

DATE=21-Jun-25

PART NAME : SPIDER FINISH

REV NUMBER : G
SER NUMBER :
STATS COUNT : 1

TIME=5:51:33 AM

ACCEPTED ON DEVIATION:

REWORK :

REJE

PART NUMBER : 321101012E

Active alignment changed to STARTUP

\*\*\*\*\*\*\*\* JS AUTOCAST FOUNDRY INDIA PVT LIMITED, COIMBATORE \*\*\*\*\*\*\*\*\*\*\*

'SHIFT' : 2

'INSPECTED BY' : SATHISHKUMAR

'DETAILS : 65

RESULTS: ACCEPTED:
PLN1=PLANE MEASURED FROM 4 HITS
CIR1=CIRCLE MEASURED FROM 4 HITS
CIR2=CIRCLE MEASURED FROM 4 HITS
Active alignment changed to A1

PLN2=PLANE MEASURED FROM 4 HITS CIR3=CIRCLE MEASURED FROM 4 HITS CIR4=CIRCLE MEASURED FROM 4 HITS Active alignment changed to A2

CIR5=CIRCLE MEASURED FROM 9 HITS PLN3=PLANE MEASURED FROM 5 HITS PLN4=PLANE MEASURED FROM 4 HITS CYL1=CYLINDER MEASURED FROM 8 HITS CYL2=CYLINDER MEASURED FROM 8 HITS CYL3=CYLINDER MEASURED FROM 6 HITS CYL4=CYLINDER MEASURED FROM 8 HITS CYL5=CYLINDER MEASURED FROM 8 HITS CYL6=CYLINDER MEASURED FROM 7 HITS PLN5=PLANE MEASURED FROM 4 HITS PLN6=PLANE MEASURED FROM 4 HITS CYL7=CYLINDER MEASURED FROM 8 HITS CYL9=CYLINDER MEASURED FROM 9 HITS CYL11=CYLINDER MEASURED FROM 6 HITS CYL10=CYLINDER MEASURED FROM 8 HITS CYL8=CYLINDER MEASURED FROM 8 HITS CYL12=CYLINDER MEASURED FROM 6 HITS PLN7=PLANE MEASURED FROM 4 HITS PLN8=PLANE MEASURED FROM 4 HITS CIR6=CIRCLE MEASURED FROM 4 HITS PNT1=POINT MEASURED FROM 1 HIT PNT2=POINT MEASURED FROM 1 HIT PLN9=PLANE MEASURED FROM 4 HITS

CIR7=CIRCLE MEASURED FROM 4 HITS PART NUMBER=SPIDER FINISH PART NUMBER : 321101012E DATE=21-Jun-25 TIME= M PAGE#=2 PLN10=PLANE MEASURED FROM 4 HITS CIR8=CIRCLE MEASURED FROM 4 HITS PNT3=POINT MEASURED FROM 1 HIT PNT4=POINT MEASURED FROM 1 HIT PLN11=PLANE MEASURED FROM 4 HITS CIR9=CIRCLE MEASURED FROM 4 HITS PLN12 = PLANE BUILT FROM 4 FEATURES , PNT2, PNT1, PNT3, PNT4, , PNT5 = POINT BUILT FROM 2 FEATURES CYL2, PLN4 PNT6 = POINT BUILT FROM 2 FEATURES CYL5, PLN5 PNT7 = POINT BUILT FROM 2 FEATURES CYL9, PLN6 PNT8 = POINT BUILT FROM 2 FEATURES CYL8, PLN7 \* Active alignment changed to A3 DIM FLAT1= FLATNESS OF PLANE PLN2 UNITS=MM AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

M 0.000 0.050 0.000 0.015 0.015 0.000 0.000 --#----DIM FLAT2= FLATNESS OF PLANE PLN12 UNITS=MM DIM FLAT2= FLATNESS OF PLANE PLN12 UNITS=MM

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

M 0.000 0.050 0.000 0.003 0.003 0.000 #-----DIM #62= LOCATION OF PLANE PLN3 UNITS=MM AX NOMINAL +TOL -TOL MEAS DEV OUTTOL Z 22.500 0.200 0.200 22.519 0.019 0.000 0.000 ----#---DIM LOC1= LOCATION OF PLANE PLN2 UNITS=MM AX NOMINAL +TOL -TOL MEAS DEV OUTTOL Z 106.968 0.200 0.200 107.045 0.077 0.000 -----#--DIM LOC42= POSITION OF CIRCLE CIR6 UNITS=MM OTTUTUTOT. 0.000 ---#----MMC 0.000 #----DIM LOC2= POSITION OF CIRCLE CIR9 UNITS=MM 35.165 MMC 0.000 ---#----DIM LOC44= POSITION OF CIRCLE CIR7 UNITS=MM

AX NOMINAL +TOL -TOL BONUS MEAS DEV OUTTOL
Y -150.750 -150.727 0.023
Z 111.000 111.039 0.039
DF 35.165 0.115 0.115 0.094 35.144 -0.021 0.000
TP MMC 0.500 0.094 0.091 0.091 0.000 0.000 ---#----0.000 -#----DIM LOC4= POSITION OF CIRCLE CIR8 UNITS=MM +TOL -TOL BONUS MEAS DEV
-150.620 0.130
111.047 0.047
0.115 0.115 0.093 35.143 -0.022
0.500 0.093 0.275 0.275 AX NOMINAL +TOL -TOL BONUS OUTTOL Y Z -150.750 111.000 DF 35.165 0.000 ---#----MMC 0.000 ----#----DIM LOC45= POSITION OF CIRCLE CIR3 UNITS=MM

AX NOMINAL +TOL -TOL BONUS MEAS DEV OUTTOL

150 750 -158.725 0.025

Y	0.000				0.007	0.007		
PART	0.000 NUMBER=SPIDER	FINISH	PART	NUMBER	: 321101012E	DATE=21	-Jun-25	TIME=
M	PAGE#=3							
DF	8.690	0.080	0.080		8.741	0.051	0.000	#-
	RFS			0.000	0.052	0.052	0.000	#
DTM	LOC6= POSITION	OF CIRCLE	CTR4 UNITS	=MM				
AX	NOMINAL	+TOI.	-TΩT.	BONIIS	MEAS	DEV	OUTTOL	
	158.750	1101	101	DONOB	158.751	0 001	OOTIOL	
V	0.000				0.000	0.001		
DE.	0.000 8.690 RFS	0 000	0 000		0.008 8.736 0.015	0.000	0 000	44
DE	0.090	0.000	0.000	0 000	0.736	0.046	0.000	#_
TP	RF'S	0.100		0.000	0.015	0.015	0.000	-#
	#67= 2D DISTANC	E FROM PLA	NE PLN2 TO	CIRCLE (	CIR6 PAR TO	ZAXIS, NO_RAI	DIUS UN	ITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV -0.018	OUTTOL		
M	3.960	0.130	0.130	3.942	-0.018	0.000	-#	
DIM	#67A= 2D DISTAN	CE FROM PL	ANE PLN2 TO	CIRCLE	CIR7 PAR TO	ZAXIS,NO_R	ADIUS U	NITS=MM
AX	NOMINAL 3.960	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	3.960	0.130	0.130	3.994	0.034	0.000	#	
DIM	#67B= 2D DISTAN	CE FROM PL	ANE PLN2 TO	CIRCLE	CIR9 PAR TO	ZAXIS, NO RA	ADIUS U	NITS=MM
AX	NOMINAL	+TOL			DEV	OUTTOL		
M	3.960	0.130	0.130			0.000	#	
DTM	#67C= 2D DISTAN	CE FROM PL	ANE PLN2 TO	CIRCLE	CIR8 PAR TO	ZAXIS.NO R	ADTUS U	NTTS=MM
ΔV	NOMINAL	±T∩T.	-TOI.	MEAS	DEV		12100 0	11110
M		0 130	0 130	4 001	0 041	0.000	#	
1*1	3.900	0.130	0.130	4.001	0.041	0.000	π	
DTM	LOC12= LOCATION	OF DIAME	DINO HINTER	—NANA				
	NOMINAL				DEM	OTIMMOT		
AA	NOMINAL	+10L	-10L	107 04F	DE V	0.000	n.	
Z	107.040	0.200	0.200	107.045	0.005	0.000	#	
DIM	#101 OF FIGURE		7.1E DI 110 E0	DT 3310	DIN111 DID EO			NITTO NO.
	#101= 2D DISTAN						ADIUS U	NITS=MM
	NOMINAL							
M	115.870	0.130	0.130	115.860	-0.010	0.000	#	
DIM	DIST6= 2D DISTA	NCE FROM P	LANE PLN9 T	O PLANE	PLN10 PAR TO	XAXIS,NO_	RADIUS	UNITS=MM
	NOMINAL							
M	115.870	0.130	0.130	115.748	-0.122	0.000 #		
DIM	#102= LOCATION	OF POINT P	NT5 UNITS=	MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
Y	-141.146	0.250	0.250 -	140.972	0.174	0.000	#-	
Z	145.633	0.250	0.250	145.638	0.005	0.000	#	
DTM	#102A= LOCATION	OF POINT	PNT6 UNITS	=MM				
AX	NOMINAL				DEV	OUTTOL		
Y					0.056		#	
Z	145 633	0.250	0.250	1/15 651	0.018	0.000	#	
4	143.033	0.230	0.230	143.031	0.010	0.000	π	
DIM	#102B= LOCATION	OF DOINE	חווחס נוגוד חים	—N/N/				
						OTTEN OT		
AX					DEV		n n	
X	-42.85U	0.250	0.250		0.147	0.000	#-	
Y	141.146	0.250	0.250	141.290	0.144	0.000 0.000	#-	
Z	145.633	0.250	0.250	145.739	0.106	0.000	#	
DIM	#102C= LOCATION							
AX		+TOL	-TOL	MEAS	DEV	OUTTOL		
X			0.250	42.981	0.131	0.000	#	
Y	141.146	0.250	0.250	141.143	0.131 -0.003	0.000		
Z			0.250	145.663	0.030	0.000		
		<del>-</del>						

Active alignment changed to A4

PART	NUMBER=SPIDE	R FINISH	PZ	ART NUMBER	· 321101012E	DATE:	=21 - Tun - 25	TIME=
			1.2	INT NORDER	. 5211010121	DAIE-	-21 Ouii 25	111111
M	PAGE#							
DIM	#95= POSITION	OF CIRCLE O	CIR9 UNIT	TS=MM				
AX	NOMINAL	+TOL	$-\mathtt{TOL}$	BONUS	MEAS	DEV	OUTTOL	
Y	0.000				0.125	0.125		
	0.000				0.022			
	0.000	0		0 000	0.022	0.022	0 000	n n
TP	RFS	0.500		0.000	0.254	0.254	0.000	#
Acti	lve alignment	changed to A	A5					
DIM	#95A= POSITIO	N OF CIRCLE	CIR8 UNI	TS=MM				
AX					MEAG	רבינו	OTTEMOT	
Y	NOMINAL 0.000	1101	101	DONOS	0 110	0 110	001101	
					0.112	0.112		
Z	0.000				-0.048	-0.048		
ΤP	0.000 RFS	0.500		0.000	0.243	0.243	0.000	#
Acti	ve alignment	changed to A	A 6					
DIM	#7= 2D DISTAN	ICE EDOM CVI	INDED CATO	) TO CVITATOR	D CVI 10	(Свишьь с	ור כבומשבים עם	VDD DVD11
	# 1- ZD DISTAN	CE EKOM CILI	THUER CITS	, TO CITTINDE	IV CITITS	(CENTEK )	TO CENTER)	ADD_KADIU
MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	NOMINAL 11.000	0.300	0.300	10.912	-0.088	0.000	#	
DTM	#7A= 2D DISTA	NCE FROM CYI	TINDER CYT	9 TO CYLINE	ER CYL11	(CENTER	TO CENTER	ADD RADI
=MM	/11	mon inon cii	JINDHN CII	J IO CILIND	DIC CILII	(CDIVIDIO	TO CHIVILITY,	, 11DD_101D1
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	11.000	0.300	0.300	10.896	-0.104	0.000	#	
DIM	#9A= LOCATION NOMINAL 3.000	OF CYLINDER	R CYL12 U	JNITS=MM				
ΔX	NOMINAI.	+T∩T.	-ТОТ.	MEAS	DEV	OIITTOI.		
D	2 000	0 200	0 200	2 001	0 001	0 000	ш	
K	3.000	0.200	0.200	3.001	0.001	0.000	#	
DIM	LOC22= LOCATI	ON OF CYLINI	DER CYL11	UNITS=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
R	NOMINAL 3.000	0.200	0.200	3.031	0.031	0 - 0 0 0	#	
	3.333	0.200	0.200	0.001	0.001	0.000	"	
DTM	#110- 1007-010	NI OE DIANE I	OT NIG TINITH	C-MM				
	#110= LOCATIO							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
Z	NOMINAL 35.940	0.100	0.100	35.876	-0.064	0.000	-#	
DIM	LOC18= LOCATI	ON OF PLANE	PLN7 UNI	TS=MM				
AX	NOMINAL	+TOI.	-TOI.	MEAS	DEV	OUTTOL		
Z	35.940	0.100	0.100	36.014			#-	
	33.940	0.100	0.100	30.014	0.074	0.000		
_								
	#4,1= POSITIO			JSE AXIS=AVE	RAGE REF LE	NGTH=0.00		MN
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
Y	0.000				0.133	0.133		
DF		0.080	0 080		9.453		0.000	#
			0.000	0 000		0.013	0.000	
TP	RFS	0.500		0.000	0.265	0.265	0.000	#
DIM	LOC16= POSITI	ON OF CYLINI	DER CYL9	USE AXIS=AV	ERAGE REF L	ENGTH=0.0	000 UNITS=	=MM
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
Y	0.000				-0.021			
DF		0.080	0 000				0.000	#
			0.000	0 000				
TP	RFS	0.500		0.000	0.041	0.041	0.000	#
Acti	lve alignment	changed to A	<b>A</b> 7					
	-							
DIM	#7B= 2D DISTA	NCE FROM CYT	LINDER CYT	2 TO PAR	TO XAXIS A	DD RADTII	S UNITS=M	И
AX	NOMINAL	+TOL	TOL	MEAS		OUTTOL	. 01.110 111	-
							п	
M	0.000	0.300	0.300	0.000	0.000	0.000	#	
l								

DIM #7C= 2D DISTANCE FROM CYLINDER CYL5 TO PAR TO XAXIS, ADD\_RADIUS UNITS=MM

AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	0.000	0.300	0.300	0.000	0.000	0.000	#	
	NUMBER=SPIDE		PA	ART NUMBER	: 3211010121	E DATE=	21-Jun-25	TIME=
DIM	#5A= LOCATION	N OF CYLINDE	R CYL3 UN	IITS=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
R	NOMINAL 3.000	0.200	0.200	3.029	0.029	0.000	#	
	LOC20= LOCATI							
AX	NOMINAL 3.000	+TOL	-TOL	MEAS	DEV	OUTTOL		
R	3.000	0.200	0.200	2.986	-0.014	0.000	#	
	110A= LOCATIO							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
Z	NOMINAL 35.940	0.200	0.200	35.950	0.010	0.000	#	
DIM	LOC17= LOCATI	ON OF PLANE	PLN5 UNI	TS=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
Z	35.940	0.200	0.200	36.002	0.062	0.000	#	
	#10,13= POSIT							P
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
Y	0.000				0.149	0.149		
DF	9.440	0.080	0.080		9.453	0.013	0.000	#
TP	0.000 9.440 RFS	0.500		0.000	0.297	0.297	0.000	#
DIM	#110B= POSITI	ON OF CYLIN	DER CYL5	USE AXIS=AV	ERAGE REF	LENGTH=0.0	00 UNITS=MM	
AX	NOMINAL 0.000 9.440 RFS	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
Y	0.000				0.045	0.045		
DF	9.440	0.080	0.080		9.452	0.012	0.000	#
TP	RFS	0.500		0.000	0.091	0.091	0.000 -#-	
DIM	#104= 2D DIST	TANCE FROM C	YLINDER CY	L2 TO CYLIN	IDER CYL5 PAI	R TO XAX	IS,NO_RADIUS	UNITS
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	85.700	0.100	0.100	85.665	-0.035	0.000	#	
DIM	DIST7= 2D DIS	STANCE FROM	CYLINDER (	CYL8 TO CYLI	NDER CYL9 P	AR TO XA	XIS,NO_RADIUS	rinu a
AX	NOMINAL 85.700	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	85.700	0.100	0.100	85.661	-0.039	0.000	#	
Acti	ve alignment	changed to	A8					
DIM	#5,#6= POSITI	ON OF CYLIN	DER CYL3	USE AXIS=AV	VERAGE REF	LENGTH=0.0	00 UNITS=MM	DISPI
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	3.000				3.146	0.146		
Y	0.000				0.119	0.119		
DF	3.000	0.100	0.100		3.029	0.029	0.000	
TP	RFS	0.500		0.000	0.188	0.188	0.000	-#
Acti	ve alignment	changed to	A9					
DIM	#9,#8= POSITI	ON OF CYLIN	DER CYL6	USE AXIS=AV	ERAGE REF	LENGTH=0.0	00 UNITS=MM	DISPI
7\ \\Z	NICMINIAI	LECT	mot.	DONILIC	MEAC	DEZ	OTTEMOT	

DIM	#9, #8= POSITION	OF CYLI	INDER CYL6	USE AXIS=AV	ERAGE REF	LENGTH=0.000	UNITS=MM	DISPI
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	-3.000				-3.189	-0.189		
Y	0.000				-0.236	-0.236		ļ
DF	3.000	0.100	0.100		2.986	-0.014	0.000	-#
ΤP	RFS	0.500		0.000	0.302	0.302	0.000	#

Active alignment changed to A10

DIM #5,#6A= POSITION OF CYLINDER CYL12 USE AXIS=AVERAGE REF LENGTH=0.000 UNITS=MM DISUS
AX NOMINAL +TOL -TOL BONUS MEAS DEV OUTTOL

Х	3.000 NUMBER=SPIDER	FINICH	D7	DT NIIMBED		0.179	1 - Tun - 25	TIME=			
M	PAGE#=			INI NOMBER	. 52110101	IZE DAIE-Z	1 0uii 25	I IME			
	0.000	0			0.199	0.199					
	3.000	0.100	0.100			0.001	0.000	#			
TP	RFS			0.000		0.268					
Acti	Active alignment changed to A12										
DIM US	#9,#8B= POSITIO	ON OF CYLI	NDER CYL11	USE AXIS	=AVERAGE I	REF LENGTH=0.	000 UNIT	S=MM DIS			
AX	NOMINAL	+TOL	-TOL	BONUS		DEV	OUTTOL				
X	-3.000				-3.136	-0.136					
Y	0.000				-0.140	-0.140					
DF	3.000	0.100	0.100		3.031	0.031					
TP	RFS	0.500		0.000	0.195	0.195	0.000	#			
Acti	ve alignment cl	hanged to	A11								
DIM	LOC3= LOCATION	OF PLANE	PLN2 UNIT	'S=MM							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL					
Z	84.588	0.200	0.200	84.523	-0.065	0.000 -	#				
	LOC5= POSITION							М			
AX		+TOL	-TOL	BONUS		DEV	OUTTOL				
	0.000					0.057					
Y	13.635 12.237	0 000	0 000		13.66/	0.032	0 000	п			
			0.080	0.000							
TP	RFS	0.500		0.000	0.131	0.131	0.000	#			
	END OF MEASUREMENT FOR										
	PN=SPIDER FITTOTAL # OF MEA						DWG=G				