





DIMENSIONAL PART REPORT										LABORATORY				
Report Number: 2024-0005_s														
Customer: BMW										Issue date: October 7, 2024				
Customer part number:														
Part name: SUPPORT ROD LS CPL VCR					Evaluation reason: <input type="checkbox"/> Annual validation: <input type="checkbox"/> New part. <input type="checkbox"/> Engineering change. <input type="checkbox"/> New tooling. <input type="checkbox"/> Corrected tooling. <input type="checkbox"/> Prototype piece. <input checked="" type="checkbox"/> Others (Specify):					Evaluated by: MIREYA HERNANDEZ				
Part number: 1372107										Evaluation date: October 7, 2024				
Number of pieces: 5										Authorized by: OSCAR GOMEZ				
Plane No.: 1372107 Dated: 02.10.18 Change: c										Evaluation machine: CMM (EM-005) / Vision System / Caliper				
Date of production and/or Batch Number					FULL LAY OUT _supplier _Nigbo					Calibration date: FEB.-24 / JUN-24 / SEP-24				
Observations:														
Item	Measuring equipment used	Characteristics	Especial Features	Spec.:			Limits		Draw: 1372107					Result
				NOMINAL	TOL. MIN -	TOL. MAX +	MIN. -	MAX. +	Obtained Value:					
									Piece 1	Piece 2	Piece 3	Piece 4	Piece 5	
1	CMM	WIDENING ALLOWED MAX.			14.300	0.000	14.300	14.240	14.260	14.240	14.150	14.25	OK	
2	Caliper	WIDENING ALLOWED MAX.			16.000	0.000	16.000	14.400	14.430	14.460	14.440	14.47	OK	
3	CMM	Radius		850.000	50.000	50.000	800.000	900.000	892.000	895.120	894.770	896.430	896.264	OK
4	CMM	Position			Φ 3	A B C	0.000	3.000	2.708	2.531	2.612	1.811	1.978	OK
5	Caliper	Distance		12.000	0.100	0.100	11.900	12.100	12.070	12.080	12.080	12.070	12.07	OK
6	Vernier	WIDENING ALLOWED MAX.			12.300	0.000	12.300	12.110	12.120	12.110	12.110	12.12	OK	
7	CMM	Diameter		14.000	0.050	0.110	13.950	14.110	13.962	13.987	13.964	13.975	13.966	OK
	CMM	Position			Φ 2	A B C	0.000	2.000	0.201	0.069	0.365	0.705	0.562	OK
8	V. System	Radius		0.300	0.000	0.200	0.300	0.500	0.302	0.304	0.305	0.303	0.303	OK
9	CMM	Diameter		12.000	0.100	0.100	11.900	12.100	11.910	11.900	11.910	11.950	11.92	OK
	CMM	Position			Φ 2	A B C	0.000	2.000	1.302	1.100	1.201	1.915	1.558	OK
10	CMM	Diameter		9.000	0.100	0.100	8.900	9.100	8.968	8.992	9.005	8.982	8.972	OK
11	CMM	Diameter		13.600	0.200	0.200	13.400	13.800	13.570	13.600	13.520	13.550	13.61	OK
13	V. System	Distance		2.500	0.000	1.500	2.500	4.000	3.910	3.880	3.920	3.890	3.88	OK
14	V. System	Draw a. max		0.000	0.000	0.500	0.000	0.500	0.135	0.132	0.128	0.137	0.13	OK
15	CMM	Angle		90.000	2.000	2.000	88.000	92.000	88.205	88.658	88.308	89.402	89.704	OK
16	CMM	Angle		58.000	REF.				56.483	56.697	56.249	56.403	56.713	
17	CMM	Distance		7.700	MIN.				8.000	8.003	8.005	8.012	8.008	OK
18	CMM	Distance		10.000	0.200	0.200	9.800	10.200	10.128	10.190	10.124	10.165	10.15	OK
19	Caliper	Distance		3.000	0.000	0.500	3.000	3.500	3.650	3.630	3.740	3.670	3.63	X
20	V. System	Distance		13.300	MAX.				13.240	13.220	13.260	13.220	13.26	OK
21	CMM	Distance		7.600	0.000	0.300	7.600	7.900	7.55	7.55	7.560	7.560	7.55	X
22	CMM	Distance		8.800	0.200	0.200	8.600	9.000	8.926	8.895	8.925	8.928	8.92	OK
23	CMM	Perpendicularity				0,4 A	0.000	0.400	0.896	0.934	0.949	0.968	0.914	X

supplier: Nigbo



supplier: T&H

