



DATE=08/09/2022

TIME=09:15:22

PART NAME : MANUAL METRIC PART A

REV NUMBER : ISSUE 1

SER NUMBER : 1

STATS COUNT : 1

STARTUP =ALIGNMENT/START,RECALL:,LIST=YES

ALIGNMENT/END

WORKPLANE/ZPLUS

MODE/MANUAL

PREHIT/1.5

RETRACT/1.5

MOVESPEED/ 250

TOUCHSPEED/ 5

FORMAT/TEXT,OPTIONS, , HEADINGS,SYMBOLS, ;NOM,TOL,MEAS,DEV,OUTTOL, ,

WRISTSPEED/ 5

WORKPLANE/ZPLUS

LOADPROBE/PROBE8\_A

TIP/T1A0B0, SHANKIJK=0, 0, 1, ANGLE=0

\$\$ NO,

!!!!!! MEASURED DATUM FEATURES !!!!!!

PLN1\_DATUM\_A=FEAT/PLANE,CARTESIAN,TRIANGLE

THEO/<0,0,0>,<0,0,1>

ACTL/<625.294,171.299,-922.843>,<-0.0000318,-0.0001375,1>

MEAS/PLANE,3

HIT/BASIC,NORMAL,<32.234,32.814,0>,<0,0,1>,<656.855,200.314,-922.838>,USE THEO=YES

HIT/BASIC,NORMAL,<-42.322,8.41,0>,<0,0,1>,<631.594,134.53,-922.847>,USE THEO=YES

HIT/BASIC,NORMAL,<10.088,-41.224,0>,<0,0,1>,<587.434,179.053,-922.843>,USE THEO=YES

ENDMEAS/

A1 =ALIGNMENT/START,RECALL:STARTUP,LIST=YES

ALIGNMENT/LEVEL,ZPLUS,PLN1\_DATUM\_A

ALIGNMENT/TRANS,ZAXIS,PLN1\_DATUM\_A

ALIGNMENT/END

CIR1\_DATUM\_B=FEAT/CIRCLE,CARTESIAN,IN,LEAST\_SQR

THEO/<0,0,-5>,<0,0,1>,50

ACTL/<627.347,171.555,-3.632>,<0,0,1>,50.013

MEAS/CIRCLE,5,WORKPLANE

HIT/BASIC,NORMAL,<25,0,-5>,<-1,0,0>,<628.792,196.52,-3.63>,USE THEO=YES

HIT/BASIC,NORMAL,<7.725,23.776,-5>,<-0.309017,-0.9510565,0>,<652.265,169.469,-3.632>,USE THEO=

YES

HIT/BASIC,NORMAL,<-20.225,14.695,-5>,<0.809017,-0.5877853,0>,<629.791,146.668,-3.627>,USE THEO=

YES

HIT/BASIC,NORMAL,<-20.225,-14.695,-5>,<0.809017,0.5877853,0>,<602.34,171.6,-3.633>,USE THEO=Y

ES

HIT/BASIC,NORMAL,<7.725,-23.776,-5>,<-0.309017,0.9510565,0>,<608.666,188.177,-3.639>,USE THEO

YES

ENDMEAS/

A2 =ALIGNMENT/START,RECALL:A1,LIST=YES

ALIGNMENT/TRANS,XAXIS,CIR1\_DATUM\_B

ALIGNMENT/TRANS,YAXIS,CIR1\_DATUM\_B

ALIGNMENT/END

\$\$ NO,

!!!!!! GENERIC POINTS FOR CURVE CONSTRUCTION !!!!!!

F4 =GENERIC/POINT,DEPENDENT,POLAR,\$

NOM/XYZ,<25+0,265+0,0+0>,\$

MEAS/XYZ,<25+0,265+0,0+0>,\$

NOM/IJK,<0+0,-1+0,0+0>,\$

MEAS/IJK,<0+0,-1+0,0+0>

F1 =GENERIC/POINT,DEPENDENT,CARTESIAN,\$
NOM/XYZ,<0+0,-25+0,0+0>,\$
MEAS/XYZ,<0+0,-25+0,0+0>,\$
NOM/IJK,<0+0,-1+0,0+0>,\$
MEAS/IJK,<0+0,-1+0,0+0>

F2 =GENERIC/POINT,DEPENDENT,POLAR,\$
NOM/XYZ,<25+0,275+0,0+0>,\$
MEAS/XYZ,<25+0,275+0,0+0>,\$
NOM/IJK,<0+0,-1+0,0+0>,\$
MEAS/IJK,<0+0,-1+0,0+0>

F3 =GENERIC/POINT,DEPENDENT,POLAR,\$
NOM/XYZ,<25+0,280+0,0+0>,\$
MEAS/XYZ,<25+0,280+0,0+0>,\$
NOM/IJK,<0+0,-1+0,0+0>,\$
MEAS/IJK,<0+0,-1+0,0+0>

F5 =GENERIC/POINT,DEPENDENT,POLAR,\$
NOM/XYZ,<25+0,285+0,0+0>,\$
MEAS/XYZ,<25+0,285+0,0+0>,\$
NOM/IJK,<0+0,-1+0,0+0>,\$
MEAS/IJK,<0+0,-1+0,0+0>

F6 =GENERIC/POINT,DEPENDENT,POLAR,\$
NOM/XYZ,<25+0,290+0,0+0>,\$
MEAS/XYZ,<25+0,290+0,0+0>,\$
NOM/IJK,<0+0,-1+0,0+0>,\$
MEAS/IJK,<0+0,-1+0,0+0>

F7 =GENERIC/POINT,DEPENDENT,POLAR,\$
NOM/XYZ,<25+0,295+0,0+0>,\$
MEAS/XYZ,<25+0,295+0,0+0>,\$
NOM/IJK,<0+0,-1+0,0+0>,\$
MEAS/IJK,<0+0,-1+0,0+0>

\$\$\$ NO,
!!!!!! CONSTRUCTED CURVE !!!!!!
CRV1 =FEAT/CURVE,DEPENDENT,9,7,TOLERANCE,0.01
THEO/13.09
MEAS/13.09
CONSTR/CURVE,F4,F1,F2,F3,F5,F6,F7,,

\$\$\$ NO,
!!!!!! MEASURED ANGLE FACE !!!!!!
PLN2\_ANGLED\_FACE=FEAT/PLANE,CARTESIAN,TRIANGLE
THEO/<8.93,-31.151,52.876>,<-0.9725406,-0.2327332,-0.0002814>
ACTL/<5.227,-27.699,57.49>,<-0.9935969,-0.112971,-0.0016656>
MEAS/PLANE,4
HIT/BASIC,NORMAL,<6.762,-22.108,62.547>,<-0.9725406,-0.2327332,-0.0002814>,<4.388,-20.413,63.795>,USE THEO=YES
HIT/BASIC,NORMAL,<10.778,-38.879,62.392>,<-0.9725406,-0.2327332,-0.0002814>,<6.037,-34.917,63.802>,USE THEO=YES
HIT/BASIC,NORMAL,<10.742,-38.72,43.22>,<-0.9725406,-0.2327332,-0.0002814>,<6.059,-34.92,51.183>,USE THEO=YES
HIT/BASIC,NORMAL,<7.438,-24.897,43.344>,<-0.9725406,-0.2327332,-0.0002814>,<4.425,-20.547,51.18>,USE THEO=YES
ENDMEAS/

\$\$\$ NO,
!!!!!! CONSTRUCTED POINT FROM CURVE AND PLANE !!!!!!
PNT6\_DATUM\_Z=FEAT/POINT,CARTESIAN,NO
THEO/<7.218,-23.935,0>,<-0.9725406,-0.2327332,-0.0002814>
ACTL/<4.96,-24.503,0>,<-0.9935969,-0.112971,-0.0016656>
CONSTR/POINT,INT,CRV1,PLN2\_ANGLED\_FACE

\$\$\$ NO,
!!!!!! CONSTRUCTED LINE BETWEEN DATUM B AND CONSTRUCTED POINT DATUM Z !!!!!!
LIN1 =FEAT/LINE,CARTESIAN,UNBOUNDED,NO
THEO/<0,0,-2.5>,<0.2887366,-0.9574086,0>
ACTL/<0,0,-1.816>,<0.198412,-0.9801187,0>
CONSTR/LINE,BF,2D,CIR1 DATUM B,PNT6 DATUM Z,,
OUTLIER\_REMOVAL/OFF,3
FILTER/OFF,WAVELENGTH=0

\$\$\$ NO,
!!!!!! ROTATION ALIGNMENT TO LINE AND ROTATE OFFSET !!!!!!

A3 =ALIGNMENT/START,RECALL:A2,LIST=YES  
ALIGNMENT/ROTATE,YMINUS,TO,LIN1,ABOUT,ZPLUS  
ALIGNMENT/ROTATE\_OFFSET,11.538,ABOUT,ZPLUS  
ALIGNMENT/END

DIM LOC1= LOCATION OF POINT PNT6\_DATUM\_Z UNITS=MM,\$  
GRAPH=OFF TEXT=OFF MULT=100.00 OUTPUT=BOTH HALF ANGLE=NO

AX	NOMINAL	+TOL	-TOL	MEAS	DEV	OUTTOL
X	-5.000	0.050	0.050	-5.000	0.000	0.000 ---#----
Y	-24.495	0.050	0.050	-24.495	0.000	0.000 ---#----
Z	0.000	0.050	0.050	0.000	0.000	0.000 ---#----
PR	25.000	0.050	0.050	25.000	0.000	0.000 ----#---

END OF DIMENSION LOC1

END OF MEASUREMENT FOR

PN=MANUAL METRIC PART A DWG=ISSUE 1 SN=1  
TOTAL # OF MEAS =3 # OUT OF TOL =0 # OF HOURS =00:01:10