



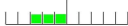



CMM Measurement Report

International Aerospace Manufacturing Pvt Ltd.,
(A JV of Rolls Royce & HAL)
Survey No 3/1, Plot No 2, 3 & 4 Elcot SEZ, Bagalur Road,
Vishwanathapuram, Hosur, Krishnagiri – TN – India – 635 109.



MACHINE NAME	: 2A0324CMM02 Admin	MEASURED DATE / TIME	: 14-05-2025 / 12:15 PM
PART NAME	: CASE, ASSY, STAGE 1	PART NUMBER	: FW71169
METHOD	: HM00	DRAWING ISSUE	: T
OPERATION	: 2285 (INDEPENDENT)	SERIAL NUMBER	: DD0050-1
CMM PROGRAM NO	: FW71169 FINAL	TITLE	:

Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
Ø		Ø628.38	Diameter	628.380	0.150	-0.150	628.358	-0.022			86
◎		Ø628.38	Concentricity X Y	0.000 0.000	0.210	0.000	0.020 -0.008 -0.006	0.020			44-1
Ø		Ø628.84	Diameter	628.840	0.150	-0.150	628.765	-0.075			90
◎		Ø628.84	Concentricity X Y	0.000 0.000	0.210	0.000	0.025 -0.007 -0.011	0.025			44-2



CMM Measurement Report


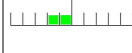
International Aerospace Manufacturing Pvt Ltd.,
(A JV of Rolls Royce & HAL)
Survey No 3/1, Plot No 2, 3 & 4 Elcot SEZ, Bagalur Road,
Vishwanathapuram, Hosur, Krishnagiri – TN – India – 635 109.






























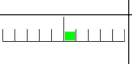



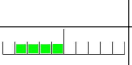

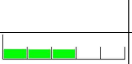

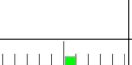














MACHINE NAME	: 2A0125CMM-03 Admin	MEASURED DATE / TIME	: 15-05-2025 / 05:19 PM
PART NAME	: CASE, ASSY, STAGE 1	PART NUMBER	: FW71169
METHOD	: HM00	DRAWING ISSUE	: T
OPERATION	: 3385 (INDEPENDENT)	SERIAL NUMBER	: DD0050-1
CMM PROGRAM NO	: FW71169 FINAL1	TITLE	:

Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
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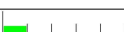
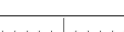
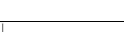








ACTUAL DIA INPUT BY OPERATOR OF FEATURE NO T4-1

		DIA	Formula calculation	634.190	0.020	-0.020	634.184	-0.006			T4-1, Ref Only
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		Ø634.58	Diameter	634.580	0.050	-0.050	634.602	0.022			101
		COATING_TH IKNESS	Formula calculation	0.165	0.085	-0.085	0.209	0.044			17
		Ø634.48	Position X Y	0.000 0.000	0.100	0.000	0.058 0.004 -0.029	0.058			103
		Ø635.08	Diameter	635.080	0.100	-0.100	635.093	0.013			98
		Ø635.08	Concentricity X Y	0.000 0.000	0.160	0.000	0.075 0.035 -0.012	0.075			44-8
		Ø643.36	Diameter	643.360	0.070	-0.070	643.394	0.034			104
		Ø643.36	Position X Y	0.000 0.000	0.100	0.000	0.059 0.028 -0.010	0.059			106
		Dim 8	Position Z	8.000	0.100	-0.100	7.990	-0.010			96
		Ø647.74	Diameter	647.740	0.150	-0.150	647.765	0.025			75
		Ø647.74	Concentricity X Y	0.000 0.000	0.210	0.000	0.056 0.028 0.000	0.056			44-4
		Dim 8	Parallelism		0.100	0.000	0.018 0.000 0.000	0.018			80, Ref Only


MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
		Dim 10.18	Position Z	10.180	0.050	-0.050	10.171	-0.009			81
		Dim 22.4	Position Z	22.400	0.050	-0.050	22.388	-0.012			82
		Ø626.96	Diameter	626.960	0.200	-0.200	626.983	0.023			74
		Ø647.74	Concentricity X Y	-0.021 0.037	0.260	0.000	0.056 0.007 0.037	0.056			44-9
		Ø4.001 Hole Datum - C	Diameter	4.001	0.009	-0.009	3.993	-0.008			148, Ref Only
		Ø4.001 Hole Datum - C	Position X Y	0.000 -331.000	0.120	0.000	0.084 0.000 -330.958	0.084			149
		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.779	0.029			139, Ref Only
	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.579	0.000	0.140 0.036 -331.940	0.140			140
		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.783	0.033			139, Ref Only
	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.583	0.000	0.128 0.037 -331.948	0.128			140
		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.780	0.030			139, Ref Only
	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.580	0.000	0.138 0.045 -331.948	0.138			140
		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.781	0.031			139, Ref Only
	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.581	0.000	0.105 0.044 -331.971	0.105			140

MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.776	0.026			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.576	0.000	0.108 0.050 -331.981	0.108			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.778	0.028			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.578	0.000	0.117 0.057 -331.987	0.117			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.774	0.024			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.574	0.000	0.115 0.057 -332.000	0.115			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.737	-0.013			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.537	0.000	0.122 0.056 -331.975	0.122			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.714	-0.036			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.514	0.000	0.112 0.055 -331.990	0.112			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.776	0.026			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.576	0.000	0.113 0.049 -332.028	0.113			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.776	0.026			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.576	0.000	0.122 0.055 -332.027	0.122			140


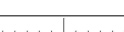

MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.773	0.023			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.573	0.000	0.096 0.045 -332.015	0.096			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.775	0.025			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.575	0.000	0.107 0.053 -332.005	0.107			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.733	-0.017			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.533	0.000	0.141 0.053 -331.953	0.141			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.777	0.027			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.577	0.000	0.126 0.057 -331.974	0.126			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.779	0.029			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.579	0.000	0.131 0.053 -331.962	0.131			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.778	0.028			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.578	0.000	0.147 0.055 -331.951	0.147			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.779	0.029			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.579	0.000	0.164 0.056 -331.940	0.164			140

MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.779	0.029			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.579	0.000	0.171 0.064 -331.944	0.171			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.778	0.028			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.578	0.000	0.170 0.070 -331.952	0.170			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.783	0.033			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.583	0.000	0.187 0.076 -331.946	0.187			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.783	0.033			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.583	0.000	0.183 0.074 -331.947	0.183			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.784	0.034			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.584	0.000	0.202 0.087 -331.948	0.202			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.228 0.101 -331.947	0.228			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.779	0.029			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.579	0.000	0.237 0.105 -331.945	0.237			140

MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.779	0.029			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.579	0.000	0.248 0.108 -331.940	0.248			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.782	0.032			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.582	0.000	0.248 0.116 -331.957	0.248			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.782	0.032			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.582	0.000	0.246 0.117 -331.963	0.246			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.742	-0.008			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.542	0.000	0.235 0.111 -331.960	0.235			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.779	0.029			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.579	0.000	0.238 0.116 -331.976	0.238			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.250 0.125 -331.997	0.250			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.739	-0.011			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.539	0.000	0.213 0.105 -331.984	0.213			140

MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.249 0.124 -332.007	0.249			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.246 0.123 -332.003	0.246			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.781	0.031			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.581	0.000	0.234 0.117 -332.001	0.234			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.221 0.110 -331.999	0.221			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.786	0.036			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.586	0.000	0.212 0.106 -332.007	0.212			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.210 0.105 -332.004	0.210			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.787	0.037			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.587	0.000	0.211 0.104 -332.016	0.211			140

MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.221 0.104 -332.036	0.221			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.789	0.039			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.589	0.000	0.194 0.089 -332.039	0.194			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.787	0.037			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.587	0.000	0.215 0.086 -332.065	0.215			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.788	0.038			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.588	0.000	0.224 0.079 -332.080	0.224			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.782	0.032			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.582	0.000	0.210 0.071 -332.078	0.210			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.185 0.060 -332.070	0.185			140
∅		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.789	0.039			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.589	0.000	0.181 0.062 -332.066	0.181			140







MACHINE NAME : 2A0125CMM-03 Admin							MEASURED DATE / TIME : 15-05-2025 / 05:19 PM				
PART NAME : CASE, ASSY, STAGE 1							PART NUMBER : FW71169				
METHOD : HM00							DRAWING ISSUE : T				
OPERATION : 3385 (INDEPENDENT)							SERIAL NUMBER : DD0050-1				
CMM PROGRAM NO: FW71169 FINAL1							TITLE :				
Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.787	0.037			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.587	0.000	0.143 0.047 -332.055	0.143			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.773	0.023			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.573	0.000	0.123 0.043 -332.044	0.123			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.784	0.034			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.584	0.000	0.090 0.044 -332.012	0.090			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.786	0.036			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.586	0.000	0.089 0.043 -331.990	0.089			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.090 0.040 -331.980	0.090			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.785	0.035			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.585	0.000	0.115 0.045 -331.964	0.115			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.786	0.036			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.586	0.000	0.114 0.041 -331.961	0.114			140

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Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.777	0.027			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.577	0.000	0.138 0.040 -331.944	0.138			140
Ø		Ø5.75 Hole	Diameter	5.750	0.150	-0.150	5.777	0.027			139, Ref Only
⊕	M	Ø5.75 Hole	Position X Y	0.000 -332.000	0.577	0.000	0.110 0.033 -331.957	0.110			140
		Dim 0.40	Position Z	0.400	0.200	-0.200	0.437	0.037			Ref Only
Ø		Ø6 Hole	Diameter	6.000	0.200	-0.200	5.930	-0.070			145, Ref Only
⊕	M	Ø6 Hole	Position X Y	0.000 -332.000	0.630	0.000	0.055 -0.001 -331.973	0.055			146
		Dim 0.40	Position Z	0.400	0.200	-0.200	0.356	-0.044			Ref Only
Ø		Ø6 Hole	Diameter	6.000	0.200	-0.200	5.930	-0.070			145, Ref Only
⊕	M	Ø6 Hole	Position X Y	0.000 -332.000	0.630	0.000	0.066 0.026 -332.021	0.066			146
		Dim 0.40	Position Z	0.400	0.200	-0.200	0.355	-0.045			Ref Only
Ø		Ø6 Hole	Diameter	6.000	0.200	-0.200	5.943	-0.057			145, Ref Only
⊕	M	Ø6 Hole	Position X Y	0.000 -332.000	0.643	0.000	0.107 0.025 -331.952	0.107			146
		Dim 0.40	Position Z	0.400	0.200	-0.200	0.358	-0.042			Ref Only

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Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
Ø		Ø6 Hole	Diameter	6.000	0.200	-0.200	5.930	-0.070			145, Ref Only
⊕	M	Ø6 Hole	Position X Y	0.000 -332.000	0.630	0.000	0.160 0.078 -331.982	0.160			146
		Dim 0.40	Position Z	0.400	0.200	-0.200	0.342	-0.058			Ref Only
Ø		Ø6 Hole	Diameter	6.000	0.200	-0.200	5.917	-0.083			145, Ref Only
⊕	M	Ø6 Hole	Position X Y	0.000 -332.000	0.617	0.000	0.147 0.065 -332.035	0.147			146
		Datum Plane - A	Flatness		0.150	0.000	0.025	0.025			51
Ø		Ø645.66 Datum - B	Diameter	645.660	0.060	-0.060	645.646	-0.014			62
○		Ø645.66 Datum - B	Circularity		0.250	0.000	0.066	0.066			60
		Ø645.66 Datum-B Cylinder	Perpendicularity		0.150	0.000	0.024 0.000 0.000	0.024			61
		Dim 30.23	Position Z	30.230	0.050	-0.050	30.223	-0.007			48
		Dim 5.11	Position Z	5.110	0.150	-0.150	5.122	0.012			120
Ø		Ø639.330	Diameter	639.330	0.080	-0.080	639.329	-0.001			117
⊕		Ø639.330	Position X Y	0.000 0.000	0.100	0.000	0.004 0.000 -0.002	0.004			119
Ø		Ø642.82	Diameter	642.820	0.150	-0.150	642.807	-0.013			63

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		Ø642.82	Concentricity X Y	0.000 0.000	0.210	0.000	0.003 0.000 -0.001	0.003			44-6
		Ø675.75	Diameter	675.750	0.300	-0.300	675.763	0.013			53
		Ø675.75	Concentricity X Y	0.000 0.000	0.360	0.000	0.005 0.000 -0.003	0.005			44-3
		Dim 22.94	Position Z	22.940	0.100	-0.100	22.931	-0.009			49
		Ø633.74 Top	Diameter	633.740	0.150	-0.150	633.801	0.061			64-1, Top
		Ø633.74 Top	Concentricity X Y	0.000 0.000	0.210	0.000	0.011 -0.002 -0.005	0.011			44-5.1
		Ø633.74 Bottom	Diameter	633.740	0.150	-0.150	633.761	0.021			64-2, Bottom
		Ø633.74 Bottom	Concentricity X Y	0.000 0.000	0.210	0.000	0.016 -0.003 -0.007	0.016			44-5.2
		Mismatch	Formula calculation	0.000	0.150	-0.150	0.040	0.040			153
		Ø624.84	Diameter	624.840	0.080	-0.080	624.800	-0.040			65
		Ø624.84	Position X Y	0.000 0.000	0.140	0.000	0.055 -0.026 -0.008	0.055			67
		Ø623.84 Top	Diameter	623.840	0.300	-0.300	623.786	-0.054			70-1
		Ø623.84 Top	Concentricity X Y	0.000 0.000	0.360	0.000	0.037 -0.018 -0.004	0.037			44-7.1
		Ø623.84 Bottom	Diameter	623.840	0.300	-0.300	623.779	-0.061			70-2

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OPERATION	: 3385 (INDEPENDENT)	SERIAL NUMBER	: DD0050-1
CMM PROGRAM NO:	FW71169 FINAL1	TITLE	:

Symbol	Datum & MMC Label	Element name	Characteristic	Nominal	+ Tol.	- Tol.	Actual	Deviation	Tol. Graphic	Out Of Tol	Feature No
		Ø623.84 Bottom	Concentricity X Y	0.000 0.000	0.360	0.000	0.038 -0.015 -0.012	0.038			44-7.2
		Ø625.55	Diameter	625.550	0.080	-0.080	625.484	-0.066			71
		Ø623.84 Bottom	Position X Y	0.000 0.000	0.140	0.000	0.038 -0.015 -0.012	0.038			73