Test Lab Work Request Form

Rev.3 –20 April, 2000

Date Submitted: 8-1-2005	**Tracking # : TLW 1813**
Project # : 241285	**Engineer: Ronkainen**

Test Objective: Run a quick screening inspection on production SPL sear safety cam blanks (P/N 300384) per the attached drawing (3 linear dimensions, 2 angular dimensions).

Test Description: Inspect samples of production SPL sear safety cam blanks from two cavities for conformance to 5 dimensions (see accompanying drawing) using the provided datum simulator fixture. Label the parts and bag each separately. Record the requested dimensional information for each part by the ID number. Measure the angles and linear dimensions "as-is" and then measure the minimum and maximum dimensions while holding the angles BASIC. The number of samples from each cavity is not yet known, but will be somewhere on the order of 10 to 15 pieces from each cavity. A quick qualification of the datum simulator fixture will be necessary as it has recently been modified.

Resource Usage:	**Test Results Required:**
Manpower Requirements –	**Formal Report: Data Only: XX**
Facility Requirements – CMM	**Requested Completion Date: 8/4/2005**

Required Materials/Parts/Equipment (include quantities):

XX samples of the sear safety cam blanks
1 sear safety cam datum simulator fixture
1 marked up drawing

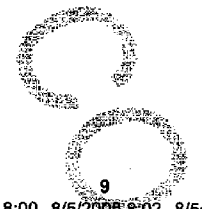
Test Parts Availability Date: 8/2/2005?

Start Date: 4 Aug 2005	**Test Assigned To: Jody Carson**
Completion Date: 5 Aug 2005	
Report Date:	**Assignment Date: 08/05/2005**

Completed as requested.

ET33930

Cavity 1				Part Number	1	2	3	4	5
Part Program	Nominal	Plus Tol	Minus Tol	Seq# Data	8/5/2005 7:49	8/5/2005 7:51	8/5/2005 7:53	8/5/2005 7:55	8/5/2005 7:56
D-300684 - Ronk Safety Cam				Inspector	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
Center Point	0.101	0.0025	0.0025	1Y	[redacted]				
Upper Left Point	0.101	0.0025	0.0025	2Y					
Upper Right Point	0.101	0.0025	0.0025	3Y					
Lower Left Point	0.101	0.0025	0.0025	4Y					
Lower Right Point	0.101	0.0025	0.0025	5Y					
Line Form	0	0.0005	0	6FM	0.0004	0.0002	0.0003	0.0002	0.0003
Angle	20	0.5	0.5	7AN	[redacted]				
Distance to Angled Line	0.101	0.0025	0.0025	8Y					
Center Point	1.3815	0.0025	0.0025	9X					
Upper Left Point	1.3815	0.0025	0.0025	10X					
Upper Right Point	1.3815	0.0025	0.0025	11X					
Lower Left Point	1.3815	0.0025	0.0025	12X					
Lower Right Point	1.3815	0.0025	0.0025	13X					
Line Form	0	0.0005	0	14FM	0.0003	0.0002	0.0002	0.0003	
Angle	106	0.5	0.5	15AN	[redacted]	106.2570	106.1735	[redacted]	106.2208
Distance to Angled Line	1.3815	0.0025	0.0025	16X					
Center Point	0.905	0.005	0.005	17X	0.9084	0.9081	0.9087	0.9091	0.9084
Upper Left Point	0.905	0.005	0.005	18X	0.9088	0.9085	0.9088	0.9094	0.9088
Upper Right Point	0.905	0.005	0.005	19X	0.9091	0.9088	0.9090	0.9096	0.9090
Lower Left Point	0.905	0.005	0.005	20X	0.9090	0.9087	0.9093	0.9097	0.9091
Lower Right Point	0.905	0.005	0.005	21X	0.9093	0.9090	0.9093	0.9100	0.9093
Line Form	0	0.0005	0	22FM	0.0002	0.0002	0.0001	0.0002	0.0004
Angle	90	0.5	0.5	23AN	90.0911	89.8554	89.8899	90.2731	89.6552
Distance to Angled Line	0.905	0.005	0.005	24X	0.9088	0.9077	0.9084	[redacted]	0.9073
Fixture Check	0.148	0.0003	0.0003	25Y	0.1479	0.1479	0.1479	0.1479	0.1479



6	7	8	9	10	11	12	13	14	15
8/5/2005 7:57	8/5/2005 7:58	8/5/2005 8:00	8/5/2005 8:02	8/5/2005 8:04	8/5/2005 8:05	8/5/2005 8:06	8/5/2005 8:08	8/5/2005 8:09	8/5/2005 8:11
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
[redacted]									
0.0002	0.0002	0.0002	0.0002	0.0002	0.0003	0.0002	0.0003	0.0002	0.0003
[redacted]									
[redacted]						1.3839			
[redacted]						1.3839			
[redacted]						1.3840			
[redacted]						[redacted]			
[redacted]						1.3840			
0.0004	0.0003	0.0003	0.0001	0.0001	0.0004	0.0001	0.0002	0.0001	0.0001
106.3460	106.4567	106.3410	106.0085	106.0521	[redacted]	106.0223	106.0638	106.1108	105.9926
[redacted]	1.3840	[redacted]			1.3838	1.3839		[redacted]	
0.9080	0.9080	0.9081	0.9081	0.9084	0.9080	0.9078	0.9079	0.9080	0.9085
0.9084	0.9083	0.9081	0.9084	0.9086	0.9083	0.9080	0.9082	0.9083	0.9087
0.9086	0.9086	0.9087	0.9086	0.9089	0.9085	0.9083	0.9084	0.9086	0.9091
0.9087	0.9086	0.9087	0.9087	0.9088	0.9085	0.9082	0.9085	0.9084	0.9090
0.9090	0.9089	0.9090	0.9090	0.9091	0.9088	0.9085	0.9088	0.9089	0.9093
0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002
89.8953	90.1595	90.0967	89.9365	89.9277	90.3459	89.7032	90.1135	90.1081	90.2129
0.9078	0.9085	0.9084	0.9079	0.9082	0.9091	0.9068	0.9082	0.9083	0.9091
0.1479	0.1479	0.1479	0.1479	0.1479	0.1479	0.1479	0.1479	0.1479	0.1479

16	17	18	19	20	21	22	23	24	25
8/5/2005 8:12	8/5/2005 8:14	8/5/2005 8:15	8/5/2005 8:17	8/5/2005 8:18	8/5/2005 8:20	8/5/2005 8:21	8/5/2005 8:22	8/5/2005 8:23	8/5/2005 8:24
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
0.1052	0.1052	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	0.1044	[illegible]
0.1048	0.1048	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	0.1041	0.1053
0.1050	0.1050	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	0.1041	0.1051
0.1052	0.1051	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	0.1044	0.1053
0.1055	0.1054	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	0.1046	0.1055
0.0003	0.0003	0.0002	0.0003	0.0002	0.0003	0.0003	0.0003	0.0003	0.0002
18.7184	18.6010	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	18.0988
0.0757	0.0710	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	0.0807
1.3851	1.3851	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	1.3851
1.3851	1.3852	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	1.3850
1.3852	1.3852	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	1.3847
1.3851	1.3851	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	1.3848
1.3852	1.3852	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	1.3848
0.0002	0.0004	0.0003	0.0001	0.0002	0.0004	0.0004	0.0002	0.0003	0.0004
106.1038	106.1038	106.3850	106.0320	106.0448	106.2263	106.3787	106.0916	106.5089	106.0631
1.3851	1.3851	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	1.3848
0.9088	0.9089	0.9081	0.9076	0.9086	0.9086	0.9084	0.9086	0.9088	0.9083
0.9090	0.9091	0.9084	0.9080	0.9088	0.9089	0.9087	0.9088	0.9089	0.9086
0.9092	0.9094	0.9087	0.9081	0.9090	0.9091	0.9089	0.9091	0.9093	0.9089
0.9093	0.9094	0.9087	0.9082	0.9090	0.9092	0.9090	0.9091	0.9093	0.9089
0.9096	0.9095	0.9090	0.9084	0.9092	0.9094	0.9092	0.9094	0.9097	0.9092
0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002
90.3018	90.1511	90.1137	90.0286	90.0984	90.4182	90.1538	90.2272	90.1518	90.1991
0.9097	0.9093	0.9085	0.9076	0.9089	0.9099	0.9089	0.9092	0.9092	0.9090
0.1479	0.1479	0.1479	0.1479	0.1479	0.1478	0.1478	0.1478	0.1479	0.1478

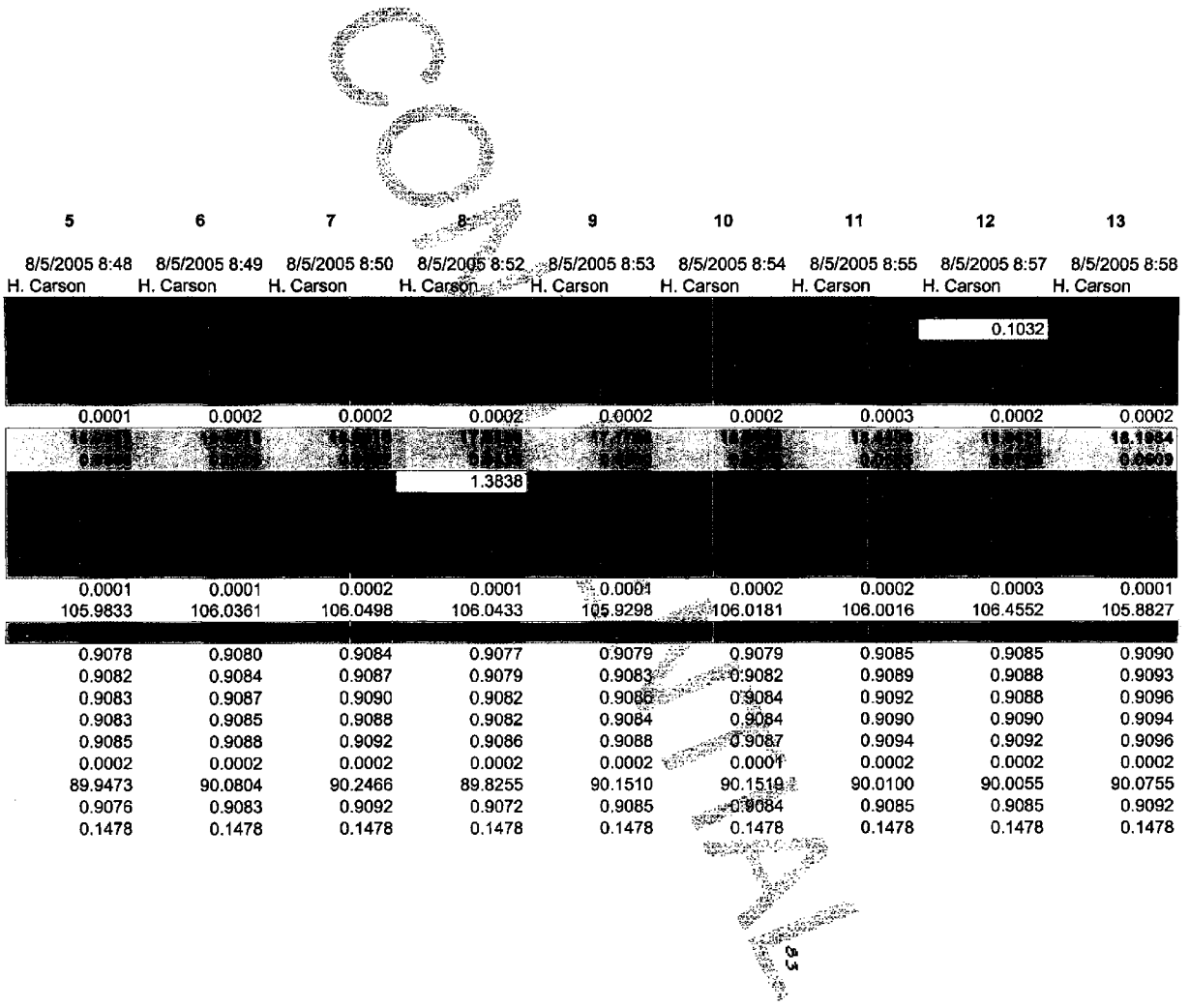
26	27	28	29	30	Individual Measurement Point Data Summary					Feature
8/5/2005 8:26	8/5/2005 8:27	8/5/2005 8:28	8/5/2005 8:29	8/5/2005 8:31	Avg	SD	Max	Min	Range	Avg
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson						
[redacted]					0.10495	0.00022	0.1054	0.1044	0.0010	0.10487
					0.10458	0.00024	0.1050	0.1041	0.0009	
					0.10469	0.00024	0.1052	0.1041	0.0011	
					0.10494	0.00024	0.1054	0.1044	0.0010	
					0.10520	0.00024	0.1057	0.1046	0.0011	
0.0002	0.0003	0.0002	0.0004	0.0002	0.00026	0.00006	0.0004	0.0002	0.0002	
[redacted]					18.69159	0.34165	19.3206	17.7753	1.5453	
					0.07291	0.00843	0.0886	0.0500	0.0386	
					1.38482	0.00045	1.3856	1.3839	0.0017	1.38482
					1.38483	0.00043	1.3856	1.3839	0.0018	
					1.38482	0.00043	1.3856	1.3840	0.0017	
					1.38484	0.00042	1.3857	1.3840	0.0017	
					1.38481	0.00043	1.3857	1.3840	0.0017	
0.0001	0.0004	0.0004	0.0002	0.0002	0.00028	0.00014	0.0007	0.0001	0.0006	
105.9301	[redacted]	106.3067	106.1691	105.9451	106.22364	0.21287	106.6989	105.9301	0.7688	
[redacted]					1.38464	0.00046	1.3857	1.3838	0.0019	
0.9091	0.9085	0.9087	0.9086	0.9089	0.90840	0.00039	0.9091	0.9076	0.0016	0.90884
0.9094	0.9088	0.9090	0.9090	0.9092	0.90868	0.00038	0.9094	0.9080	0.0015	
0.9097	0.9091	0.9092	0.9092	0.9095	0.90894	0.00039	0.9097	0.9081	0.0015	
0.9095	0.9091	0.9092	0.9092	0.9095	0.90895	0.00039	0.9097	0.9082	0.0016	
0.9098	0.9094	0.9095	0.9094	0.9098	0.90923	0.00037	0.9100	0.9084	0.0016	
0.0002	0.0002	0.0003	0.0003	0.0002	0.00021	0.00005	0.0004	0.0001	0.0003	
89.9138	90.0150	89.9207	89.8627	90.2828	90.07009	0.18412	90.4182	89.6552	0.7630	
0.9088	0.9086	0.9084	0.9082	0.9098	0.90862	0.00077	0.9100	0.9068	0.0032	
0.1478	0.1478	0.1478	0.1478	0.1478	0.14786	0.00002	0.1479	0.1478	0.0001	

ϵ Data Summary (All Points on Feature)

SD	Max	Min	Range
0.03910	0.1057	0.1041	0.0016
0.51743	1.3857	1.3839	0.0018
0.33957	0.9100	0.9076	0.0024

Cavity 2				Part Number	1	2	3	4
				Seq#				
Part Program	Nominal	Plus Tol	Minus Tol	DataType	8/5/2005 8:32	8/5/2005 8:44	8/5/2005 8:45	8/5/2005 8:46
D-300684 - Ronk Safety Cam				Inspector	H. Carson	H. Carson	H. Carson	H. Carson
Center Point	0.101	0.0025	0.0025	1Y	[illegible]	[illegible]	[illegible]	[illegible]
Upper Left Point	0.101	0.0025	0.0025	2Y	[illegible]	[illegible]	[illegible]	[illegible]
Upper Right Point	0.101	0.0025	0.0025	3Y	[illegible]	[illegible]	[illegible]	[illegible]
Lower Left Point	0.101	0.0025	0.0025	4Y	[illegible]	[illegible]	[illegible]	[illegible]
Lower Right Point	0.101	0.0025	0.0025	5Y	[illegible]	[illegible]	[illegible]	[illegible]
Line Form	0	0.0005	0	6FM	0.0003	0.0002	0.0001	0.0002
Angle	20	0.5	0.5	7AN	[illegible]	[illegible]	[illegible]	[illegible]
Distance to Angled Line	0.101	0.0025	0.0025	8Y	[illegible]	[illegible]	[illegible]	[illegible]
Center Point	1.3815	0.0025	0.0025	9X	[illegible]	[illegible]	[illegible]	[illegible]
Upper Left Point	1.3815	0.0025	0.0025	10X	[illegible]	[illegible]	[illegible]	[illegible]
Upper Right Point	1.3815	0.0025	0.0025	11X	[illegible]	[illegible]	[illegible]	[illegible]
Lower Left Point	1.3815	0.0025	0.0025	12X	[illegible]	[illegible]	[illegible]	[illegible]
Lower Right Point	1.3815	0.0025	0.0025	13X	[illegible]	[illegible]	[illegible]	[illegible]
Line Form	0	0.0005	0	14FM	0.0002	0.0001	0.0001	0.0002
Angle	106	0.5	0.5	15AN	106.1132	105.9324	106.0230	106.0520
Distance to Angled Line	1.3815	0.0025	0.0025	16X	[illegible]	[illegible]	[illegible]	[illegible]
Center Point	0.905	0.005	0.005	17X	0.9078	0.9081	0.9079	0.9086
Upper Left Point	0.905	0.005	0.005	18X	0.9082	0.9084	0.9082	0.9088
Upper Right Point	0.905	0.005	0.005	19X	0.9085	0.9076	0.9084	0.9089
Lower Left Point	0.905	0.005	0.005	20X	0.9082	0.9086	0.9084	0.9090
Lower Right Point	0.905	0.005	0.005	21X	0.9085	0.9087	0.9087	0.9093
Line Form	0	0.0005	0	22FM	0.0003	0.0003	0.0002	0.0002
Angle	90	0.5	0.5	23AN	89.8263	90.3172	90.0314	90.3350
Distance to Angled Line	0.905	0.005	0.005	24X	0.9072	0.9091	0.9080	0.9097
Fixture Check	0.148	0.0003	0.0003	25Y	0.1478	0.1478	0.1478	0.1478

[illegible] = under low limit
[illegible] = over high limit



5	6	7	8	9	10	11	12	13
8/5/2005 8:48	8/5/2005 8:49	8/5/2005 8:50	8/5/2005 8:52	8/5/2005 8:53	8/5/2005 8:54	8/5/2005 8:55	8/5/2005 8:57	8/5/2005 8:58
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
							0.1032	
0.0001	0.0002	0.0002	0.0002	0.0002	0.0002	0.0003	0.0002	0.0002
			1.3838					
0.0001	0.0001	0.0002	0.0001	0.0001	0.0002	0.0002	0.0003	0.0001
105.9833	106.0361	106.0498	106.0433	105.9298	106.0181	106.0016	106.4552	105.8827
0.9078	0.9080	0.9084	0.9077	0.9079	0.9079	0.9085	0.9085	0.9090
0.9082	0.9084	0.9087	0.9079	0.9083	0.9082	0.9089	0.9088	0.9093
0.9083	0.9087	0.9090	0.9082	0.9086	0.9084	0.9092	0.9088	0.9096
0.9083	0.9085	0.9088	0.9082	0.9084	0.9084	0.9090	0.9090	0.9094
0.9085	0.9088	0.9092	0.9086	0.9088	0.9087	0.9094	0.9092	0.9096
0.0002	0.0002	0.0002	0.0002	0.0002	0.0001	0.0002	0.0002	0.0002
89.9473	90.0804	90.2466	89.8255	90.1510	90.1519	90.0100	90.0055	90.0755
0.9076	0.9083	0.9092	0.9072	0.9085	0.9084	0.9085	0.9085	0.9092
0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478

14	15	16	17	18	19	20	21	22
8/5/2005 8:59	8/5/2005 9:00	8/5/2005 9:01	8/5/2005 9:03	8/5/2005 9:04	8/5/2005 9:05	8/5/2005 9:06	8/5/2005 9:08	8/5/2005 9:09
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
				0.1031				
				0.1035				
0.0002	0.0002	0.0002	0.0002	0.0002	0.0001	0.0002	0.0002	0.0003
[redacted]								
0.0001	0.0001	0.0003	0.0001	0.0001	0.0002	0.0002	0.0004	0.0002
105.9918	105.9735	106.1635	106.1136	106.0633	106.0747	105.9937	106.2300	106.0473
0.9089	0.9084	0.9082	0.9086	0.9087	0.9082	0.9083	0.9086	0.9088
0.9092	0.9088	0.9085	0.9088	0.9089	0.9085	0.9087	0.9088	0.9089
0.9094	0.9088	0.9087	0.9088	0.9091	0.9087	0.9089	0.9090	0.9091
0.9093	0.9088	0.9086	0.9090	0.9088	0.9086	0.9088	0.9089	0.9092
0.9096	0.9090	0.9089	0.9093	0.9092	0.9089	0.9091	0.9093	0.9094
0.0002	0.0002	0.0002	0.0002	0.0002	0.0001	0.0002	0.0002	0.0001
90.1160	90.3210	89.9105	90.2465	90.3182	90.0179	90.0605	90.1980	90.0955
0.9092	0.9094	0.9079	0.9095	0.9097	0.9083	0.9085	0.9092	0.9091
0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478

23	24	25	26	27	28	29	30	Individ
8/5/2005 9:10	8/5/2005 9:12	8/5/2005 9:13	8/5/2005 9:14	8/5/2005 9:15	8/5/2005 9:17	8/5/2005 9:18	8/5/2005 9:19	Avg
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	
[redacted]								0.10451
								0.10395
								0.10428
								0.10440
								0.10492
0.0002	0.0002	0.0002	0.0003	0.0001	0.0001	0.0003	0.0002	0.00019
[redacted]								18.05650
								0.05682
[redacted]								1.38480
								1.38485
								1.38488
								1.38484
								1.38486
0.0001	0.0001	0.0001	0.0002	0.0002	0.0002	0.0001	0.0001	0.00016
105.9914	105.9382	105.9140	105.9723	105.9675	105.9273	105.9030	105.9031	106.02296
[redacted]								1.38481
0.9081	0.9077	0.9077	0.9080	0.9082	0.9080	0.9090	0.9088	0.90828
0.9085	0.9080	0.9081	0.9082	0.9085	0.9085	0.9095	0.9091	0.90859
0.9088	0.9083	0.9082	0.9083	0.9088	0.9087	0.9097	0.9094	0.90877
0.9085	0.9081	0.9081	0.9084	0.9087	0.9085	0.9095	0.9093	0.90871
0.9088	0.9084	0.9084	0.9086	0.9088	0.9088	0.9097	0.9095	0.90899
0.0002	0.0002	0.0001	0.0002	0.0003	0.0002	0.0001	0.0002	0.00018
89.9763	90.1882	90.0962	90.1560	90.1328	90.0247	90.0191	90.1531	90.10114
0.9080	0.9083	0.9080	0.9085	0.9086	0.9081	0.9090	0.9092	0.90859
0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.1478	0.14780

ual Measurement Point Data Summary				Feature Data Summary (All Points on Feature)				
SD	Max	Min	Range	Avg	SD	Max	Min	Range
0.00027	0.1049	0.1038	0.0011	0.10441	0.03895	0.1055	0.1031	0.0024
0.00032	0.1045	0.1031	0.0014					
0.00030	0.1049	0.1035	0.0014					
0.00031	0.1050	0.1037	0.0013					
0.00029	0.1055	0.1043	0.0012					
0.00005	0.0003	0.0001	0.0002					
0.38826	18.9621	17.1985	1.7637					
0.00956	0.0785	0.0354	0.0431					
0.00047	1.3857	1.3838	0.0019	1.38484	0.51748	1.3858	1.3838	0.0019
0.00044	1.3857	1.3841	0.0015					
0.00044	1.3858	1.3842	0.0016					
0.00043	1.3857	1.3842	0.0015					
0.00043	1.3857	1.3842	0.0016					
0.00006	0.0004	0.0001	0.0003					
0.11437	106.4552	105.8827	0.5725					
0.00043	1.3858	1.3841	0.0017					
0.00040	0.9090	0.9077	0.0014	0.90867	0.33952	0.9097	0.9076	0.0021
0.00040	0.9095	0.9079	0.0015					
0.00045	0.9097	0.9076	0.0021					
0.00038	0.9095	0.9081	0.0014					
0.00038	0.9097	0.9084	0.0013					
0.00004	0.0003	0.0001	0.0002					
0.13643	90.3350	89.8255	0.5095					
0.00067	0.9097	0.9072	0.0024					
0.00001	0.1478	0.1478	0.0000					

Cavity 3				Part Number Seq#	1	2	3	4
Part Program	Nominal	Plus Tol	Minus Tol	DataType	8/4/2005 15:09	8/4/2005 15:10	8/4/2005 15:14	8/4/2005 15:16
D-300684 - Ronk Safety Cam				Inspector	H. Carson	H. Carson	H. Carson	H. Carson
Center Point	0.101	0.0025	0.0025	1Y	0.1021	0.1022	0.1019	0.1018
Upper Left Point	0.101	0.0025	0.0025	2Y	0.1014	0.1017	0.1014	0.1011
Upper Right Point	0.101	0.0025	0.0025	3Y	0.1018	0.1020	0.1018	0.1015
Lower Left Point	0.101	0.0025	0.0025	4Y	0.1016	0.1017	0.1014	0.1014
Lower Right Point	0.101	0.0025	0.0025	5Y	0.1024	0.1025	0.1023	0.1021
Line Form	0	0.0005	0	6FM	0.0002	0.0002	0.0002	0.0002
Angle	20	0.5	0.5	7AN	[illegible]	[illegible]	[illegible]	[illegible]
Distance to Angled Line	0.101	0.0025	0.0025	8Y	[illegible]	[illegible]	[illegible]	[illegible]
Center Point	1.3815	0.0025	0.0025	9X	1.3839	[illegible]	[illegible]	[illegible]
Upper Left Point	1.3815	0.0025	0.0025	10X	1.3839	[illegible]	[illegible]	1.3840
Upper Right Point	1.3815	0.0025	0.0025	11X	1.3838	[illegible]	[illegible]	1.3840
Lower Left Point	1.3815	0.0025	0.0025	12X	1.3839	[illegible]	[illegible]	1.3840
Lower Right Point	1.3815	0.0025	0.0025	13X	1.3839	[illegible]	[illegible]	[illegible]
Line Form	0	0.0005	0	14FM	0.0002	0.0002	0.0001	0.0001
Angle	106	0.5	0.5	15AN	106.0587	106.0073	105.9255	106.0176
Distance to Angled Line	1.3815	0.0025	0.0025	16X	1.3838	[illegible]	[illegible]	1.3839
Center Point	0.905	0.005	0.005	17X	0.9066	0.9075	0.9068	0.9067
Upper Left Point	0.905	0.005	0.005	18X	0.9067	0.9075	0.9069	0.9067
Upper Right Point	0.905	0.005	0.005	19X	0.9067	0.9074	0.9068	0.9067
Lower Left Point	0.905	0.005	0.005	20X	0.9067	0.9075	0.9067	0.9067
Lower Right Point	0.905	0.005	0.005	21X	0.9067	0.9075	0.9068	0.9067
Line Form	0	0.0005	0	22FM	0.0002	0.0001	0.0002	0.0001
Angle	90	0.5	0.5	23AN	89.9431	89.8390	90.0012	89.9199
Distance to Angled Line	0.905	0.005	0.005	24X	0.9065	0.9069	0.9068	0.9065
Fixture Check	0.1479	0.0003	0.0003	25Y	0.1477	0.1477	0.1477	0.1477

= under low limit
= over high limit

5	6	7	8	9	10	11	12	13
8/4/2005 15:17	8/4/2005 15:18	8/4/2005 15:20	8/4/2005 15:27	8/4/2005 15:29	8/4/2005 15:31	8/4/2005 15:33	8/4/2005 15:34	8/4/2005 15:39
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
0.1018	0.1017	0.1021	0.1017	0.1017	0.1022	0.1017	0.1021	0.1018
0.1014	0.1012	0.1015	0.1014	0.1011	0.1016	0.1013	0.1016	0.1012
0.1017	0.1015	0.1019	0.1021	0.1016	0.1020	0.1017	0.1022	0.1016
0.1015	0.1012	0.1014	0.1013	0.1011	0.1016	0.1012	0.1016	0.1013
0.1023	0.1021	0.1023	0.1025	0.1021	0.1025	0.1022	0.1026	0.1018
0.0002	0.0002	0.0002	[redacted]	0.0002	0.0002	0.0002	0.0003	0.0002
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	1.3835	[redacted]	1.3835
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	1.3834	[redacted]	1.3836
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	1.3834	[redacted]	1.3835
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	1.3834	[redacted]	1.3837
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	1.3835	[redacted]	1.3836
0.0001	0.0001	0.0002	0.0002	0.0001	0.0002	0.0002	0.0001	0.0001
105.9897	106.0295	105.9000	106.0162	105.9699	106.0407	106.0528	105.9098	106.1189
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	1.3840	1.3833	[redacted]	1.3834
0.9075	0.9070	0.9072	0.9073	0.9071	0.9068	0.9063	0.9073	0.9064
0.9075	0.9070	0.9072	0.9073	0.9070	0.9068	0.9063	0.9074	0.9061
0.9075	0.9070	0.9071	0.9073	0.9070	0.9068	0.9063	0.9073	0.9063
0.9075	0.9070	0.9072	0.9073	0.9071	0.9068	0.9063	0.9074	0.9063
0.9076	0.9070	0.9073	0.9074	0.9071	0.9069	0.9063	0.9075	0.9065
0.0002	0.0002	0.0003	0.0002	0.0001	0.0002	0.0002	0.0001	0.0002
89.8941	89.8303	[redacted]	89.9847	89.8872	89.7263	90.0931	89.8868	89.8966
0.9072	0.9065	0.9094	0.9073	0.9067	0.9059	0.9066	0.9070	0.9061
0.1477	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477

14	15	16	17	18	19	20	21	22
8/4/2005 15:41	8/4/2005 15:42	8/4/2005 15:43	8/4/2005 15:45	8/4/2005 15:46	8/4/2005 15:48	8/4/2005 15:49	8/4/2005 15:50	8/4/2005 15:51
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
0.1021	0.1021	0.1020	0.1018	0.1020	0.1020	0.1020	0.1020	0.1021
0.1015	0.1015	0.1015	0.1012	0.1014	0.1014	0.1016	0.1014	0.1015
0.1019	0.1020	0.1019	0.1015	0.1020	0.1021	0.1020	0.1019	0.1020
0.1015	0.1015	0.1014	0.1013	0.1014	0.1015	0.1016	0.1016	0.1016
0.1024	0.1025	0.1024	0.1021	0.1024	0.1025	0.1025	0.1025	0.1026
0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0003	0.0002	0.0002
[redacted]								
		1.3838	1.3834					
		1.3838	1.3835					
		1.3838	1.3835					
		1.3837	1.3835					
		1.3839	1.3835					
0.0002		0.0003	0.0002	0.0001	0.0002	0.0001	0.0001	0.0001
105.9230	106.2405	105.7741	106.0004	105.9477	106.0734	106.0465	106.0103	106.0123
		1.3840	1.3834					
0.9068	0.9072	0.9066	0.9063	0.9071	0.9069	0.9077	0.9071	0.9071
0.9069	0.9072	0.9065	0.9064	0.9070	0.9069	0.9077	0.9071	0.9071
0.9068	0.9071	0.9065	0.9063	0.9070	0.9068	0.9076	0.9071	0.9071
0.9068	0.9072	0.9065	0.9063	0.9071	0.9069	0.9076	0.9070	0.9070
0.9069	0.9073	0.9067	0.9065	0.9072	0.9070	0.9078	0.9071	0.9072
0.0002	0.0001	0.0001	0.0003	0.0002	0.0001	0.0002	0.0002	0.0001
89.9272	90.0244	90.0575	90.0021	90.0253	90.0069	90.0274	89.9258	89.9302
0.9066	0.9073	0.9067	0.9063	0.9072	0.9069	0.9078	0.9069	0.9069
0.1476	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477

23	24	25	26	27	28	29	30
8/4/2005 15:59	8/4/2005 16:01	8/4/2005 16:03	8/4/2005 16:08	8/4/2005 16:09	8/4/2005 16:11	8/4/2005 16:12	8/4/2005 16:13
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
0.1017	0.1018	0.1017	0.1021	0.1016	0.1020	0.1017	0.1021
0.1012	0.1012	0.1010	0.1016	0.1009	0.1014	0.1011	0.1015
0.1017	0.1016	0.1015	0.1020	0.1014	0.1018	0.1016	0.1020
0.1012	0.1013	0.1011	0.1016	0.1011	0.1016	0.1013	0.1017
0.1022	0.1022	0.1020	0.1026	0.1019	0.1025	0.1022	0.1026
0.0002	0.0002	0.0001	0.0001	0.0002	0.0002	0.0002	0.0002
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	1.3840	1.3833	[redacted]	1.3840	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	1.3834	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	1.3832	[redacted]	[redacted]	[redacted]	1.3840	[redacted]
[redacted]	[redacted]	1.3835	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	1.3833	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
0.0002	[redacted]	0.0002	0.0002	0.0001	0.0002	0.0002	0.0002
106.0477	105.5527	106.2231	105.9393	106.0517	106.0257	106.0473	106.0202
[redacted]	[redacted]	1.3831	[redacted]	1.3840	[redacted]	1.3839	[redacted]
0.9071	0.9068	0.9060	0.9068	0.9068	0.9073	0.9066	0.9072
0.9071	0.9068	0.9061	0.9069	0.9069	0.9073	0.9067	0.9072
0.9070	0.9068	0.9061	0.9069	0.9068	0.9073	0.9067	0.9072
0.9070	0.9068	0.9061	0.9068	0.9068	0.9073	0.9067	0.9072
0.9071	0.9070	0.9061	0.9070	0.9069	0.9073	0.9067	0.9073
0.0002	0.0001	0.0002	0.0001	0.0002	0.0001	0.0002	0.0001
89.8678	90.0729	90.0015	90.1002	89.9269	90.0055	89.9366	89.9114
0.9066	0.9071	0.9061	0.9072	0.9067	0.9074	0.9064	0.9069
0.1477	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477	0.1477

Cavity 4				Part Number	1	2	3	4
				Seq#				
Part Program	Nominal	Plus Tol	Minus Tol	DataType	8/4/2005 16:15	8/4/2005 16:17	8/4/2005 16:18	8/4/2005 16:20
D-300684 - Ronk Safety Cam				Inspector	H. Carson	H. Carson	H. Carson	H. Carson
Center Point	0.101	0.0025	0.0025	1Y	0.1023	0.1020	0.1026	0.1021
Upper Left Point	0.101	0.0025	0.0025	2Y	0.1014	0.1011	0.1016	0.1011
Upper Right Point	0.101	0.0025	0.0025	3Y	0.1022	0.1017	0.1023	0.1018
Lower Left Point	0.101	0.0025	0.0025	4Y	0.1021	0.1016	0.1024	0.1018
Lower Right Point	0.101	0.0025	0.0025	5Y	0.1028	0.1025	0.1031	0.1026
Line Form	0	0.0005	0	6FM	0.0001	0.0001	0.0002	0.0002
Angle	20	0.5	0.5	7AN	[illegible]	[illegible]	[illegible]	[illegible]
Distance to Angled Line	0.101	0.0025	0.0025	8Y	[illegible]	[illegible]	[illegible]	[illegible]
Center Point	1.3815	0.0025	0.0025	9X	[illegible]	[illegible]	[illegible]	[illegible]
Upper Left Point	1.3815	0.0025	0.0025	10X	[illegible]	[illegible]	[illegible]	[illegible]
Upper Right Point	1.3815	0.0025	0.0025	11X	[illegible]	[illegible]	[illegible]	[illegible]
Lower Left Point	1.3815	0.0025	0.0025	12X	[illegible]	[illegible]	[illegible]	[illegible]
Lower Right Point	1.3815	0.0025	0.0025	13X	[illegible]	[illegible]	[illegible]	[illegible]
Line Form	0	0.0005	0	14FM	0.0001	0.0002	0.0002	0.0002
Angle	106	0.5	0.5	15AN	106.0254	106.0852	106.1512	106.0393
Distance to Angled Line	1.3815	0.0025	0.0025	16X	[illegible]	[illegible]	[illegible]	[illegible]
Center Point	0.905	0.005	0.005	17X	0.9075	0.9069	0.9078	0.9070
Upper Left Point	0.905	0.005	0.005	18X	0.9075	0.9070	0.9078	0.9070
Upper Right Point	0.905	0.005	0.005	19X	0.9075	0.9070	0.9078	0.9070
Lower Left Point	0.905	0.005	0.005	20X	0.9076	0.9070	0.9079	0.9072
Lower Right Point	0.905	0.005	0.005	21X	0.9079	0.9072	0.9082	0.9074
Line Form	0	0.0005	0	22FM	0.0001	0.0002	0.0001	0.0001
Angle	90	0.5	0.5	23AN	89.9100	89.9341	90.2157	90.0051
Distance to Angled Line	0.905	0.005	0.005	24X	0.9072	0.9067	0.9085	0.9070
Fixture Check	0.148	0.0003	0.0003	25Y	[illegible]	[illegible]	[illegible]	[illegible]

[illegible] = under low limit
[illegible] = over high limit

5	6	7	8	9	10	11	12	13
8/4/2005 16:22	8/4/2005 16:29	8/4/2005 16:30	8/4/2005 16:31	8/4/2005 16:32	8/4/2005 16:34	8/4/2005 16:35	8/4/2005 16:36	8/4/2005 16:38
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
0.1026	0.1022	0.1024	0.1026	0.1023	0.1023	0.1020	0.1023	0.1025
0.1015	0.1012	0.1016	0.1016	0.1014	0.1014	0.1012	0.1013	0.1014
0.1023	0.1017	0.1021	0.1024	0.1018	0.1020	0.1019	0.1019	0.1023
0.1024	0.1019	0.1022	0.1023	0.1021	0.1023	0.1018	0.1019	0.1019
0.1031	0.1026	0.1029	0.1034	0.1027	0.1028	0.1025	0.1027	0.1029
0.0001	0.0001	0.0002	0.0001	0.0001	0.0002	0.0001	0.0001	0.0003
[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	1.3837	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	1.3837	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	1.3836	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	1.3837	[illegible]	[illegible]	[illegible]	[illegible]	1.3838	[illegible]	[illegible]
[illegible]	1.3836	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
0.0001	0.0002	0.0001	0.0001	0.0001	0.0003	0.0002	0.0001	0.0003
105.9941	106.1061	105.9737	106.0074	106.0511	105.8678	105.9483	106.0842	105.9942
[illegible]	1.3835	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
0.9076	0.9065	0.9076	0.9073	0.9077	0.9074	0.9071	0.9073	0.9070
0.9077	0.9065	0.9075	0.9073	0.9077	0.9075	0.9070	0.9073	0.9070
0.9078	0.9067	0.9076	0.9074	0.9077	0.9073	0.9072	0.9072	0.9072
0.9077	0.9068	0.9076	0.9073	0.9079	0.9075	0.9072	0.9073	0.9071
0.9079	0.9070	0.9079	0.9078	0.9082	0.9077	0.9074	0.9076	0.9074
0.0001	0.0001	0.0001	0.0002	0.0001	0.0002	0.0001	0.0002	0.0003
90.0256	90.0049	89.9811	89.9124	90.1054	90.0444	90.1096	90.0612	89.9333
0.9077	0.9065	0.9075	0.9070	0.9080	0.9076	0.9074	0.9074	0.9068
[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]

14	15	16	17	18	19	20	21	22
8/4/2005 16:39	8/4/2005 16:40	8/4/2005 16:41	8/4/2005 16:43	8/4/2005 16:44	8/4/2005 16:45	8/4/2005 16:47	8/4/2005 16:48	8/4/2005 16:49
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
0.1020	0.1023	0.1021	0.1023	0.1025	0.1023	0.1017	0.1020	0.1024
0.1011	0.1016	0.1012	0.1012	0.1014	0.1014	0.1011	0.1010	0.1015
0.1019	0.1020	0.1017	0.1018	0.1021	0.1020	0.1016	0.1017	0.1020
0.1017	0.1021	0.1019	0.1021	0.1023	0.1023	0.1009	0.1016	0.1022
0.1025	0.1026	0.1024	0.1027	0.1028	0.1028	0.1021	0.1024	0.1029
0.0001	0.0002	0.0001	0.0001	0.0002	0.0002	0.0002	0.0002	0.0001
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	1.3835	1.3840	[redacted]	[redacted]	[redacted]	1.3834	1.3838	1.3838
[redacted]	1.3835	1.3839	[redacted]	[redacted]	[redacted]	1.3834	1.3838	1.3838
[redacted]	1.3834	1.3839	[redacted]	[redacted]	[redacted]	1.3833	1.3837	1.3838
[redacted]	1.3835	1.3840	[redacted]	[redacted]	[redacted]	1.3835	1.3838	1.3838
[redacted]	1.3835	1.3839	[redacted]	[redacted]	[redacted]	1.3834	1.3837	1.3838
0.0001	0.0002	0.0002	0.0001	0.0001	0.0001	0.0002	0.0002	0.0001
106.0214	106.0500	106.0735	106.0156	105.9936	105.9898	106.0428	106.0972	105.9952
[redacted]	1.3834	1.3839	[redacted]	[redacted]	[redacted]	1.3833	1.3836	1.3838
0.9072	0.9063	0.9069	0.9074	0.9074	0.9074	0.9061	0.9067	0.9067
0.9072	0.9063	0.9069	0.9074	0.9074	0.9074	0.9062	0.9067	0.9067
0.9072	0.9063	0.9068	0.9074	0.9074	0.9074	0.9061	0.9066	0.9068
0.9073	0.9065	0.9070	0.9074	0.9075	0.9075	0.9061	0.9069	0.9069
0.9074	0.9067	0.9075	0.9076	0.9076	0.9077	0.9063	0.9070	0.9071
0.0001	0.0001	0.0001	0.0001	0.0002	0.0001	0.0002	0.0002	0.0002
90.2389	90.0815	90.0517	90.0647	89.9316	90.1025	89.9867	89.9095	90.1674
0.9080	0.9065	0.9070	0.9076	0.9072	0.9077	0.9061	0.9063	0.9073
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]

23	24	25	26	27	28	29	30
8/4/2005 16:51	8/4/2005 16:52	8/4/2005 16:54	8/4/2005 16:55	8/4/2005 16:57	8/4/2005 16:58	8/4/2005 17:00	8/4/2005 17:01
H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson	H. Carson
0.1025	0.1021	0.1028	0.1021	0.1018	0.1024	0.1022	0.1023
0.1016	0.1011	0.1020	0.1015	0.1009	0.1013	0.1014	0.1013
0.1023	0.1017	0.1024	0.1019	0.1017	0.1023	0.1018	0.1021
0.1022	0.1018	0.1026	0.1020	0.1011	0.1017	0.1021	0.1020
0.1030	0.1025	0.1033	0.1026	0.1023	0.1027	0.1027	0.1029
0.0001	0.0002	0.0002	0.0001	0.0002	0.0001	0.0002	0.0003
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]
[redacted]	1.3838	[redacted]	1.3837	1.3834	[redacted]	[redacted]	[redacted]
[redacted]	1.3837	[redacted]	1.3837	1.3835	[redacted]	[redacted]	[redacted]
[redacted]	1.3835	[redacted]	1.3838	1.3835	[redacted]	[redacted]	[redacted]
[redacted]	1.3838	[redacted]	1.3837	1.3835	[redacted]	[redacted]	[redacted]
[redacted]	1.3837	[redacted]	1.3837	1.3835	1.3839	[redacted]	[redacted]
0.0001	0.0002	0.0002	0.0002	0.0001	0.0002	0.0003	0.0002
105.9839	106.0700	105.9286	105.9520	106.0785	105.9418	106.0856	106.0187
[redacted]	1.3836	[redacted]	1.3838	1.3834	[redacted]	[redacted]	[redacted]
0.9076	0.9065	0.9078	0.9065	0.9063	0.9068	0.9073	0.9071
0.9076	0.9065	0.9079	0.9065	0.9064	0.9068	0.9074	0.9071
0.9076	0.9065	0.9078	0.9067	0.9064	0.9070	0.9075	0.9071
0.9076	0.9066	0.9079	0.9066	0.9065	0.9069	0.9074	0.9071
0.9077	0.9070	0.9081	0.9068	0.9067	0.9072	0.9077	0.9074
0.0002	0.0002	0.0005	0.0002	0.0002	0.0002	0.0002	0.0003
90.2126	89.9806	89.7535	89.9621	90.0969	90.0693	89.9516	90.1211
0.9083	0.9064	0.9069	0.9064	0.9067	0.9071	0.9072	0.9074
[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]	[redacted]