



HEXAGON METROLOGY

DATE=1/19/2012 TIME=1:24:02 PM
PART NAME : ALL CYL BLOCK EURO-2
REV NUMBER : V553700009800
SER NUMBER : A22
STATS COUNT : 1

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

ALIGNMENT/END

MODE/MANUAL

CHECK/ 10,1

MOVESPEED/ 30

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

LOADPROBE/ALL-2011

TIP/TIP1, SHANKIJK=0, 0, 1, ANGLE=90

PLN2 =FEAT/PLANE,CARTESIAN,TRIANGLE

THEO/<1387.3007,722.0622,345.6597>,<0.0001002,-0.000362,0.9999999>

ACTL/<1303.2211,238.7345,345.5137>,<0.0000122,0.0001227,1>

MEAS/PLANE,3

HIT/BASIC,NORMAL,<1059.4678,809.5263,345.7245>,<0.0001002,-0.0003561,0.9999999>,<104
2.4274 ,406.0299,345.4964>,USE THEO=YES

HIT/BASIC,NORMAL,<1380.2457,550.6868,345.6002>,<0.0001002,-0.0003561,0.9999999>,<119
4.981 ,155.0557,345.5253>,USE THEO=YES

HIT/BASIC,NORMAL,<1722.1811,806.1104,345.6569>,<0.0001002,-0.0003561,0.9999999>,<167
2.2547 ,155.1178,345.5194>,USE THEO=YES

ENDMEAS/

CIR1 =FEAT/CIRCLE,CARTESIAN,IN,LEAST_SQR

THEO/<1715.8576,573.4981,339.6138>,<0,0,1>,18.0098

ACTL/<1716.0748,179.841,340.6394>,<0,0,1>,18.013

MEAS/CIRCLE,4,WORKPLANE

HIT/BASIC,NORMAL,<1707.1723,575.8742,339.6804>,<0.9646792,-0.2634273,0>,<1707.1195,1
78.8642 ,340.6353>,USE THEO=YES

HIT/BASIC,NORMAL,<1716.7463,564.5447,339.6341>,<-0.0985773,0.9951294,0>,<1717.164,17
0.9025 ,340.6393>,USE THEO=YES

HIT/BASIC,NORMAL,<1724.7859,572.3203,339.5967>,<-0.9913502,0.131243,0>,<1724.995,178
.5859 ,340.6456>,USE THEO=YES

HIT/BASIC,NORMAL,<1715.7613,582.5006,339.6446>,<0.0108492,-0.9999411,0>,<1712.8282,1
88.2403 ,340.6376>,USE THEO=YES

ENDMEAS/

```
CIR2 =FEAT/CIRCLE,CARTESIAN,IN,LEAST_SQR
THEO/<1293.8769,573.7089,338.7962>,<0,0,1>,18.0164
ACTL/<1294.099,179.1262,339.8633>,<0,0,1>,18.0068
MEAS/CIRCLE,4,WORKPLANE
HIT/BASIC,NORMAL,<1284.9402,574.7329,339.0325>,<0.9935443,-0.1134451,0>,<1286.2075,1
74.7912 ,339.8609>,USE THEO=YES

HIT/BASIC,NORMAL,<1293.5985,564.7076,338.8314>,<0.0314502,0.9995053,0>,<1296.0056,17
0.3275 ,339.8626>,USE THEO=YES

HIT/BASIC,NORMAL,<1302.7813,572.3726,338.6949>,<-0.9888643,0.1488201,0>,<1303.0491,1
78.1438 ,339.8665>,USE THEO=YES

HIT/BASIC,NORMAL,<1293.8353,582.7191,338.7738>,<0.005175,-0.9999866,0>,<1295.0502,18
8.0788 ,339.8631>,USE THEO=YES

ENDMEAS/
A1 =ALIGNMENT/START,RECALL:STARTUP,LIST=YES
ALIGNMENT/LEVEL,ZPLUS,PLN2
ALIGNMENT/TRANS,ZAXIS,PLN2
ALIGNMENT/ROTATE_CIRCLE,XMINUS,TO,CIR1,AND,CIR2,ABOUT,ZPLUS
ALIGNMENT/TRANS,XAXIS,CIR1
ALIGNMENT/TRANS,YAXIS,CIR1
ALIGNMENT/END
MODE/DCC
CLEARP/ZPLUS,10,ZPLUS,0,ON
MOVESPEED/ 100
TEMPCOMP/ORIGIN=0,0,0,Material Coeff=0.0000115,Reference Temp=20
,Hi Threshold=26,Lo Threshold=18,Sensor num=14
,X Axis Temp=21.0533,Y Axis Temp=21.5167,Z Axis Temp=22.3533,Part Temp=23.6
SUMP FACE =FEAT/PLANE,CARTESIAN,OUTLINE
THEO/<-363.9169,104.8777,-0.0002>,<-0.0000373,-0.0000925,1>
ACTL/<-363.928,104.9059,0.0549>,<-0.0000837,-0.0002947,1>
MEAS/PLANE,6
MOVE/CLEARPLANE
HIT/BASIC,NORMAL,<-634.0232,235.5447,-0.0039>,<-0.0000366,-0.0000661,1>,<-633.993,235.
5416 ,0.0292>,USE THEO=YES

HIT/BASIC,NORMAL,<-634.2215,-24.1113,-0.0097>,<-0.0000366,-0.0000661,1>,<-634.1918,-24
.1023 ,0.0208>,USE THEO=YES

HIT/BASIC,NORMAL,<-414.1098,235.1642,0.0125>,<-0.0000366,-0.0000661,1>,<-414.0898,235
.1575 ,0.1049>,USE THEO=YES

HIT/BASIC,NORMAL,<-343.6281,-24.4454,0.0008>,<-0.0000366,-0.0000661,1>,<-343.6081,-24.
4362 ,0.0325>,USE THEO=YES

HIT/BASIC,NORMAL,<-70.6698,227.8835,0.0291>,<-0.0000366,-0.0000661,1>,<-70.6595,227.8
792 ,0.143>,USE THEO=YES

HIT/BASIC,NORMAL,<-87.036,-20.6139,-0.0028>,<-0.0000366,-0.0000661,1>,<-87.0258,-20.60
46 ,-0.0008>,USE THEO=YES

ENDMEAS/
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DH-1   =FEAT/CIRCLE,CARTESIAN,IN,LEAST_SQR
        THEO/<-0.001,-0.0007,-6.4276>,<0,0,1>,18.0092
        ACTL/<0.081,0.0112,-6.4208>,<0,0,1>,18.0132
        MEAS/CIRCLE,4,WORKPLANE
        MOVE/CLEARPLANE
        HIT/BASIC,NORMAL,<-8.972,0.7451,-6.3473>,<0.9965674,-0.0827852,0>,<-8.8964,0.7413,-6.33
          67 >,USE THEO=YES

        HIT/BASIC,NORMAL,<1.8761,-8.7986,-6.2704>,<-0.2091175,0.9778905,0>,<1.8502,-8.8194,-6.2
          592 >,USE THEO=YES

        HIT/BASIC,NORMAL,<8.8414,-1.6363,-6.6904>,<-0.9833171,0.1818998,0>,<8.9304,-1.6677,-6.6
          771 >,USE THEO=YES

        HIT/BASIC,NORMAL,<-0.4965,8.985,-6.4207>,<0.0545651,-0.9985102,0>,<-0.5262,8.9968,-6.41
          01 >,USE THEO=YES

        ENDMEAS/
DH-2   =FEAT/CIRCLE,CARTESIAN,IN,LEAST_SQR
        THEO/<-422.001,-0.0064,-5.5279>,<0,0,1>,18
        ACTL/<-421.8979,0.0102,-5.4811>,<0,0,1>,18.0037
        MEAS/CIRCLE,4,WORKPLANE
        MOVE/CLEARPLANE
        HIT/BASIC,NORMAL,<-430.9315,1.0565,-5.416>,<0.992998,-0.1181313,0>,<-430.8386,1.0476,-
          5.4058 >,USE THEO=YES

        HIT/BASIC,NORMAL,<-421.5615,-8.9942,-5.5323>,<-0.0483828,0.9988289,0>,<-421.576,-8.987
          3 ,-5.5212>,USE THEO=YES

        HIT/BASIC,NORMAL,<-413.6777,-3.4302,-5.5328>,<-0.9247465,0.3805835,0>,<-413.6051,-3.48
          83 ,-5.5181>,USE THEO=YES

        HIT/BASIC,NORMAL,<-421.704,8.9869,-5.4892>,<-0.0325479,-0.9994702,0>,<-421.716,9.0112,
          -5.4793 >,USE THEO=YES

        ENDMEAS/
        MOVE/CLEARPLANE
        MOVE/POINT,NORMAL,<-874,0,10>
        TIP/TIP3, SHANKIJK=-1, -0.0005, -0.0001, ANGLE=-89.9793
        WORKPLANE/XMINUS
        CLEARP/XMINUS,-724,ZPLUS,0,ON
PNT-3  =FEAT/POINT,CARTESIAN
        THEO/<-693.4721,21.909,-11.0169>,<-1,0,0>
        ACTL/<-693.3941,21.9136,-11.0221>,<-1,0,0>
        MEAS/POINT,1
        MOVE/CLEARPLANE
        HIT/BASIC,NORMAL,<-693.4721,21.909,-11.0169>,<-1,0,0>,<-693.3941,21.9136,-11.0221>,US
          E THEO= YES

        ENDMEAS/
PNT-4  =FEAT/POINT,CARTESIAN
        THEO/<-693.4136,188.4916,-11.031>,<-1,0,0>
        ACTL/<-693.3655,188.4898,-11.0377>,<-1,0,0>
        MEAS/POINT,1
        MOVE/CLEARPLANE
        HIT/BASIC,NORMAL,<-693.4136,188.4916,-11.031>,<-1,0,0>,<-693.3655,188.4898,-11.0377>,
          USE THEO= YES

        ENDMEAS/

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REAR FACE =FEAT/PLANE,CARTESIAN,OUTLINE

THEO/⟨-693.4964,105.7613,-167.8259⟩,⟨-0.9999999,0.0004738,-0.0000687⟩

ACTL/⟨-693.365,105.8366,-167.5552⟩,⟨-1,0.0002191,-0.000101⟩

MEAS/PLANE,11

MOVE/CLEARPLANE

HIT/BASIC,NORMAL,⟨-693.6192,-39.3205,-9.8518⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.419,-39.3162,-9.8551⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.5657,21.5079,-14.6107⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3957,21.5112,-14.6193⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.4563,246.0878,-14.7792⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3497,246.0843,-14.7867⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.4847,202.7005,-136.5762⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3459,202.6976,-136.5806⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.5056,110.1534,-150.4861⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3645,110.1571,-150.491⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.549,12.2128,-148.0204⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3872,12.216,-148.0279⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.5268,37.468,-251.3063⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3667,37.4706,-251.3092⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.5051,110.5829,-251.3416⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3476,110.5851,-251.3463⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.4581,201.0093,-257.0236⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3382,201.0079,-257.0278⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.4601,172.5817,-304.6743⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3397,172.5822,-304.6751⟩,USE THEO=YES

HIT/BASIC,NORMAL,⟨-693.5462,89.2043,-304.3838⟩,⟨-0.9999999,0.0005001,-0.0000857⟩,⟨-693.3606,89.2066,-304.3882⟩,USE THEO=YES

ENDMEAS/

MOVE/CLEARPLANE

MOVE/POINT,NORMAL,⟨-707,90,134⟩

TIP/TIP2, SHANKIJK=1, 0.0005, 0.0001, ANGLE=89.9793

WORKPLANE/XPLUS

CLEARP/XPLUS,61,ZPLUS,0,ON

FRONT FACE =FEAT/PLANE,CARTESIAN,OUTLINE

THEO/<39.5039,122.9335,-179.6792>,<0.9999999,-0.0004722,0.0000127>

ACTL/<39.6055,122.717,-179.3971>,<1,-0.0002403,0.0000974>

MEAS/PLANE,11

MOVE/CLEARPLANE

HIT/BASIC,NORMAL,<39.4645,-8.659,-13.9532>,<0.9999999,-0.0004119,0.0000668>,<39.5611,-8.6516,-13.9617>,USE THEO=YES

HIT/BASIC,NORMAL,<39.5773,222.1624,-14.0269>,<0.9999999,-0.0004119,0.0000668>,<39.612,222.16,-14.038>,USE THEO=YES

HIT/BASIC,NORMAL,<39.5472,224.7253,-132.6906>,<0.9999999,-0.0004119,0.0000668>,<39.6218,224.7283,-132.6985>,USE THEO=YES

HIT/BASIC,NORMAL,<39.5563,154.6399,-132.5186>,<0.9999999,-0.0004119,0.0000668>,<39.6081,154.6462,-132.5288>,USE THEO=YES

HIT/BASIC,NORMAL,<39.4529,19.4825,-132.6676>,<0.9999999,-0.0004119,0.0000668>,<39.5747,19.4875,-132.675>,USE THEO=YES

HIT/BASIC,NORMAL,<39.4906,42.5391,-191.1033>,<0.9999999,-0.0004119,0.0000668>,<39.585,42.5441,-191.1101>,USE THEO=YES

HIT/BASIC,NORMAL,<39.5775,116.9062,-216.3539>,<0.9999999,-0.0004119,0.0000668>,<39.6145,116.9088,-216.3614>,USE THEO=YES

HIT/BASIC,NORMAL,<39.5743,216.2541,-226.9508>,<0.9999999,-0.0004119,0.0000668>,<39.6339,216.2501,-226.9585>,USE THEO=YES

HIT/BASIC,NORMAL,<39.5691,246.6981,-305.5455>,<0.9999999,-0.0004119,0.0000668>,<39.6518,246.6966,-305.5502>,USE THEO=YES

HIT/BASIC,NORMAL,<39.535,104.7137,-305.3555>,<0.9999999,-0.0004119,0.0000668>,<39.6064,104.718,-305.3626>,USE THEO=YES

HIT/BASIC,NORMAL,<39.5032,10.3914,-302.1171>,<0.9999999,-0.0004119,0.0000668>,<39.5915,10.3995,-302.1238>,USE THEO=YES

ENDMEAS/

303 =FEAT/CIRCLE,CARTESIAN,IN,LEAST_SQR

THEO/<30.8758,172.0186,-211.1993>,<1,0,0>,48

ACTL/<31.0576,172.1104,-211.076>,<1,0,0>,48.1731

MEAS/CIRCLE,4,WORKPLANE

MOVE/CLEARPLANE

HIT/BASIC,NORMAL,<30.8483,150.2162,-201.2045>,<0,0.9092577,-0.4162336>,<30.8649,150.1517,-201.172>,USE THEO=YES

HIT/BASIC,NORMAL,<31.1981,150.6788,-222.125>,<0,0.8900568,0.4558497>,<31.1968,150.7038,-222.1067>,USE THEO=YES

HIT/BASIC,NORMAL,<31.1945,168.5686,-234.9298>,<0,0.1442582,0.9895401>,<31.1766,168.5597,-234.9045>,USE THEO=YES

HIT/BASIC,NORMAL,<31.0037,188.3974,-228.7271>,<0,-0.6823186,0.7310549>,<30.9921,188.4384,-228.7804>,USE THEO=YES

ENDMEAS/

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PNT-303 =FEAT/POINT,CARTESIAN
  THEO/<8.2045,173.0047,-213.8717>,<1,0,0>
  ACTL/<8.2793,173.0067,-213.8802>,<1,0,0>
  MEAS/POINT,1
  MOVE/CLEARPLANE
  HIT/BASIC,NORMAL,<8.2045,173.0047,-213.8717>,<1,0,0>,<8.2793,173.0067,-213.8802>,USE
    THEO= YES

  ENDMEAS/
310 =FEAT/CIRCLE,CARTESIAN,IN,LEAST_SQR
  THEO/<32.3892,194.2854,-176.5772>,<1,0,0>,48
  ACTL/<32.3369,194.3598,-176.4627>,<1,0,0>,48.1534
  MEAS/CIRCLE,5,WORKPLANE
  MOVE/CLEARPLANE
  HIT/BASIC,NORMAL,<32.1078,182.6212,-155.6308>,<0,0.4871794,-0.8733019>,<32.1407,182.5
    347 ,-155.4979>,USE THEO=YES

  HIT/BASIC,NORMAL,<32.1014,196.7697,-152.7191>,<0,-0.102991,-0.9946823>,<32.1338,196.7
    859 ,-152.496>,USE THEO=YES

  HIT/BASIC,NORMAL,<32.3763,212.9907,-161.5644>,<0,-0.7798467,-0.6259706>,<32.3929,213.
    1526 ,-161.4214>,USE THEO=YES

  HIT/BASIC,NORMAL,<32.5095,218.1135,-173.7268>,<0,-0.9929637,-0.1184191>,<32.5185,218.
    2727 ,-173.7042>,USE THEO=YES

  HIT/BASIC,NORMAL,<32.5004,216.3153,-186.0482>,<0,-0.9184405,0.3955591>,<32.4985,216.4
    269 ,-186.1056>,USE THEO=YES

  ENDMEAS/
PNT-310 =FEAT/POINT,CARTESIAN
  THEO/<8.2027,200.599,-175.5195>,<1,0,0>
  ACTL/<8.3087,200.5985,-175.5295>,<1,0,0>
  MEAS/POINT,1
  MOVE/CLEARPLANE
  HIT/BASIC,NORMAL,<8.2027,200.599,-175.5195>,<1,0,0>,<8.3087,200.5985,-175.5295>,USE T
    HEO= YES

  ENDMEAS/
PNT-1 =FEAT/POINT,CARTESIAN
  THEO/<39.5011,50.3932,-80.0033>,<1,0,0>
  ACTL/<39.5896,50.4013,-80.015>,<1,0,0>
  MEAS/POINT,1
  MOVE/CLEARPLANE
  HIT/BASIC,NORMAL,<39.5011,50.3932,-80.0033>,<1,0,0>,<39.5896,50.4013,-80.015>,USE THE
    O= YES

  ENDMEAS/
PNT-2 =FEAT/POINT,CARTESIAN
  THEO/<39.5891,162.1238,-80.0124>,<1,0,0>
  ACTL/<39.6033,162.1263,-80.0221>,<1,0,0>
  MEAS/POINT,1
  MOVE/CLEARPLANE
  HIT/BASIC,NORMAL,<39.5891,162.1238,-80.0124>,<1,0,0>,<39.6033,162.1263,-80.0221>,USE
    THEO= YES

  ENDMEAS/
  MOVE/CLEARPLANE
  MOVE/POINT,NORMAL,<60.9313,212.3959,173.7275>
  WORKPLANE/ZPLUS

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LIN1 =FEAT/LINE,CARTESIAN,UNBOUNDED,NO
 THEO/<-0.001,-0.0007,-5.9778>,<-1,-0.0000133,0>
 ACTL/<0.081,0.0112,-5.9509>,<-1,-0.0000023,0>
 CONSTR/LINE,BF,2D,DH-1,DH-2,,
 OUTLIER_REMOVAL/OFF,3
 FILTER/OFF,WAVELENGTH=0

LIN2 =FEAT/LINE,CARTESIAN,UNBOUNDED,NO
 THEO/<39.5011,50.3932,-80.0078>,<0.0007879,0.9999997,0>
 ACTL/<39.5896,50.4013,-80.0186>,<0.0001228,1,0>
 CONSTR/LINE,BF,2D,PNT-1,PNT-2,,
 OUTLIER_REMOVAL/OFF,3
 FILTER/OFF,WAVELENGTH=0

LIN3 =FEAT/LINE,CARTESIAN,UNBOUNDED,NO
 THEO/<-693.4721,21.909,-11.024>,<0.0003508,0.9999999,0>
 ACTL/<-693.3941,21.9136,-11.0299>,<0.0001712,1,0>
 CONSTR/LINE,BF,2D,PNT-3,PNT-4,,
 OUTLIER_REMOVAL/OFF,3
 FILTER/OFF,WAVELENGTH=0

A2 =ALIGNMENT/START,RECALL:A1,LIST=YES
 ALIGNMENT/LEVEL,ZPLUS,SUMP FACE
 ALIGNMENT/TRANS,ZAXIS,SUMP FACE
 ALIGNMENT/TRANS,XAXIS,DH-1
 ALIGNMENT/TRANS,YAXIS,DH-1
 ALIGNMENT/ROTATE,XMINUS,TO,LIN1,ABOUT,ZPLUS
 ALIGNMENT/END

DIM FLAT1= FLATNESS OF PLANE SUMP FACE UNITS=MM,\$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.0000	0.0692	0.0200	0.0000	0.0692	0.0492 ----->

DIM LOC1= LOCATION OF CIRCLE DH-1 UNITS=MM,\$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000 ---#----
Y	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000 ---#----
D	18.0000	18.0132	0.0180	0.0000	0.0132	0.0000 -----#--

END OF DIMENSION LOC1

DIM LOC2= LOCATION OF CIRCLE DH-2 UNITS=MM,\$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	-422.0000	-421.9788	0.0400	-0.0400	0.0212	0.0000 -----#-
Y	0.0000	0.0003	0.0000	0.0000	0.0003	0.0003 ----->
D	18.0000	18.0037	0.0180	-0.0100	0.0037	0.0000 ---#----

END OF DIMENSION LOC2

DIM LOC4= LOCATION OF PLANE FRONT FACE UNITS=MM,\$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	39.5000	39.5103	0.2000	-0.2000	0.0103	0.0000 ----#---

END OF DIMENSION LOC4

DIM LOC3= LOCATION OF PLANE REAR FACE UNITS=MM,\$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	-693.5000	-693.4593	0.2000	-0.2000	0.0407	0.0000 ----#---

END OF DIMENSION LOC3

A3 =ALIGNMENT/START,RECALL:A2,LIST=YES
 ALIGNMENT/TRANS,XAXIS,FRONT FACE
 ALIGNMENT/END

DIM LOC5= LOCATION OF PLANE REAR FACE UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	-733.0000	-732.9696	0.2000	-0.2000	0.0304	0.0000 ----#---

END OF DIMENSION LOC5

DIM FLAT2= FLATNESS OF PLANE REAR FACE UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.0000	0.0141	0.1000	0.0000	0.0141	0.0000 -#-----

DIM FLAT3= FLATNESS OF PLANE FRONT FACE UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.0000	0.0138	0.1000	0.0000	0.0138	0.0000 -#-----

DIM PARL1= PARALLELISM OF PLANE FRONT FACE,RFS TO PLANE REAR FACE,RFS UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	0.0000	0.0144	0.1000	0.0000	0.0144	0.0000 -#-----

RECALL/ALIGNMENT,INTERNAL,A2

DIM LOC6= LOCATION OF CIRCLE 303 UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	172.0000	172.0389	0.1500	-0.1500	0.0389	0.0000 ----#--
Z	-211.2200	-211.1838	0.1500	-0.1500	0.0362	0.0000 ----#---
D	48.0000	48.1731	0.2000	-0.2000	0.1731	0.0000 -----#

END OF DIMENSION LOC6

RECALL/ALIGNMENT,INTERNAL,A3

DIM LOC7= LOCATION OF POINT PNT-303 UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	-31.3000	-31.3290	0.2000	-0.2000	-0.0290	0.0000 ---#----

END OF DIMENSION LOC7

DIM LOC8= LOCATION OF POINT PNT-310 UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
X	-31.3000	-31.2964	0.2000	-0.2000	0.0036	0.0000 ----#---

END OF DIMENSION LOC8

RECALL/ALIGNMENT,INTERNAL,A2

DIM LOC9= LOCATION OF CIRCLE 310 UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	194.2700	194.2984	0.1500	-0.1500	0.0284	0.0000 ----#---
Z	-176.6000	-176.5771	0.1500	-0.1500	0.0229	0.0000 ----#---
D	48.0000	48.1534	0.2000	-0.2000	0.1534	0.0000 -----#

END OF DIMENSION LOC9

DIM DIST1= 3D DISTANCE FROM CIRCLE 303 TO CIRCLE 310,NO_RADIUS UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	41.1600	41.1475	0.2000	-0.2000	-0.0125	0.0000 ---#----

LIN4 =FEAT/LINE,CARTESIAN,UNBOUNDED,NO

THEO/<30.8714,172,-211.22>,<0.0367781,0.5406371,0.8404516>

ACTL/<30.9598,172.0389,-211.1838>,<0.0311472,0.5407081,0.8406334>

CONSTR/LINE,BF,3D,303,310,,

OUTLIER_REMOVAL/OFF,3

FILTER/OFF,WAVELENGTH=0

DIM ANGL1= 3D ANGLE FROM LINE LIN4 TO ZAXIS , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
A	32°48'44"	32°47'35"	0°30'00"	-0°30'00"	-0°01'09"	0°00'00" ---#----

COMMENT/REPT,SUMP FACE PER

DIM PERP2= PERPENDICULARITY OF PLANE REAR FACE,RFS TO PLANE SUMP FACE,RFS UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX NOMINAL MEAS +TOL -TOL DEV OUTTOL
M 0.0000 0.0183 0.1000 0.0000 0.0183 0.0000 -#-----

DIM PERP3= PERPENDICULARITY OF PLANE FRONT FACE,RFS TO PLANE SUMP FACE,RFS UNITS=MM , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX NOMINAL MEAS +TOL -TOL DEV OUTTOL
M 0.0000 0.0126 0.1000 0.0000 0.0126 0.0000 -#-----

DIM PERP1= PERPENDICULARITY OF LINE LIN3,RFS TO LINE LIN1,RFS EXTENDLENGTH=0.0000 UNITS=M
M , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX NOMINAL MEAS +TOL -TOL DEV OUTTOL
M 0.0000 0.0289 0.1000 0.0000 0.0289 0.0000 --#-----

DIM PERP4= PERPENDICULARITY OF LINE LIN2,RFS TO LINE LIN1,RFS EXTENDLENGTH=0.0000 UNITS=M
M , \$

GRAPH=OFF TEXT=OFF MULT=10.00 OUTPUT=BOTH

AX NOMINAL MEAS +TOL -TOL DEV OUTTOL
M 0.0000 0.0140 0.1000 0.0000 0.0140 0.0000 -#-----

FPTR =FILE/OPEN,C:\MCD TRAILS\REPORTS\ALL\2011\EURO-2 1ST MACHINE\PALLET-A\11-01-2012\EURO-2.xls ,WRITE

- FILE/WRITELINE,FPTR,FLAT1.MEAS
- FILE/WRITELINE,FPTR,LOC1.D.MEAS
- FILE/WRITELINE,FPTR,LOC2.D.MEAS
- FILE/WRITELINE,FPTR,LOC2.X.MEAS
- FILE/WRITELINE,FPTR,LOC3.X.MEAS
- FILE/WRITELINE,FPTR,FLAT2.MEAS
- FILE/WRITELINE,FPTR,PERP2.MEAS
- FILE/WRITELINE,FPTR,PERP1.MEAS
- FILE/WRITELINE,FPTR,PARL1.MEAS
- FILE/WRITELINE,FPTR,LOC5.X.MEAS
- FILE/WRITELINE,FPTR,LOC4.X.MEAS
- FILE/WRITELINE,FPTR,FLAT3.MEAS
- FILE/WRITELINE,FPTR,PERP3.MEAS
- FILE/WRITELINE,FPTR,PERP4.MEAS
- FILE/WRITELINE,FPTR,LOC6.D.MEAS
- FILE/WRITELINE,FPTR,LOC6.Y.MEAS
- FILE/WRITELINE,FPTR,LOC6.Z.MEAS
- FILE/WRITELINE,FPTR,LOC7.X.MEAS
- FILE/WRITELINE,FPTR,LOC9.D.MEAS
- FILE/WRITELINE,FPTR,LOC9.Y.MEAS
- FILE/WRITELINE,FPTR,LOC9.Z.MEAS
- FILE/WRITELINE,FPTR,LOC8.X.MEAS
- FILE/WRITELINE,FPTR,DIST1.MEAS
- FILE/WRITELINE,FPTR,ANGL1.MEAS

END OF MEASUREMENT FOR

PN=ALL CYL BLOCK EURO-2 DWG=V553700009800 SN=A22
TOTAL # OF MEAS =0 # OUT OF TOL =0 # OF HOURS =00:00:00