

DATE=21-Jun-25

PART NAME : SPIDER FINISH

REV NUMBER : G
SER NUMBER :
STATS COUNT : 1

TIME=4:51:45 AM

PART NUMBER : 321101012E

Active alignment changed to STARTUP

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

'SHIFT' : 2

'INSPECTED BY' : SATHISHKUMAR

'DETAILS : 65

RESULTS : ACCEPTED: ACCEPTED ON DEVIATION: REWORK: REJECTED:

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

CIR5=CIRCLE MEASURED FROM 4 HITS CIR6=CIRCLE MEASURED FROM 4 HITS CIR7=CIRCLE MEASURED FROM 4 HITS CIR8=CIRCLE MEASURED FROM 4 HITS CIR9=CIRCLE MEASURED FROM 4 HITS CIR10=CIRCLE MEASURED FROM 4 HITS CIR11=CIRCLE MEASURED FROM 4 HITS CIR12=CIRCLE MEASURED FROM 4 HITS CIR13=CIRCLE MEASURED FROM 4 HITS CIR14=CIRCLE MEASURED FROM 4 HITS CIR15=CIRCLE MEASURED FROM 4 HITS CIR16=CIRCLE MEASURED FROM 4 HITS CIR17=CIRCLE MEASURED FROM 4 HITS CIR18=CIRCLE MEASURED FROM 11 HITS CIR19=CIRCLE MEASURED FROM 10 HITS PLN3=PLANE MEASURED FROM 4 HITS CIR20=CIRCLE MEASURED FROM 4 HITS PLN4=PLANE MEASURED FROM 4 HITS CIR21=CIRCLE MEASURED FROM 4 HITS PLN5=PLANE MEASURED FROM 4 HITS CIR22=CIRCLE MEASURED FROM 4 HITS

PLN6=PLANE MEASURED FROM 4 HITS CIR23=CIRCLE MEASURED FROM 4 HITS

PLN24=PLANE MEASURED FROM 4 HITS
CYL10=CYLINDER MEASURED FROM 8 HITS
CYL11=CYLINDER MEASURED FROM 12 HITS
CIR39 = CIRCLE BUILT FROM 15 FEATURES ,CIR5,CIR4,CIR17,CIR16,CIR15,CIR14,CIR13,CIR12,CIR3
R10,CIR9,CIR8,CIR7,CIR6,,
Active alignment changed to A3

PLN21 = PLANE BUILT FROM 2 FEATURES PLN16, PLN14

PNT6 = POINT BUILT FROM 2 FEATURES CYL2, PLN7

PNT7 = POINT BUILT FROM 2 FEATURES CYL6, PLN9

CIR42 = CIRCLE BUILT FROM 2 FEATURES PLN7, CON1

CIR43 = CIRCLE BUILT FROM 2 FEATURES PLN9, CON2

LIN1 = LINE BUILT FROM 6 FEATURES, CIR26, CIR27, CIR28, CIR31, CIR30, CIR29,,

LIN2 = LINE BUILT FROM 6 FEATURES, CIR37, CIR36, CIR24, CIR35, CIR34, CIR33,,

PLN22 = PLANE BUILT FROM 2 FEATURES PLN13, PLN15

PLN23 = PLANE BUILT FROM 2 FEATURES PLN11, PLN17

CIR34=CIRCLE MEASURED FROM 4 HITS CIR35=CIRCLE MEASURED FROM 4 HITS PLN18=PLANE MEASURED FROM 4 HITS CIR44=CIRCLE MEASURED FROM 6 HITS

PNT5 = POINT BUILT FROM 2 FEATURES CYL10, PLN24 PLN20 = PLANE BUILT FROM 2 FEATURES PLN18, PLN12

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LIN3 = LINE BUILT FROM 2 FEATURES , CIR19, CIR15,,
PART NUMBER=SPIDER FINISH PART NUMBER : 321101012E DATE=21-Jun-25 TIME=
M PAGE#=3
LIN4 = LINE BUILT FROM 2 FEATURES , CIR19, CIR16,,
LIN5 = LINE BUILT FROM 2 FEATURES , CIR19, CIR17,,
LIN6 = LINE BUILT FROM 2 FEATURES , CIR19, CIR4,,
LIN7 = LINE BUILT FROM 2 FEATURES , CIR19, CIR5,
LIN8 = LINE BUILT FROM 2 FEATURES , CIR19, CIR6, ,
LIN9 = LINE BUILT FROM 2 FEATURES , CIR19, CIR7,,
LIN10 = LINE BUILT FROM 2 FEATURES , CIR19, CIR8,,
LIN11 = LINE BUILT FROM 2 FEATURES , CIR19, CIR9,,
LIN12 = LINE BUILT FROM 2 FEATURES , CIR19, CIR10,,
LIN13 = LINE BUILT FROM 2 FEATURES , CIR19, CIR11, ,
LIN14 = LINE BUILT FROM 2 FEATURES , CIR19, CIR3,,
LIN15 = LINE BUILT FROM 2 FEATURES , CIR19, CIR12,,
LIN16 = LINE BUILT FROM 2 FEATURES , CIR19, CIR13,,
LIN17 = LINE BUILT FROM 2 FEATURES , CIR19, CIR14, ,
*************************
DIM FLAT1= FLATNESS OF PLANE PLN2 UNITS=MM
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

M 0.000 0.050 0.000 0.011 0.011 0.000
                                                                     0.000 -#----
DIM #25= LOCATION OF CIRCLE CIR19 UNITS=MM
                                 -TOL MEAS DEV OUTTOL
0.000 182.078 0.078 0.000 ---#---
0.000 0.028 0.028 0.000 ---#---
AX NOMINAL +TOL -TOL MEAS
D
       182.000
                      0.150
                     0.050
       0.000
RN
DIM #24= LOCATION OF CIRCLE CIR39 UNITS=MM
                                 -TOL MEAS DEV OUTTOL
0.100 -0.061 -0.061 0.000 -#-----
0.100 -0.030 -0.030 0.000 ---#----
0.100 209.995 -0.005 0.000 ---#---
AX NOMINAL +TOL -TOL MEAS
X 0.000 0.100 0.100 -0.061
Y 0.000 0.100 0.100 -0.030
D 210.000 0.100 0.100 209.995
DIM #20= 2D ANGLE FROM LINE LIN3 TO LINE LIN4
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
A 22°30'00" 0°30'00" 0°30'00" 22°30'30" 0°00'30" 0°00'00" ----#----
DIM #20-1= 2D ANGLE FROM LINE LIN4 TO LINE LIN5
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
A 22°30'00" 0°30'00" 0°30'00" 22°30'49" 0°00'49" 0°00'00" ----#----
DIM #20-2= 2D ANGLE FROM LINE LIN5 TO LINE LIN6
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL A 22°30'00" 0°30'00" 22°31'26" 0°01'26" 0°00'00" ----#----
DIM #20-3= 2D ANGLE FROM LINE LIN6 TO LINE LIN7
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
A 22°30'00" 0°30'00" 0°30'00" 22°30'08" 0°00'08" 0°00'00" ----#---
                                                          DEV
DIM #20-4= 2D ANGLE FROM LINE LIN7 TO LINE LIN8
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL A 22°30'00" 0°30'00" 22°30'14" 0°00'14" 0°00'00" ----#----
DIM #20-5= 2D ANGLE FROM LINE LIN8 TO LINE LIN9
                                                         DEV
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
A 22°30'00" 0°30'00" 0°30'00" 22°29'05" -0°00'55" 0°00'00" ----#----
DIM #20-6= 2D ANGLE FROM LINE LIN9 TO LINE LIN10
-TOI. MEAS DEV
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
A 22°30'00" 0°30'00" 0°30'00" 22°29'57" -0°00'03" 0°00'00" ----#----
DIM #20-7= 2D ANGLE FROM LINE LIN10 TO LINE LIN11

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°28'48" -0°01'12" 0°00'00" ----#----
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PART NUMBER	R=SPIDER FINISH	PART NUMBER	: 321101012E	DATE=21-Jun-25	TIME=
M	PAGE#=4				

DIM #20-8= 2D ANGLE FROM LINE LIN11 TO LINE LIN12

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°28'07" -0°01'53" 0°00'00" ----#---DIM #20-9= 2D ANGLE FROM LINE LIN12 TO LINE LIN13

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°29'37" -0°00'23" 0°00'00" ----#----DIM #20-10= 2D ANGLE FROM LINE LIN13 TO LINE LIN14

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°29'40" -0°00'20" 0°00'00" ----#----DIM #20-11= 2D ANGLE FROM LINE LIN14 TO LINE LIN15

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°30'01" 0°00'01" 0°00'00" ----#----DIM #20-12= 2D ANGLE FROM LINE LIN15 TO LINE LIN16

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°29'39" -0°00'21" 0°00'00" ----#----DIM #20-13= 2D ANGLE FROM LINE LIN16 TO LINE LIN17

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°30'20" 0°00'20" 0°00'00" ----#----DIM #23= 2D ANGLE FROM LINE LIN3 TO XAXIS

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A -22°30'00" 0°30'00" -22°35'41" -0°05'41" 0°00'00" ---#----DIM #23A= 2D ANGLE FROM LINE LIN17 TO XAXIS

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL

A 22°30'00" 0°30'00" 0°30'00" 22°25'57" -0°04'03" 0°00'00" ---#----DIM #44A= 2D ANGLE FROM CYLINDER CYL6 TO ZAXIS AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
A 15°30'00" 0°30'00" 15°34'41" 0°04'41" 0°00'00" ----#---DIM #44B= 2D ANGLE TO CYLINDER CYL2 FROM ZAXIS DEV AX NOMINAL +TOL -TOL MEAS DEV OUTTOL
A 15°30'00" 0°30'00" 15°28'05" -0°01'55" 0°00'00" ----#----DIM LOC5= POSITION OF CIRCLE CIR40 UNITS=MM MEAS DEV -158.722 0.028 0.015 0.015 AX NOMINAL +TOL -TOL BONUS OUTTOL -158.7501 0.000 DF 8.739 0.049 0.064 0.064 0.080 8.690 0.080 0.000 ----#-RFS 0.000 0.100 0.000 ----#---DIM LOC6= POSITION OF CIRCLE CIR41 UNITS=MM DEV OUTTOL 8.690 0.080 0.080 RFS 0.100 0.000 ----#-0.032 DIM #18, #21, #22= POSITION OF CIRCLE CIR40 UNITS=MM AX NOMINAL +TOL -TOL BONUS MEAS OUTTOL

0.000 ----#-

0.000 --#----

X

Y

DF

TP

-158.750

0.000 8.690

MMC

DIM	#19,#21,#22= PC	OSITION OF (	CIRCLE CIF	R41 UNITS	S=MM			
7 7	NOMINAT	<b>+</b> ₩○T	<b>-</b> ₩○T	BONIIC	MEAG	DEV	OUTTOL	
PART	NUMBER=SPIDER	FINISH	PAR	RT NUMBER	: 321101012E	DATE=	21-Jun-25	TIME=
M	PAGE#=5	5			150 755	0 005		
X Y	158.750				158.755	0.005		
DF	0.000 8.690	0.080	0.080	0.127	8.737	0.013	0 - 0 0 0	#-
TP	MMC	0.100		0.127	0.032	0.032	0.000	-#
DIM	#64= LOCATION (	OF PLANE PL	N5 UNITS=	=MM				
AX	NOMINAL -46.500	+TOL	-TOL	MEAS	DEV	OUTTOL		
Z	-46.500	0.250	0.250	-46.492	0.008	0.000	#	
DTM	#64A= LOCATION	OF PLANE P	N4 UNTTS	S=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
Z	NOMINAL -46.500	0.250	0.250	-46.505	-0.005	0.000	#	
	#64B= LOCATION							
AX Z	NOMINAL	+TOL	-TOL	MEAS	DEV 0.010	OUTTOL	п	
乙	-46.500	0.250	0.250	-46.490	0.010	0.000	#	
DIM	#64C= LOCATION	OF PLANE P	LN3 UNITS	S=MM				
	NOMINAL				DEV	OUTTOL		
Z	-46.500	0.250	0.250	-46.502	-0.002	0.000	#	
DIM	#121, #115, #120=	= POSITION (	OF CIRCLE	CIR22 UI	NITS=MM			
AX	NOMINAL -121.260 -102.040 6.750	+'I'OL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	-121.260				-121.235	0.025		
DE.	-102.040	0.250	0 250	0 273	-102.007	0.033	0 000	#
ТР	MMC	0.230	0.230	0.273	0.083	0.023	0.000	#
DIM	#121, #115, #120	A= POSITION	OF CIRCLE	CIR23 T	UNITS=MM			
	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
	-121.260				-121.261			
Y 	102.040	0 0 5 0	0 0 5 0		102.056	0.016		
DF.	6.750 MMC	0.250	0.250	0.322	6.822	0.072	0.000	#
1 P	IMIMC	0.800		0.322	0.033	0.033	0.000	#
DIM	#121, #115, #120E	B= POSITION	OF CIRCLE	CIR20 T	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	121.260				121.225	-0.035		
Y	102.040					-0.019		
DF		0.250	0.250	0.314			0.000	
TP	MMC	0.800		0.314	0.080	0.080	0.000	#
DTM	#121, #115, #1200	C= POSITION	OF CIRCLE	: CTR21 I	INTTS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	121.260					0.006		
Y	-102.040					-0.014		
DF		0.250	0.250	0.299		0.049	0.000	#
ΤP	MMC	0.800		0.299	0.030	0.030	0.000	#
D.T.:	20    27   7   27	TON 05 507	n parme	TTTO NO.				
DIM AX	#39,#37= LOCATI	ION OF POINT +TOL	F PNT5 UN -TOL	IITS=MM MEAS	DEV	OUTTOL		
AX X	134.000			134.115			#	
Y	0.000	0.400					#	
Z	-26.000	0.250		-26.129			#	
	-		-		-			
DIM	#34= LOCATION (			JITS=MM				
AX	NOMINAL		-TOL	MEAS		OUTTOL		
D	18.000	0.110	0.000	18.046	0.046	0.000	#	

DIM #36= LOCATION OF CYLINDER CYL11 UNITS=MM

AX PART M		R FINISH			DEV : 321101012E		=21-Jun-25	TIME=
D			0.200	29.920	-0.080	0.000	#	
DIM	#34A= 2D ANGL	E TO CYLIND	ER CYL10 FF	ROM XAX	IS			
AX						OUTTOL		
A	30°00'00"	0°30'00"	0°30'00" 2	29°57'22"	DEV -0°02'38"	0°00'00"	#	
DIM	#74,#65,#77,#	78= POSITIO	N OF CIRCLE	CIR36	UNITS=MM			
AX		+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
	-150.750				-150.748	0.002		
Z	-111.000	0 115	0 115	0 000	-110.996	0.004	0 000	
			0.115		35.139			
TP	MMC	0.500		0.089	0.009	0.009	0.000	#
DIM	#74,#65,#77,#	78A= POSITI	ON OF CIRCI	LE CIR27	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS		OUTTOL	
Y	150.750				150.747			
Z	-111.000				-111.045	-0.045		
DF	35.165	0.250	0.250	0.230	35.145	-0.020	0.000	
TP	MMC	0.500		0.230	0.090	0.090	0.000	-#
DIM	#74,#65,#96,#	95= POSITIO	N OF CIRCLE	CIR30	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS 150.634	DEV	OUTTOL	
Y	150.750				150.634			
	-111.000					-0.047		
			0.250		35.143			
TP	MMC	0.500		0.228	0.251	0.251	0.000	#
DIM	#74,#65,#96,#	95A= POSITI	ON OF CIRCI	LE CIR34	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
Y	-150.750					-0.120		
Z	-111.000				-111.064 35.147	-0.064		
DF	35.165	0.250	0.250	0.232	35.147	-0.018	0.000	
TP	MMC	0.500		0.232	0.272	0.272	0.000	#
Acti	ve alignment	changed to	A4					
DTM	#106= POSITION	N OF PLANE	рт.м21 гімтт	"S=MM				
	NOMINAL				MEAS	DEV	OUTTOL	
X	0.000				-0.009			
TP	RFS	0.500		0.000	0.019		0.000	#
DTM	LOC2= LOCATIO	N OF PLANE	рт.n1 <i>1</i> ттитт	"S=MM				
AX					DEV	OUTTOL		
X							-#	
DIM	LOC4= LOCATIO	N OF DIAME	DI NI 1 C IINIT II					
AX					DEV	$\cap$ IITT $\cap$ I		
					0.117		#_	
21	0.000	0.200	0.200	0.11/	O • I I /	0.000	π —	
					N1 PAR TO ZA		ADIUS UNI	rs=mm
					DEV			
M	69.850	0.250	0.250	69.899	0.049	0.000	#	
ртм	#101= 2D DIST	ANCE FROM P	LANE PIN13	TO PLANE	PLN15 PAR TO	XAXTS 1	NO RADTIIS	UNITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	PLN15 PAR TO DEV	OUTTOL		11.110 1111
M	115.870	0.130	0.130	115.758	-0.112	0.000	#	

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL X 57.935 0.100 0.100 57.870 -0.065 0.000 -#-----

DIM LOC19= LOCATION OF PLANE PLN15 UNITS=MM

DIM	LOC17= LOCATION	N OF PLANE F	PLN13 UNIT	S=MM				
AX	NOMINAL				DEV	OUTTOI.		
	NUMBER=SPIDER						=21Tun-25	TTME=
M	PAGE#=	7	11111	·	0211010121	DITTE	21 0411 20	1 1111
	-57.935	0 100	0 100	-57 888	0 047	0 000	#	
21	37.933	0.100	0.100	37.000	0.047	0.000	π	
DTM	#100= POSITION		NIOO IINITMO	- NANA				
					ME A C	DET	OTTEMOT	
	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X		0 000		0 000	-0.011	-0.011	0 000	u.
TP	RFS	0.380		0.000	0.022	0.022	0.000	#
			_					
Acti	lve alignment ch	nanged to A5	5					
DIM	#106A= POSITION	OF PLANE F	PLN20 UNIT	TS=MM				
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	0.000				-0.020	-0.020		
TP	RFS	0.500		0.000	0.040	0.040	0.000	#
DIM	LOC8= LOCATION	OF PLANE PI	LN12 UNITS	S=MM				
	NOMINAL				DEV	OUTTOL		
X	-8.000	0.200	0.200	-8.119	-0.119	0.000	-#	
ртм	LOC12= LOCATION	J OF PLANE F	PT.N18 IINTT	S=MM				
	NOMINAL				DEV	$\bigcap IITTT \bigcap I$		
V	8.000	0.300	101	9 076	0.076	0 000	#	
Λ	0.000	0.200	0.200	0.070	0.070	0.000	π	
DIM	#40A= 2D DISTAN	ICE EDOM DIA	NIE DINO EC	O TIME TIME		ANTO NO	DADTIIC IINI:	T III C — MAA
DIM	NOMINAL	NCE FROM PLA	ANE PLN9 IC	) TINE TINS	PAR IO 2.	AAIS,NO_	RADIUS UN.	LIS-MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL	n e	
M	69.850	0.250	0.250	69.790	-0.060	0.000	#	
	#101A= 2D DISTA							UNITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	115.870	0.100	0.100	115.855	-0.015	0.000	#	
DIM	LOC3= LOCATION	OF PLANE PI	LN11 UNITS	S=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
X	-57.935	0.100	0.100	-57.962	-0.027	0.000	#	
DIM	LOC13= LOCATION	OF PLANE F	PLN17 UNIT	S=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
X	NOMINAL 57.935	0.100	0.100	57.893	-0.042	0.000	#	
DTM	#100A= POSITION	J OF PLANE F	PT.N23 IINTT	S=MM				
AX					ME AS	DEW	OIITTOI	
X	0.000	. 101	101	DONOD	MEAS -0.035	_0 035	001101	
T D	RFS	0 300		0 000	0.070	0.033	0 000	_#
IF	Kr 5	0.300		0.000	0.070	0.070	0.000	-#
DIM	#107 OD DIGEN	ICE EDOM DIA	NID DINI10 D		N110 DAD EIO	373 37 T C	NO DADILIO	IINITEO MM
	#107= 2D DISTAN						NO_RADIUS	UNITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	16.000	0.250	0.250	16.195	0.195	0.000	#	
	#94= CIRCULAR B							
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	NOMINAL 0.000	0.250	0.000	0.102	0.102	0.000	#	
DIM	#76= CIRCULAR B	RUNOUT OF CI	RCLE CIR35	TO CIRCLE	CIR33 UNI	TS=MM		
AX					DEV			
M		0.250	0.000	0.098	0.098	0.000	#	
					2 2 3 3 3	2.000	"	
ртм	#94A= CIRCULAR	RIINOIIT OF C	TRCLE CIR?	7 TO CIRCI	E CTR26 IIN	TTS=MM		
AX								
M		0 250	101	0 037	U U37	0 000	_#	
1,1	0.000	0.230	0.000	0.03/	0.03/	0.000	-#	

DIM #76A= CIRCULAR RUNOUT OF CIRCLE CIR31 TO CIRCLE CIR29 UNITS=MM

AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	0.000	0.250	0.000	0.102	0.102	OUTTOL 0.000#
	T NUMBER=SPIDER PAGE#=		PART	NUMBER :	321101012E	DATE=21-Jun-25 TIME
DIM	LOC24= LOCATIO	N OF CIRCLE	CIR37 UNI	TS=MM		
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL 0.000#
D	42.660	0.060	0.060	42.651	-0.009	0.000#
DIM	#75= LOCATION	OF CIRCLE CI	R33 UNITS	S=MM		
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL 0.000#
D	42.660	0.060	0.060	42.649	-0.011	0.000#
DIM	#66= LOCATION	OF CIRCLE CI	IR25 UNITS	S=MM		
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
D	60.300	0.250	0.250	60.275	-0.025	OUTTOL 0.000#
	#66A= LOCATION					
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
D	60.300	0.250	0.250	60.178	-0.122	OUTTOL 0.000#
DIM	#66B= LOCATION	OF CIRCLE O	CIR38 UNIT	S=MM		
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
D	60.300	0.250	0.250	60.266	-0.034	OUTTOL 0.000#
DIM	LOC10= LOCATIO	N OF CIRCLE	CIR44 UNI	TS=MM		
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
D	60.300	0.250	0.250	60.165	-0.135	OUTTOL 0.000#
DIM	#93= LOCATION	OF CIRCLE CI	R26 UNITS	S=MM		
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
D	42.660	0.060	0.060	42.655	-0.005	0.000#
DIM	LOC1= LOCATION	OF CIRCLE C	CIR29 UNIT	S=MM		
	NOMINAL				DEV	OUTTOL
D	42.660	0.060	0.060	42.648	-0.012	0.000#
DIM	#90= 2D DISTAN	CE FROM POIN	T PNT1 TO	PLANE PLN11	PAR TO	XAXIS, NO_RADIUS UNITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	6.200	0.250	0.250	6.397	0.197	0.000#
DIM	#90A= 2D DISTA	NCE FROM PLA	ANE PLN17 T	O POINT PNI	4 PAR TO	XAXIS,NO RADIUS UNITS=MM
AX	NOMINAL		-TOL		DEV	<b>—</b>
M	6.200	0.250	0.250		0.180	0.000#-
DIM	#90B= 2D DISTA	NCE FROM POI	INT PNT2 TC	PLANE PLN1	.3 PAR TO	XAXIS,NO RADIUS UNITS=MM
	NOMINAL					<u>—</u>
M	6.200	0.250	0.250	6.368	0.168	0.000#-
DIM	#90C= 2D DISTA	NCE FROM POI	INT PNT3 TC	PLANE PLN1	.5 PAR TO	XAXIS,NO_RADIUS UNITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	6.200	+TOL 0.250	0.250	6.323	0.123	0.000#
Ali	gnment Recalled					
DIM	#68= 2D DISTAN	CE FROM LINE	E LIN1 TO L	INE LIN2 PA	AR TO YAX	XIS,NO RADIUS UNITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	301.500	0.250	0.250	301.495	-0.005	0.000#

Acti	lve alignment	t changed to	A11			
DIM	DIST1= 2D DI	ISTANCE FROM	LINE LIN2 T	O PLANE PLN1	0 PAR TO	ZAXIS,NO_RADIUS UNITS=MM
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
M	19.180	0.250	0.250	19.117	-0.063	0.000#

PAR'I M	Γ NUMBER=SPIDE PAGE#		Ε	PART NUMBER	: 321101012F	E DATE=21	-Jun-25	TIME=
DIM AX	#51= LOCATION	OF CYLINDER +TOL	-TOL	MEAS	DEV 0.107	OUTTOL 0.000	#	
	#50= LOCATION							
AX	NOMINAL 49.600	+TOL	-TOL	MEAS	DEV -0.260	OUTTOL 0.000 -#	:	
DIM	#48= CIRCULAR							
AX M	NOMINAL 0.000	+TOL 0.250	-TOL 0.000	MEAS 0.108	DEV 0.108	OUTTOL 0.000	#	
	#49= LOCATION				D 17.7	DESTRUCT.		
Ax A/2	NOMINAL 35°00'00"	1°00'00" 1°	00'00"	MEAS 35°14'27"	0°14'27"	0°00'00"	#	
DIM	#113= LOCATIO	N OF CYLINDER	CYL7	UNITS=MM				
XΑ	NOMINAL 3.000	+TOL	-TOL	MEAS	DEV 0 017	OUTTOL	#	
K	3.000	0.200	0.200	3.01/	0.01/	0.000	#	
DIM	#113A= LOCATI	ON OF CYLINDE	R CYL8	UNITS=MM	. —			
	NOMINAL 3.000	+TOL 0.200	-TOL	MEAS	DEV	OUTTOL	ш	
K	3.000	0.200	0.200	۷	-0.023	0.000	#	
DIM	#112= 2D DIST	ANCE FROM CYL	INDER C	CYL7 TO CYLIN	IDER CYL8 PAF	R TO YAXIS	ADD_RADIU	S UNIT
AX	NOMINAL 41.270	+TOL	-TOL	MEAS	DEV	OUTTOL	п	
				41.407	-0.011	0.000	#	
	, we arrandent	changed to Al						
	_	changed to A1						
DIM	#114= POSITIO	N OF CYLINDER	CYL7					DISPLA
DIM AX	#114= POSITIO	N OF CYLINDER	CYL7	BONUS	MEAS	DEV		DISPLA
DIM AX X	#114= POSITIO NOMINAL 0.000	ON OF CYLINDER +TOL	CYL7	BONUS	MEAS -0.212	DEV -0.212	OUTTOL	
DIM AX X Y DF	#114= POSITIO NOMINAL 0.000	ON OF CYLINDER +TOL	CYL7	BONUS	MEAS -0.212	DEV -0.212	OUTTOL	
DIM AX X Y DF	#114= POSITIO NOMINAL 0.000	ON OF CYLINDER +TOL 0.250	CYL7	BONUS	MEAS -0.212	DEV -0.212	OUTTOL	
DIM AX X Y DF TP	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS	ON OF CYLINDER +TOL 0.250 0.380	CYL7 -TOL	BONUS 0.000	MEAS -0.212 17.607 3.017 0.213	DEV -0.212 -0.028 0.017 0.213	0.000 0.000	# #
DIM AX X Y DF TP DIM AX	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL	ON OF CYLINDER +TOL 0.250 0.380 STANCE FROM CI +TOL	CYL7 -TOL 0.250 RCLE CI -TOL	BONUS  0.000  IR35 TO PLANE  MEAS	MEAS -0.212 17.607 3.017 0.213 E PLN10 PAR T	DEV -0.212 -0.028 0.017 0.213 FO ZAXIS,N	OUTTOL 0.000 0.000 JO_RADIUS	# #
DIM AX X Y DF TP DIM AX	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS	ON OF CYLINDER +TOL 0.250 0.380 STANCE FROM CI +TOL	CYL7 -TOL 0.250 RCLE CI -TOL	BONUS  0.000  IR35 TO PLANE  MEAS	MEAS -0.212 17.607 3.017 0.213 E PLN10 PAR T	DEV -0.212 -0.028 0.017 0.213 FO ZAXIS,N	OUTTOL 0.000 0.000 JO_RADIUS	# #
DIM AX X Y DF TP DIM AX M	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL 19.180	ON OF CYLINDER +TOL 0.250 0.380 STANCE FROM CI +TOL 0.250	CYL7 -TOL 0.250 RCLE CI -TOL 0.250	BONUS  0.000  IR35 TO PLANE  MEAS  19.120	MEAS -0.212 17.607 3.017 0.213  PLN10 PAR T DEV -0.060	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000	0.000 0.000 0.000 IO_RADIUS	# # UNITS=M
DIM AX X Y DF TP DIM AX M	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE	CYL7 -TOL 0.250 RCLE CI -TOL 0.250	BONUS  0.000  IR35 TO PLANE  MEAS  19.120  USE AXIS=AV	MEAS -0.212 17.607 3.017 0.213  PLN10 PAR T DEV -0.060	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000	0.000 0.000 0.000 IO_RADIUS	# # UNITS=M
DIM AX X Y DF TP DIM AX M	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL 19.180 #114A= POSITI	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8	BONUS  0.000  IR35 TO PLANE  MEAS  19.120  USE AXIS=AV	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR T DEV -0.060  VERAGE REF I MEAS 0.240	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000 LENGTH=0.000 DEV 0.240	OUTTOL  0.000 0.000  IO_RADIUS# UNITS=MM	# # UNITS=M
DIM AX X Y DF TP DIM AX M	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL 19.180 #114A= POSITI NOMINAL	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE +TOL	CYL7 -TOL 0.250 RCLE CI -TOL 0.250 R CYL8 -TOL	BONUS  0.000  IR35 TO PLANE  MEAS  19.120  USE AXIS=AV	MEAS -0.212 17.607 3.017 0.213  PLN10 PAR T DEV -0.060  PERAGE REF I MEAS 0.240 -17.659	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS, N OUTTOL 0.000  LENGTH=0.000 DEV 0.240 -0.024	OUTTOL  0.000 0.000  NO_RADIUS# UNITS=MM OUTTOL	# # UNITS=M DISPI
DIM AX Y Y DF TP DIM AX M DIM AX X Y	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL 19.180 #114A= POSITI NOMINAL 0.000 -17.635 3.000	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE +TOL  0.250	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8	BONUS  0.000  IR35 TO PLANE  MEAS  19.120  USE AXIS=AV  BONUS	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TO DEV -0.060  VERAGE REF IOMEAS 0.240 -17.659 2.977	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS, N OUTTOL 0.000  LENGTH=0.000 DEV 0.240 -0.024 -0.023	OUTTOL  0.000 0.000  IO_RADIUS# UNITS=MM OUTTOL  0.000	# UNITS=M DISPI
DIM AX Y Y DF TP DIM AX M DIM AX X Y	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL 19.180 #114A= POSITI NOMINAL 0.000 -17.635	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE +TOL	CYL7 -TOL 0.250 RCLE CI -TOL 0.250 R CYL8 -TOL	BONUS  0.000  IR35 TO PLANE  MEAS  19.120  USE AXIS=AV  BONUS	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TO DEV -0.060  VERAGE REF IOMEAS 0.240 -17.659 2.977	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS, N OUTTOL 0.000  LENGTH=0.000 DEV 0.240 -0.024	OUTTOL  0.000 0.000  IO_RADIUS# UNITS=MM OUTTOL  0.000	# UNITS=M DISPI
DIM AX Y DF TP DIM AX M DIM AX Y DF TP	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS DIST2= 2D DIS NOMINAL 19.180 #114A= POSITI NOMINAL 0.000 -17.635 3.000	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE +TOL  0.250 0.380	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8 -TOL 0.250	BONUS  0.000  IR35 TO PLANE MEAS 19.120  USE AXIS=AV BONUS  0.000	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TODEV -0.060  VERAGE REF IOMEAS 0.240 -17.659 2.977 0.241	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000 LENGTH=0.000 DEV 0.240 -0.024 -0.023	OUTTOL  0.000 0.000  IO_RADIUS# UNITS=MM OUTTOL  0.000	# UNITS=M DISPI
DIM AX Y DF TP DIM AX M DIM AX Y DF TP	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS  DIST2= 2D DIS NOMINAL 19.180  #114A= POSITI NOMINAL 0.000 -17.635 3.000 RFS  CYLY1= CYLIND NOMINAL	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE +TOL  0.250 0.380  ORICITY OF CYL +TOL	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8 -TOL  0.250  INDER C -TOL	BONUS  0.000  IR35 TO PLANE MEAS 19.120  USE AXIS=AV BONUS  0.000  CYL8 UNITS=M MEAS	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TO DEV -0.060  VERAGE REF I MEAS 0.240 -17.659 2.977 0.241  MM DEV	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000 LENGTH=0.000 DEV 0.240 -0.024 -0.023 0.241  OUTTOL	0.000 0.000 0.000 0.000 0.000 0.000 0.000	# UNITS=M DISPI
DIM AX Y DF TP  DIM AX M  DIM AX Y DF TP  DIM	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS  DIST2= 2D DIS NOMINAL 19.180  #114A= POSITI NOMINAL 0.000 -17.635 3.000 RFS  CYLY1= CYLIND NOMINAL	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  CON OF CYLINDE +TOL  0.250 0.380  ORICITY OF CYL	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8 -TOL  0.250  INDER C -TOL	BONUS  0.000  IR35 TO PLANE MEAS 19.120  USE AXIS=AV BONUS  0.000  CYL8 UNITS=M MEAS	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TO DEV -0.060  VERAGE REF I MEAS 0.240 -17.659 2.977 0.241  MM DEV	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000 LENGTH=0.000 DEV 0.240 -0.024 -0.023 0.241  OUTTOL	0.000 0.000 0.000 0.000 0.000 0.000 0.000	# UNITS=M DISPI
DIM AX Y DF TP  DIM AX M  DIM AX Y DF TP  DIM AX X Y DF TP  DIM AX M	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS  DIST2= 2D DIS NOMINAL 19.180  #114A= POSITI NOMINAL 0.000 -17.635 3.000 RFS  CYLY1= CYLIND NOMINAL	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  SON OF CYLINDE +TOL  0.250 0.380  ORICITY OF CYL +TOL 0.380	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8 -TOL  0.250  INDER C -TOL 0.000	BONUS  0.000  IR35 TO PLANE MEAS 19.120  USE AXIS=AV BONUS  0.000  CYL8 UNITS=M MEAS	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TO DEV -0.060  VERAGE REF I MEAS 0.240 -17.659 2.977 0.241  MM DEV	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000 LENGTH=0.000 DEV 0.240 -0.024 -0.023 0.241  OUTTOL	0.000 0.000 0.000 0.000 0.000 0.000 0.000	# UNITS=M DISPI
DIM AX Y DF TP DIM AX M DIM AX Y DF TP DIM AX AX Y AX AX Y DF TP DIM AX M	#114= POSITIONOMINAL 0.000 17.635 3.000 RFS  DIST2= 2D DISNOMINAL 19.180  #114A= POSITINOMINAL 0.000 -17.635 3.000 RFS  CYLY1= CYLINDNOMINAL 0.000	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  SON OF CYLINDE +TOL  0.250 0.380  PRICITY OF CYL +TOL 0.380  changed to A8	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8 -TOL  0.250  INDER C -TOL 0.000	BONUS  0.000  IR35 TO PLANE MEAS 19.120  USE AXIS=AV BONUS  0.000  CYL8 UNITS=M MEAS 0.017	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TODEV -0.060  VERAGE REF IOMEAS 0.240 -17.659 2.977 0.241  IM DEV 0.017	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000 LENGTH=0.000 DEV 0.240 -0.024 -0.023 0.241  OUTTOL	0.000 0.000 0.000 0.000 0.000 0.000 0.000	# # UNITS=M DISPI
DIM AX Y DF TP DIM AX M DIM AX Y DF TP DIM AX AX Y AX AX Y DF TP DIM AX M	#114= POSITIO NOMINAL 0.000 17.635 3.000 RFS  DIST2= 2D DIS NOMINAL 19.180  #114A= POSITI NOMINAL 0.000 -17.635 3.000 RFS  CYLY1= CYLIND NOMINAL 0.000 ive alignment	ON OF CYLINDER +TOL  0.250 0.380  STANCE FROM CI +TOL 0.250  SON OF CYLINDE +TOL  0.250 0.380  ORICITY OF CYL +TOL 0.380  Changed to A8	CYL7 -TOL  0.250  RCLE CI -TOL 0.250  R CYL8 -TOL  0.250  INDER C -TOL 0.000	BONUS  0.000  IR35 TO PLANE MEAS 19.120  USE AXIS=AV BONUS  0.000  CYL8 UNITS=M MEAS 0.017  JNITS=MM MEAS	MEAS -0.212 17.607 3.017 0.213  E PLN10 PAR TOLEV -0.060  VERAGE REF IOMEAS 0.240 -17.659 2.977 0.241  MM DEV 0.017	DEV -0.212 -0.028 0.017 0.213  TO ZAXIS,N OUTTOL 0.000 LENGTH=0.000 DEV 0.240 -0.024 -0.023 0.241  OUTTOL	0.000 0.000 0.000 0.000 0.000 0.000 0.000	# UNITS=M DISPI

DIM #48A= CIRCULAR RUNOUT OF CYLINDER CYL1 TO CYLINDER CYL2 UNITS=MM

AX NOMINAL +TOL -TOL MEAS DEV OUTTOL MODEL OF THE PROPERTY OF

PART	r NUMBER=SPID	ER FINISH		PART NUMBER	: 32110101	2E DATE:	=21-Jun-25	TIME=
M	PAGE							
DIM	#49A= LOCATI		CON1 UNI	TS=MM				
AX	NOMINAL		-TOL		DEV			
A/2	35°00'00"	1 00 00"	1 00 00 "	35°24'23"	0°24'23"	0 00 00 "	#	
DTM	#113B= LOCAT	TON OF CVITE	NDED CVIA	IINTTS-MM				
AX		+TOL	-TOL		DEV	OUTTOL		
R		0.200				0.000	#	
DIM	#113C= LOCAT	ION OF CYLI	NDER CYL3	UNITS=MM				
AX		+TOL		MEAS		OUTTOL		
R	3.000	0.200	0.200	3.014	0.014	0.000	#	
DTM	#111A= 2D DI	STANCE FROM	CYLINDER	CYI.3 TO CYI	TINDER CYLA	PAR TO Y	AVIS ADD RA	DTIIS IINI
AX	NOMINAL				DEV			DIOS ONI
M	41.270			41.248		0.000	#	
Acti	ive alignment	changed to	A7					
DIM	#114B= POSIT	ION OF CYLI	NDER CYL4	USE AXIS=A	AVERAGE REF	LENGTH=0.	000 UNITS=	MM DISPI
AX	NOMINAL	+TOL	-TOL	BONUS		DEV	OUTTOL	
X	0.000				-0.166			
Y	17.635				17.557	-0.078		
DF	3.000	0.250	0.250	0 000	3.070 0.183	0.070	0.000	
TP	RFS	0.380		0.000	0.183	0.183	0.000	#
DIM	#114C= POSIT	ION OF CYLI	NDER CYL3	USE AXIS=A	AVERAGE REF	LENGTH=0.	000 UNITS=	MM DISPI
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS		OUTTOL	
X	0.000					0.216		
	-17.635				-17.608			
DF			0.250	0 000			0.000	
TP	RFS	0.380		0.000	0.217	0.217	0.000	#
Acti	lve alignment	changed to	A9					
Acti	lve alignment	changed to	A10					
DTM	LOC31= LOCAT	ITON OF DOIN	n Dime iii	NIT III C — MA				
AX			T PNTS UI -TOL		DEV	OUTTOL		
	89.517				0.168		#-	
Z	103.047	0.250	0.250				#	
Acti	lve alignment	changed to	A6					
DIM	LOC9= LOCATI	ON OF CIRCLE	E CIR1 U	NITS=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
X	0.000	0.150	0.150		-0.065		#	
Y	-105.000	0.250	0.250				#	
D	16.654	0.400	0.400	16.666	0.012	0.000	#	
PNT8	B = POINT BUI	LT FROM 2 FI	EATURES C	YL6, PLN9				
	9 = POINT BUI							
	#54= POSITIO							
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	0.000				-0.005	-0.005		
Y	-169.417 -43.690				-169.480 -43.778	-0.063 -0.088		
Z TP	-43.690 RFS	0.500		0.000	0.216	0.216	0 000	#
TE	617	0.500		0.000	0.210	0.210	0.000	#

AX NOMINAL +TOL -TOL BONUS MEAS DEV OUTTOL X 0.000 -0.054 -0.054

DIM #54A= POSITION OF POINT PNT9 UNITS=MM

Y	169.417				169.357	-0.060		
PART	NUMBER=SE	PIDER FINISH	H	PART NUMBER	: 321101012E	DATE	=21-Jun-25	TIME=
M	PA	AGE#=11						
Z					-43.683			
TP	RFS	0.500		0.000	0.162	0.162	0.000	#
7 0+ 1	olianma	at abangod	± ~ 712					
ACLI	.ve arrgime	ent changed	to Als					
Alic	nment Reca	alled ID=A3						
_	,							
				CIR40, CIR41,	,			
Acti	ve alignme	ent changed	to A15					
7 ~+ -	1		±- 716					
ACTI	ve alignme	ent changed	to Alb					
DIM	#32,26,58,	59.LOC7= PO	OSITION OF C	IRCLE CIR15	UNITS=MM			
AX	NOMINAL	+TOL		BONUS	MEAS	DEV	OUTTOL	
X	97.010				96.958	-0.052		
Y	40.180					-0.037		
DF	16.500	0.200	0.200	0.364	16.664	0.164	0.000	#
TP	MMC	0.400		0.364	0.128	0.128		-#
		59.LOC7= PC	OSITION OF C	CIRCLE CIR16	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	74.250					-0.044		
Y	74.250				74.203	-0.047		
DF	16.500	0.200	0.200	0.361	16.661	0.161	0.000	#
TP	MMC	0.400		0.361	0.129	0.129	0.000	-#
DIM	11.20 20 20	E0 1007 D		ITDATE ATD17	IINITEO MM			
				CIRCLE CIR17		DELI	OTTEMOT	
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X Y	40.180				40.138	-0.042		
DF	97.010 16.500	0.200	0.200			-0.048 0.155	0 000	#-
TP	RFS	0.400	0.200	0.000	0.128			#
IF	KFS	0.400		0.000	0.120	0.128	0.000	#
DIM	#29,58,59I	LOC10= POSI	TION OF CIRC	LE CIR4 UNI	TS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	0.000				-0.067	-0.067		
Y	105.000				104.957	-0.043		
DF	16.500	0.200	0.200		16.659	0.159	0.000	#
TP	RFS	0.400		0.000	0.159	0.159		#
				CIRCLE CIR5				
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	-40.180				-40.243	-0.063		
Y	97.010				96.969	-0.041		
DF	16.500	0.200	0.200		16.637	0.137		#-
TP	RFS	0.400		0.000	0.150	0.150	0.000	#
D.T.:	W01 05 50		DOGETHE CO. C.		TINITED SO:			
				CIRCLE CIRC		D. 27. 7	OTTER OT	
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	-74.250				-74.307	-0.057		
Y	74.250	0.000	0.000		74.196	-0.054	0 000	
DF	16.500	0.200	0.200	0 000	16.672	0.172	0.000	#
TP	RFS	0.400		0.000	0.156	0.156	0.000	#
DTM	#32 26 50	59A T.OC22-	DOSTUTOM OF	' CIRCLE CIR7	/ IINITTS-MM			
AX	#32,26,58, NOMINAL	+TOL	-TOL	BONUS	UNITS=MM MEAS	DEV	OUTTOL	
AA	NOMITINAL	+10L	-1.07	DUNUS	MEAS	DF A	OUTTOL	

-97.073

40.155

16.648

0.000

-0.063

-0.025

0.148

0.136

0.000 ----#-

0.000 ---#----

Χ

Y

DF TP -97.010

40.180

16.500

RFS

0.200

0.400

0.200

AX	NOMINAL	+TOL	F CIRCLE CI -TOL		MEAS	DEV	OUTTOL	
PART	NUMBER=SP	IDER FINISH		PART NUMBER	: 321101012E	DATE:	=21-Jun-25	TIME=
M	PA	GE#=12						
X	-105.000				-105.061	-0.061		
Y	0.000				-0.049	-0.049		
DF	16.500	0.200	0.200		16.666	0.166	0.000	#
TP	RFS	0.400		0.000		0.156		#
DTM	#32 26 58	59B I.OC32=	POSTUTOM OF	CIRCLE CIR9	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	-97.010	1101	101	DONOS	-97.069	-0.059	OOTIOD	
Y	-40.180				-40.220	-0.040		
DF	16.500	0.200	0.200		16.663	0.163	0 000	#
TP	RFS	0.400	0.200	0.000	0.142	0.142		#
11	KES	0.400		0.000	0.142	0.142	0.000	π
				CIRCLE CIR10		DELL	011555	
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	-74.250				-74.329	-0.079		
Y	-74.250	0 000	0 000			-0.015	0 000	
	16.500	0.200	0.200	0 000		0.161 0.160		#
TP	RFS	0.400		0.000	0.160	0.160	0.000	#
DIM	#30,28,58,	59B.LOC34=	POSITION OF	CIRCLE CIR11	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	-40.180				-40.256	-0.076		
Y	-97.010				-97.038	-0.028		
DF	16.500		0.200		16.664	0.164		#
TP	RFS	0.400		0.000	0.162	0.162	0.000	#
DIM	#29,58,59A	.LOC35= POS	ITION OF CI	RCLE CIR3 UN	IITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	0.000				-0.067	-0.067		
Y	-105.000				-105.023	-0.023		
DF	16.500	0.200	0.200		16.661	0.161	0.000	#
TP	RFS	0.400		0.000	0.142	0.142		#
DTM	#30.28.58.	59C I.OC36=	POSITION OF	CIRCLE CIR12	IINITTS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	40.180	1101	101	DONOD	40.118	-0.062	OOTIOL	
	-97.000					-0.028		
DF	16.500	0.200	0.200		16.668	0.168	0 000	#
TP	RFS	0.400	0.200	0.000	0.136			#
				CIRCLE CIR13				
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	74.250				74.175	-0.075		
Y	-74.250				-74.285	-0.035		
DF	16.500	0.200	0.200		16.660	0.160		#
TP	RFS	0.400		0.000	0.165	0.165	0.000	#
DIM	#32,26,58,	58C.LOC38=	POSITION OF	CIRCLE CIR14	UNITS=MM			
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	97.010				96.934	-0.076		
Y	-40.180				-40.224	-0.044		
DF	16.500	0.200	0.200		16.664	0.164	0.000	#
TP	RFS	0.400		0.000	0.176	0.176	0.000	#
DIM	LOC7= LOCA	TION OF CIR	CLE CIR39	UNITS=MM				
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
X	0.000						-#	
Y	0.010				-0.042		#	
D	210.000				-0.005		#	
_		0.100	3.100	_00.00	3.000		"	

DIM	#53.LOC10=	POSITION OF	CYLINDER C	CYL2 USE	AXIS=AVERAGE	REF LENGTH	i=0.000 UN	ITS=MM
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
PART	NUMBER=SPI	IDER FINISH	P	PART NUMBE	CR : 3211010	12E DATE=	21-Jun-25	TIME=
M	PAC	GE#=13						
X	0.000				-0.023	-0.023		
DF	38.100	0.100	0.100		38.071	-0.029	0.000	#
TP	RFS	0.400		0.000	0.046	0.046	0.000	-#
DIM	LOC15= POSI	ITION OF CYL	INDER CYL6	USE AXIS	S=AVERAGE RE	F LENGTH=0.0	000 UNITS=	MM
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	0.000				0.027	0.027		
DF	38.100	0.100	0.100		38.081	-0.019	0.000	#
TP	RFS	0.400		0.000	0.054	0.054	0.000	-#

Active alignment changed to A14

CIR32=CIRCLE MEASURED FROM 9 HITS

END OF MEASUREMENT FOR

PN=SPIDER FINISH PART NUMBER : 321101012E

TOTAL # OF MEAS = 0 # OUT OF TOL = 0 # OF HOURS = 00:00:37 DWG=G