

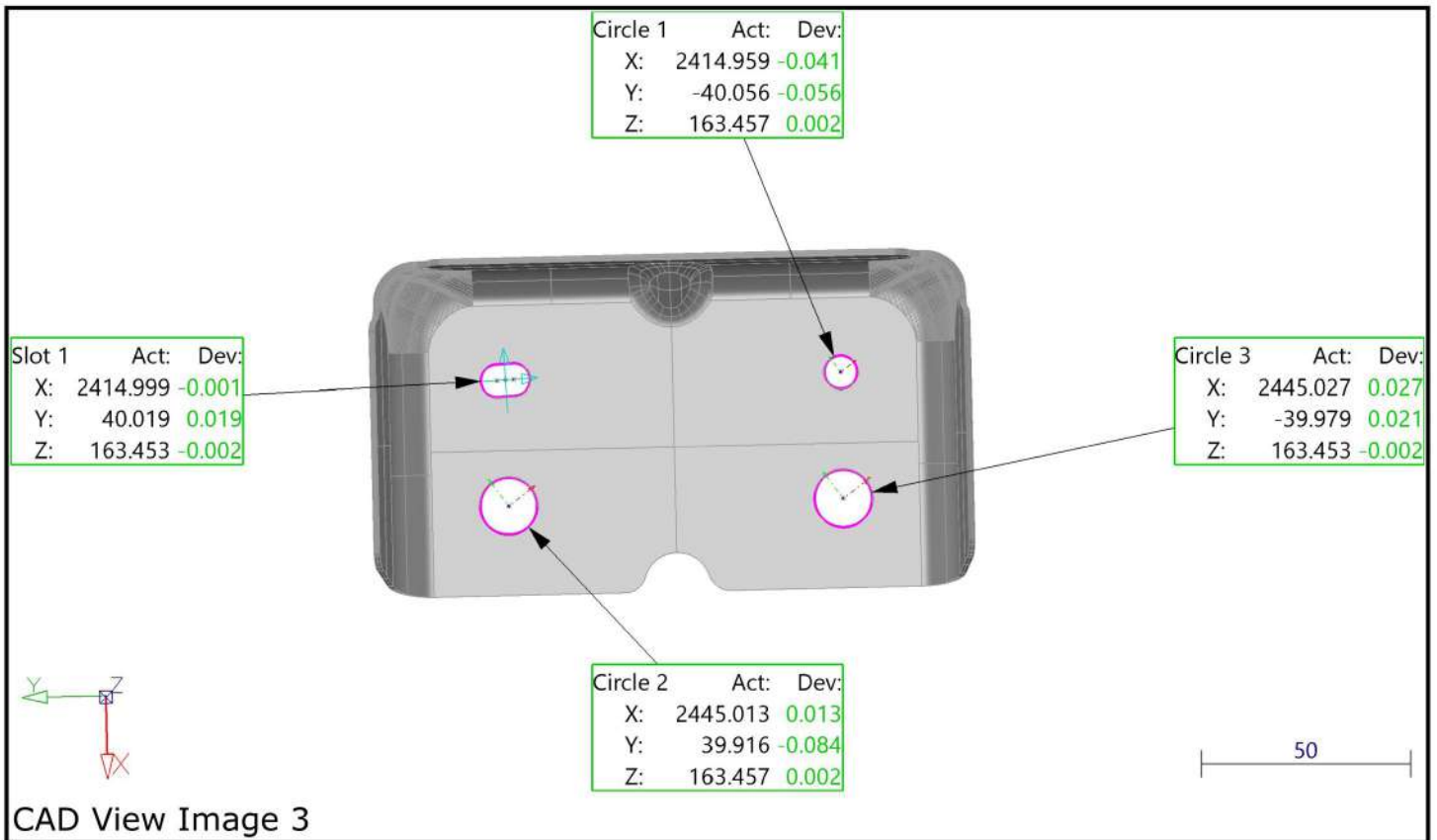
CMM INSPECTION REPORT

Unique Measurement Service
No-5/80, Shop no-03,
Ground Floor, Mogappair
Road,
Mannurpet, Padi, Chennai-600 050

Phone: 044-45050301

Cell: 099652 51951

Description:	0101BB204560N_019	Date:	21-09-2023
Part No:		Inspected By:	AKASH VENKATESAN
Comp No:	01		



CAD View Image 3

Geometric Group 1

Slot 1

		Nominal	Measured	Hi-Tol	Lo-Tol	Deviation	Error
Centre	X	2415.000	2414.999	0.100	-0.100	-0.001	-
	Y	40.000	40.019	0.100	-0.100	0.019	-
	Z	163.455	163.453	0.100	-0.100	-0.002	-

Number of probed points: 6

Circle 1

		Nominal	Measured	Hi-Tol	Lo-Tol	Deviation	Error
Centre	X	2415.000	2414.959	0.100	-0.100	-0.041	-
	Y	-40.000	-40.056	0.100	-0.100	-0.056	-
	Z	163.455	163.457	0.100	-0.100	0.002	-

Number of probed points: 4

Geometric Group 1

Circle 2

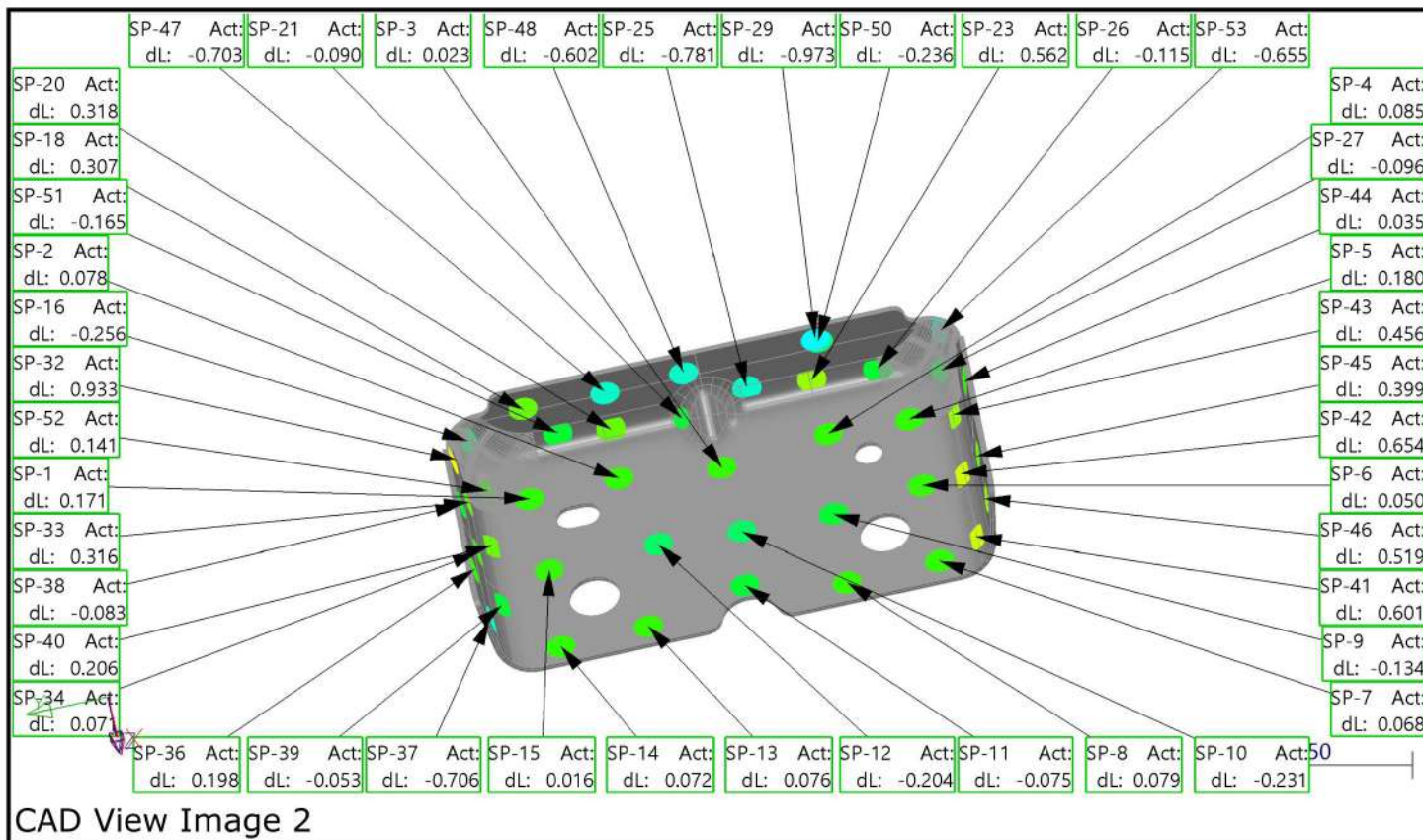
		Nominal	Measured	Hi-Tol	Lo-Tol	Deviation	Error
Centre	X	2445.000	2445.013	0.100	-0.100	0.013	-
	Y	40.000	39.916	0.100	-0.100	-0.084	-
	Z	163.455	163.457	0.100	-0.100	0.002	-

Number of probed points: 4

Circle 3

		Nominal	Measured	Hi-Tol	Lo-Tol	Deviation	Error
Centre	X	2445.000	2445.027	0.100	-0.100	0.027	-
	Y	-40.000	-39.979	0.100	-0.100	0.021	-
	Z	163.455	163.453	0.100	-0.100	-0.002	-

Number of probed points: 4

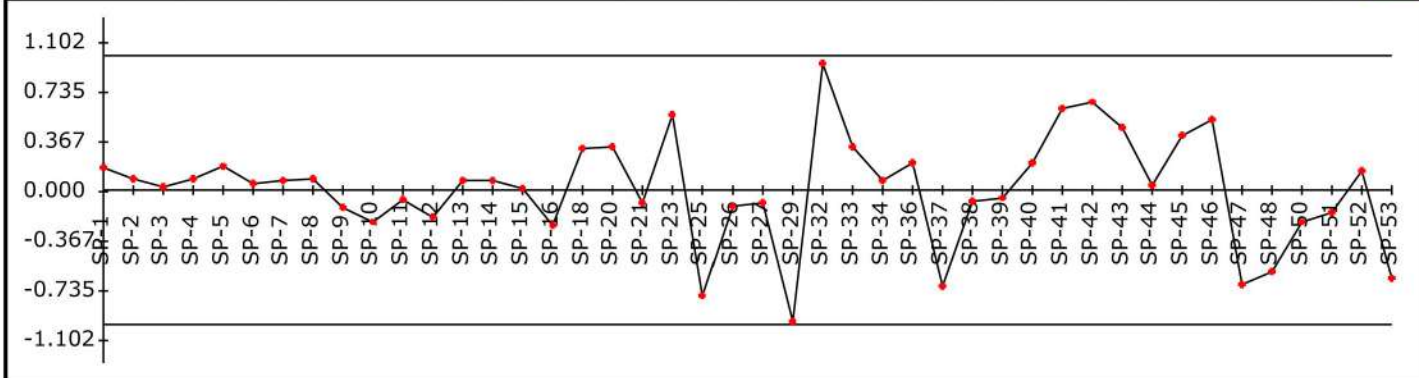


SURFACE

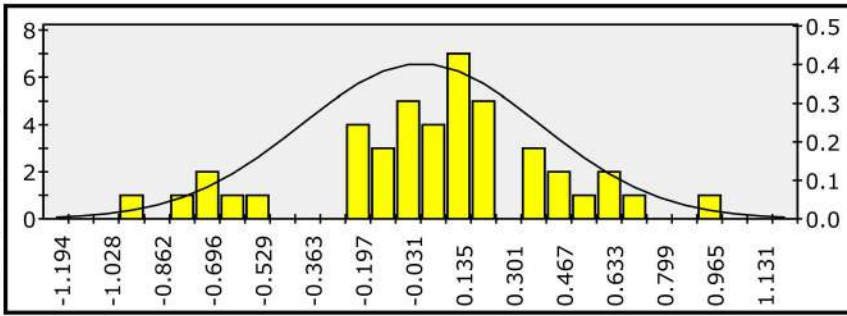
Name	Nominal			Measured			TOL.		Deviation			To.Dev
	X	Y	Z	X	Y	Z	-Tol	+Tol	dX	dY	dZ	DL
SP-1	2405.275	51.842	163.455	2405.275	51.842	163.284	-1.000	1.000	0.000	0.000	-0.171	0.171
SP-2	2404.767	27.117	163.455	2404.767	27.117	163.377	-1.000	1.000	0.000	0.000	-0.078	0.078
SP-3	2408.961	-0.515	163.455	2408.961	-0.515	163.432	-1.000	1.000	0.000	0.000	-0.023	0.023
SP-4	2405.084	-30.379	163.455	2405.084	-30.379	163.370	-1.000	1.000	0.000	0.000	-0.085	0.085
SP-5	2406.266	-52.657	163.455	2406.266	-52.657	163.275	-1.000	1.000	0.000	0.000	-0.180	0.180
SP-6	2430.999	-52.487	163.455	2430.999	-52.487	163.405	-1.000	1.000	0.000	0.000	-0.050	0.050
SP-7	2459.352	-52.913	163.455	2459.352	-52.913	163.387	-1.000	1.000	0.000	0.000	-0.068	0.068
SP-8	2459.839	-27.305	163.455	2459.839	-27.305	163.376	-1.000	1.000	0.000	0.000	-0.079	0.079
SP-9	2434.248	-27.413	163.455	2434.248	-27.413	163.589	-1.000	1.000	0.000	0.000	0.134	-0.134
SP-10	2433.298	-2.309	163.455	2433.298	-2.309	163.686	-1.000	1.000	0.000	0.000	0.231	-0.231
SP-11	2452.796	-0.235	163.455	2452.796	-0.235	163.530	-1.000	1.000	0.000	0.000	0.075	-0.075
SP-12	2431.413	20.330	163.455	2431.413	20.330	163.659	-1.000	1.000	0.000	0.000	0.204	-0.204
SP-13	2460.008	27.357	163.455	2460.008	27.357	163.379	-1.000	1.000	0.000	0.000	-0.076	0.076
SP-14	2460.527	51.573	163.455	2460.527	51.573	163.383	-1.000	1.000	0.000	0.000	-0.072	0.072
SP-15	2432.164	50.459	163.455	2432.164	50.459	163.439	-1.000	1.000	0.000	0.000	-0.016	0.016
SP-16	2390.277	64.771	151.918	2390.080	64.915	151.996	-1.000	1.000	-0.197	0.144	0.078	-0.256
SP-18	2387.822	48.443	146.756	2388.127	48.443	146.729	-1.000	1.000	0.305	-0.000	-0.027	0.307
SP-20	2389.961	26.527	159.554	2390.227	26.527	159.381	-1.000	1.000	0.266	0.000	-0.174	0.318
SP-21	2391.203	7.225	160.190	2391.143	7.187	160.246	-1.000	1.000	-0.060	-0.038	0.056	-0.090
SP-23	2389.160	-29.089	158.001	2389.683	-29.089	157.796	-1.000	1.000	0.523	0.000	-0.206	0.562
SP-25	2388.734	-11.482	156.560	2387.969	-11.482	156.715	-1.000	1.000	-0.765	0.000	0.155	-0.781
SP-26	2389.642	-47.062	159.025	2389.541	-47.062	159.081	-1.000	1.000	-0.101	0.000	0.056	-0.115
SP-27	2394.978	-63.735	159.227	2394.937	-63.793	159.291	-1.000	1.000	-0.041	-0.059	0.064	-0.096
SP-29	2387.650	-32.476	144.787	2386.680	-32.476	144.872	-1.000	1.000	-0.970	0.000	0.085	-0.973
SP-32	2403.551	69.759	143.935	2403.551	68.841	143.773	-1.000	1.000	0.000	-0.919	-0.162	0.933

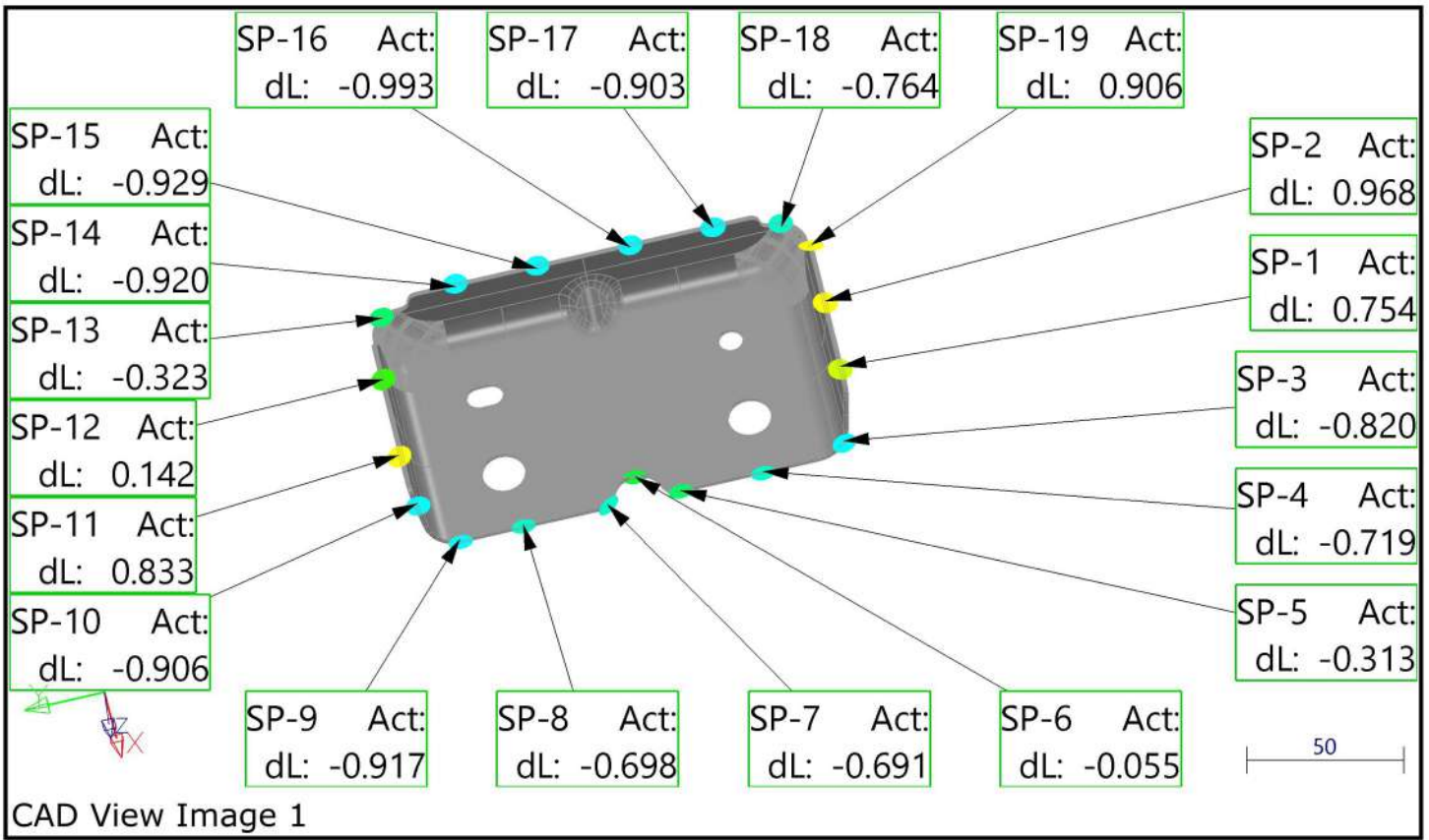
SURFACE

Name	Nominal			Measured			TOL.		Deviation			To.Dev
	X	Y	Z	X	Y	Z	-Tol	+Tol	dX	dY	dZ	DL
SP-33	2411.106	68.098	153.359	2411.106	67.787	153.304	-1.000	1.000	0.000	-0.311	-0.055	0.316
SP-34	2430.210	68.211	152.715	2430.210	68.142	152.702	-1.000	1.000	0.000	-0.070	-0.012	0.071
SP-36	2445.168	69.962	142.785	2445.168	69.768	142.750	-1.000	1.000	0.000	-0.195	-0.034	0.198
SP-37	2455.052	68.196	152.799	2455.052	68.892	152.922	-1.000	1.000	0.000	0.695	0.123	-0.706
SP-38	2420.784	69.895	143.167	2420.784	69.977	143.181	-1.000	1.000	0.000	0.082	0.014	-0.083
SP-39	2443.401	64.845	160.843	2443.401	64.881	160.882	-1.000	1.000	0.000	0.037	0.039	-0.053
SP-40	2421.271	64.546	161.113	2421.271	64.411	160.957	-1.000	1.000	-0.000	-0.135	-0.156	0.206
SP-41	2455.976	-64.320	161.302	2455.976	-63.940	160.836	-1.000	1.000	0.000	0.379	-0.466	0.601
SP-42	2431.929	-63.809	161.690	2431.929	-63.431	161.157	-1.000	1.000	0.000	0.378	-0.534	0.654
SP-43	2410.817	-64.914	160.777	2410.817	-64.598	160.448	-1.000	1.000	0.000	0.316	-0.329	0.456
SP-44	2414.209	-69.595	144.867	2414.209	-69.560	144.861	-1.000	1.000	0.000	0.035	-0.006	0.035
SP-45	2439.086	-69.033	148.056	2439.086	-68.640	147.987	-1.000	1.000	-0.000	0.393	-0.069	0.399
SP-46	2454.614	-68.963	148.455	2454.614	-68.451	148.364	-1.000	1.000	-0.000	0.512	-0.090	0.519
SP-47	2387.886	26.007	147.485	2387.185	26.007	147.546	-1.000	1.000	-0.700	0.000	0.061	-0.703
SP-48	2387.800	4.091	146.510	2387.201	4.091	146.563	-1.000	1.000	-0.600	0.000	0.052	-0.602
SP-50	2387.716	-33.123	145.547	2387.481	-33.123	145.568	-1.000	1.000	-0.235	0.000	0.021	-0.236
SP-51	2389.065	40.752	157.749	2388.909	40.752	157.804	-1.000	1.000	-0.156	0.000	0.056	-0.165
SP-52	2400.430	62.604	161.995	2400.451	62.538	161.872	-1.000	1.000	0.021	-0.066	-0.123	0.141
SP-53	2390.043	-65.618	149.364	2389.545	-66.016	149.515	-1.000	1.000	-0.498	-0.398	0.150	-0.655



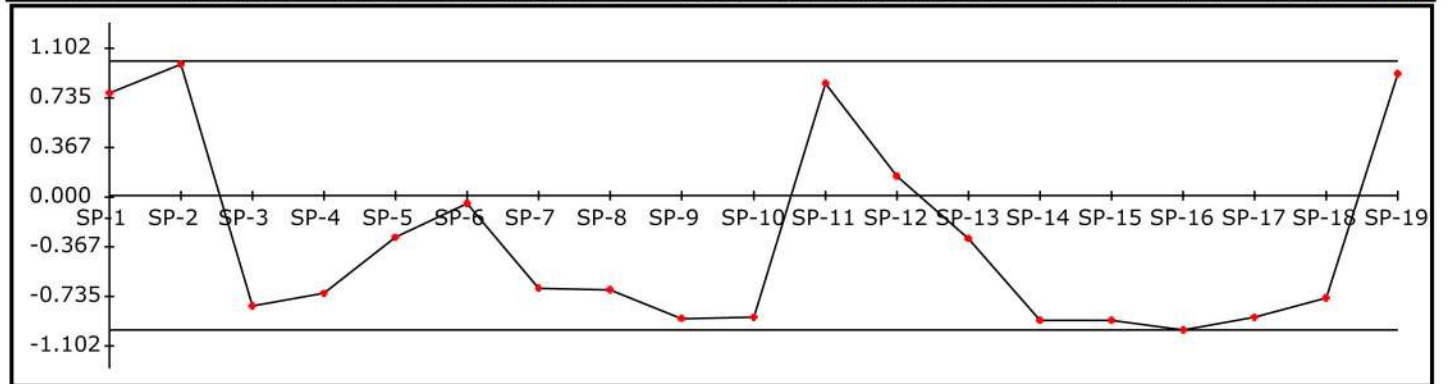
Number of points	44
Out of tolerance	
Performance	100%
Mean	0.010
Std. Deviation	0.396
Max. Value	0.933
Min. Value	-0.973





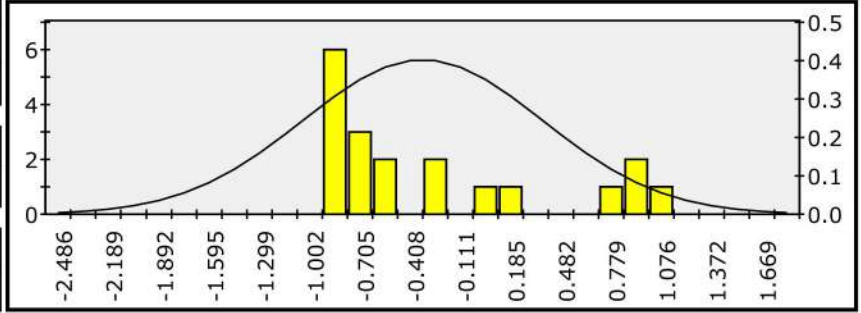
TRIM

Name	Nominal			Measured			TOL.		Deviation			To.Dev
	X	Y	Z	X	Y	Z	-Tol	+Tol	dX	dY	dZ	DL
SP-1	2450.355	-71.014	139.195	2450.355	-71.145	138.452	-1.000	1.000	0.000	-0.131	-0.743	0.754
SP-2	2424.454	-71.281	140.257	2424.454	-71.449	139.304	-1.000	1.000	0.000	-0.168	-0.953	0.968
SP-3	2464.663	-67.110	160.341	2463.869	-66.991	160.506	-1.000	1.000	-0.794	0.119	0.165	-0.820
SP-4	2466.391	-39.915	164.515	2465.672	-39.915	164.515	-1.000	1.000	-0.719	0.000	0.000	-0.719
SP-5	2466.391	-13.318	164.208	2466.078	-13.318	164.208	-1.000	1.000	-0.313	0.000	0.000	-0.313
SP-6	2457.005	-0.289	164.622	2456.950	-0.291	164.622	-1.000	1.000	-0.055	-0.002	0.000	-0.055
SP-7	2465.776	10.086	163.866	2465.170	10.418	163.866	-1.000	1.000	-0.606	0.332	0.000	-0.691
SP-8	2466.391	37.920	163.789	2465.693	37.920	163.789	-1.000	1.000	-0.698	0.000	0.000	-0.698
SP-9	2466.089	58.575	164.565	2465.172	58.566	164.565	-1.000	1.000	-0.917	-0.009	0.000	-0.917
SP-10	2460.439	69.503	147.195	2459.571	69.477	147.454	-1.000	1.000	-0.868	-0.026	0.259	-0.906
SP-11	2445.355	71.720	140.335	2445.355	71.865	139.514	-1.000	1.000	0.000	0.145	-0.821	0.833
SP-12	2415.529	70.823	140.176	2415.529	70.848	140.037	-1.000	1.000	0.000	0.025	-0.140	0.142
SP-13	2388.442	66.541	146.226	2388.490	66.512	146.543	-1.000	1.000	0.048	-0.030	0.318	-0.323
SP-14	2386.144	41.332	140.828	2386.224	41.332	141.745	-1.000	1.000	0.080	0.000	0.917	-0.920
SP-15	2386.391	14.691	140.907	2386.472	14.691	141.832	-1.000	1.000	0.081	0.000	0.925	-0.929
SP-16	2386.649	-15.620	140.382	2386.736	-15.620	141.371	-1.000	1.000	0.087	0.000	0.989	-0.993
SP-17	2386.924	-42.468	139.555	2387.002	-42.468	140.454	-1.000	1.000	0.079	0.000	0.899	-0.903
SP-18	2387.517	-63.764	147.216	2387.623	-63.744	147.972	-1.000	1.000	0.106	0.020	0.756	-0.764
SP-19	2402.105	-71.157	141.300	2401.630	-71.291	140.541	-1.000	1.000	-0.475	-0.134	-0.759	0.906



TRIM

Number of points	19
Out of tolerance	
Performance	100%
Mean	-0.334
Std. Deviation	0.708
Max. Value	0.968
Min. Value	-0.993



Notes

Unique Measurement Service