



Customer **The QC Group**
 Date **January 12, 2015**
 Inspector **Bob Johnson**
 WO# **2015xxxx-W02**

Part Name **Drum Casting**
 Part # **-**
 Rev. **A2**
 Lot # **-**



Results are reported in **INCHES**

DIM #	NOMINAL	+TOL	-TOL	DESCRIPTION	PART 1	PART 2	PART 3	INSPECTION
					Actual	Actual	Actual	EQUIPMENT USED
1	8.622	.005	.005	Diameter	8.6235	8.6211	8.6228	Touch Probe CMM 2185
2	.000	.008	.000	Cylindricity	.0060	.0051	.0073	Touch Probe CMM 2185
3	4.325	.005	.005	Diameter	4.3259	4.3216	4.3232	Touch Probe CMM 2185
4	.454	.005	.005	Depth	.4551	.4574	.4566	Touch Probe CMM 2185
5	.610	.005	.005	Depth	.6065	.6057	.6051	Touch Probe CMM 2185
6	.945	.005	.005	Depth	.9385	.9384	.9386	Touch Probe CMM 2185
7	1.695	.005	.005	Depth	1.6991	1.6996	1.6989	Touch Probe CMM 2185
8	1.870	.005	.005	Depth	1.8704	1.8723	1.8722	Touch Probe CMM 2185
9	.875	.005	.005	Diameter	.8788	.8766	.8787	Vision CMM 1293
10A	.438	.005	.005	Diameter	.4365	.4357	.4374	Vision CMM 1293
10B	.438	.005	.005	Diameter	.4381	.4383	.4385	Vision CMM 1293
10C	.438	.005	.005	Diameter	.4321	.4324	.4330	Vision CMM 1293
10D	.438	.005	.005	Diameter	.4401	.4418	.4424	Vision CMM 1293
11A	.50	.01	.01	Diameter	.4968	.4984	.4981	Vision CMM 1293
11B	.50	.01	.01	Diameter	.5041	.5040	.5057	Vision CMM 1293
11C	.50	.01	.01	Diameter	.4934	.4929	.4944	Vision CMM 1293
11D	.50	.01	.01	Diameter	.5021	.5037	.5022	Vision CMM 1293
12	5.350	.005	.005	Diameter	5.3510	5.3489	5.3522	Calculated
13A	.000	.010	.000	Position	.0035	.0038	.0042	Calculated
13A	2.675			Radial Basic	2.6733	2.6749	2.6739	Touch Probe CMM 2185
13A	0.00			Angle Basic	.0100	.0410	.0380	Touch Probe CMM 2185
13B	.000	.010	.000	Position	.0185	.0108	.0119	Calculated
13B	2.675			Radial Basic	2.6749	2.6747	2.6753	Touch Probe CMM 2185
13B	90.0			Angle Basic	90.1980	90.1150	90.1270	Touch Probe CMM 2185
13C	.000	.010	.000	Position	.0017	.0063	.0055	Calculated
13C	2.675			Radial Basic	2.6751	2.6781	2.6741	Touch Probe CMM 2185
13C	180.0			Angle Basic	180.0180	180.0114	180.0560	Touch Probe CMM 2185
13D	.000	.010	.000	Position	.0079	.0071	.0062	Calculated
13D	2.675			Radial Basic	2.6748	2.6743	2.6753	Touch Probe CMM 2185
13D	90.0			Angle Basic	90.0840	90.0745	90.0659	Touch Probe CMM 2185
14A	90	.5	.5	Angle	90.0100	89.9590	89.9620	Touch Probe CMM 2185
14B	90	.5	.5	Angle	90.1980	90.1150	90.1270	Touch Probe CMM 2185
14C	90	.5	.5	Angle	89.9340	89.9369	89.9901	Touch Probe CMM 2185
14D	90	.5	.5	Angle	90.0840	90.0745	90.0659	Touch Probe CMM 2185
15	0	32	0	Surface Finish	12.15	13.85	13.55	Profilometer 1234*
16	2.970	.005	.005	Height	2.9749	2.9748	2.9750	Touch Probe CMM 2185
17	0	.005	0	Parallelism	.0045	.0038	.0041	Touch Probe CMM 2185
18	2.720	.005	.005	Height	2.7216	2.7198	2.7231	Touch Probe CMM 2185
19	0	.005	0	Parallelism	.0034	.0023	.0018	Touch Probe CMM 2185
20	3.158	.005	.005	Height	3.1561	3.1595	3.1602	Touch Probe CMM 2185
21	.180	.005	.005	Height	.1689	.1687	.1678	Touch Probe CMM 2185
22	6.500	.005	.005	Diameter	6.4968	6.5032	6.4981	Touch Probe CMM 2185
23	.969	.005	.005	Diameter	.9702	.9724	.9717	Touch Probe CMM 2185
24	8.433	.005	.005	Diameter	8.4377	8.4358	8.4344	Touch Probe CMM 2185
25	7.563	.005	.005	Diameter	7.5631	7.5656	7.5648	Touch Probe CMM 2185

- Notes:**
1. Equipment marked with an asterisk * fall outside The QC Group's A2LA accreditation for measurement.
 2. Results highlighted yellow are near the high or low limit (>80% of the tolerance). Results in red text are out of tolerance.
 3. Dim 6 measured surface does not appear very flat as drawn. Almost domed or radius feature present.
 4. Dim 10C is very rough and appears to have burrs. Tried to clean out but did not improve the numbers much.