



DATE=21-Jun-25  
PART NAME : SPIDER FINISH  
REV NUMBER : G  
SER NUMBER :  
STATS COUNT : 1

TIME=5:51:33 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 : REJECT

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

AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL
X	-158.750				-158.725	0.025	

Y	0.000				0.007	0.007		
PART 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	-----#-
TP	RFS	0.100		0.000	0.052	0.052	0.000	----#----
DIM LOC6= POSITION OF CIRCLE CIR4 UNITS=MM								
AX	NOMINAL	+TOL	-TOL	BONUS	MEAS	DEV	OUTTOL	
X	158.750				158.751	0.001		
Y	0.000				0.008	0.008		
DF	8.690	0.080	0.080		8.736	0.046	0.000	-----#-
TP	RFS	0.100		0.000	0.015	0.015	0.000	-#-----
DIM #67= 2D DISTANCE FROM PLANE PLN2 TO CIRCLE CIR6 PAR TO ZAXIS,NO_RADIUS UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	3.960	0.130	0.130	3.942	-0.018	0.000	---#-----	
DIM #67A= 2D DISTANCE FROM PLANE PLN2 TO CIRCLE CIR7 PAR TO ZAXIS,NO_RADIUS UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	3.960	0.130	0.130	3.994	0.034	0.000	-----#---	
DIM #67B= 2D DISTANCE FROM PLANE PLN2 TO CIRCLE CIR9 PAR TO ZAXIS,NO_RADIUS UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	3.960	0.130	0.130	4.017	0.057	0.000	-----#--	
DIM #67C= 2D DISTANCE FROM PLANE PLN2 TO CIRCLE CIR8 PAR TO ZAXIS,NO_RADIUS UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	3.960	0.130	0.130	4.001	0.041	0.000	-----#---	
DIM LOC12= LOCATION OF PLANE PLN2 UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
Z	107.040	0.200	0.200	107.045	0.005	0.000	----#----	
DIM #101= 2D DISTANCE FROM PLANE PLN8 TO PLANE PLN11 PAR TO XAXIS,NO_RADIUS UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	115.870	0.130	0.130	115.860	-0.010	0.000	----#----	
DIM DIST6= 2D DISTANCE FROM PLANE PLN9 TO PLANE PLN10 PAR TO XAXIS,NO_RADIUS UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
M	115.870	0.130	0.130	115.748	-0.122	0.000	#-----	
DIM #102= LOCATION OF POINT PNT5 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	----#----	
DIM #102A= LOCATION OF POINT PNT6 UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
Y	-141.146	0.250	0.250	-141.090	0.056	0.000	-----#---	
Z	145.633	0.250	0.250	145.651	0.018	0.000	----#----	
DIM #102B= LOCATION OF POINT PNT8 UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
X	-42.850	0.250	0.250	-42.703	0.147	0.000	-----#-	
Y	141.146	0.250	0.250	141.290	0.144	0.000	-----#-	
Z	145.633	0.250	0.250	145.739	0.106	0.000	-----#--	
DIM #102C= LOCATION OF POINT PNT7 UNITS=MM								
AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL		
X	42.850	0.250	0.250	42.981	0.131	0.000	-----#--	
Y	141.146	0.250	0.250	141.143	-0.003	0.000	----#----	
Z	145.633	0.250	0.250	145.663	0.030	0.000	-----#---	

Active alignment changed to A4





X 3.000 3.179 0.179  
PART NUMBER=SPIDER FINISH PART NUMBER : 321101012E DATE=21-Jun-25 TIME=  
M PAGE#=6  
Y 0.000 0.199 0.199  
DF 3.000 0.100 0.100 3.001 0.001 0.000 ----#----  
TP RFS 0.500 0.000 0.268 0.268 0.000 ----#----

Active alignment changed to A12

DIM #9,#8B= POSITION OF CYLINDER CYL11 USE AXIS=AVERAGE REF LENGTH=0.000 UNITS=MM DIS  
US  
AX NOMINAL +TOL -TOL BONUS MEAS 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 0.000 -----#----  
TP RFS 0.500 0.000 0.195 0.195 0.000 ---#-----

Active alignment changed to A11

DIM LOC3= LOCATION OF PLANE PLN2 UNITS=MM  
AX NOMINAL +TOL -TOL MEAS DEV OUTTOL  
Z 84.588 0.200 0.200 84.523 -0.065 0.000 ---#-----  
  
DIM LOC5= POSITION OF CYLINDER CYL7 USE AXIS=AVERAGE REF LENGTH=0.000 UNITS=MM  
AX NOMINAL +TOL -TOL BONUS MEAS DEV OUTTOL  
X 0.000 0.057 0.057  
Y 13.635 13.667 0.032  
DF 12.237 0.080 0.080 12.246 0.009 0.000 -----#----  
TP RFS 0.500 0.000 0.131 0.131 0.000 --#-----

PN=SPIDER FINISH END OF MEASUREMENT FOR  
PART NUMBER : 321101012E DWG=G  
TOTAL # OF MEAS =70 # OUT OF TOL =2 # OF HOURS =00:22:58