0050	-0.0050	0.0021	
Ref #21,1b3 Ø1.025-1.035	1.0318	1.0300	0.0050	-0.0050	0.0018	
Ref #25,1b4 Ø1.250 ±.010	1.2538	1.2500	0.0100	-0.0100	0.0038	

Ref #38 Note 11

Ref #38,1c4-1 Hex OD to Datum B	0.0012	0.0000	0.0050	0.0000	0.0012	
Ref #38,1c4-2 Ref #21 at entry to Datum B	0.0003	0.0000	0.0050	0.0000	0.0003	
Ref #38,1c4-3 Ref #21 at depth to Datum B	0.0001	0.0000	0.0050	0.0000	0.0001	
Ref #38,1c4-4 Ref #25 to Datum B	0.0003	0.0000	0.0050	0.0000	0.0003	
Ref #38,1c4 Ro_.005	0.0012	0.0000	0.0050	0.0000	0.0012	
Ref X Value1 QCC1 If out of tolerance part may have moved in fixture. Re-run program.	0.5161	0.5161	0.0003	-0.0003	0.0000	
Ref Y Value1 QCC1 If out of tolerance part may have moved in fixture. Re-run program.	0.5160	0.5160	0.0003	-0.0003	0.0000	