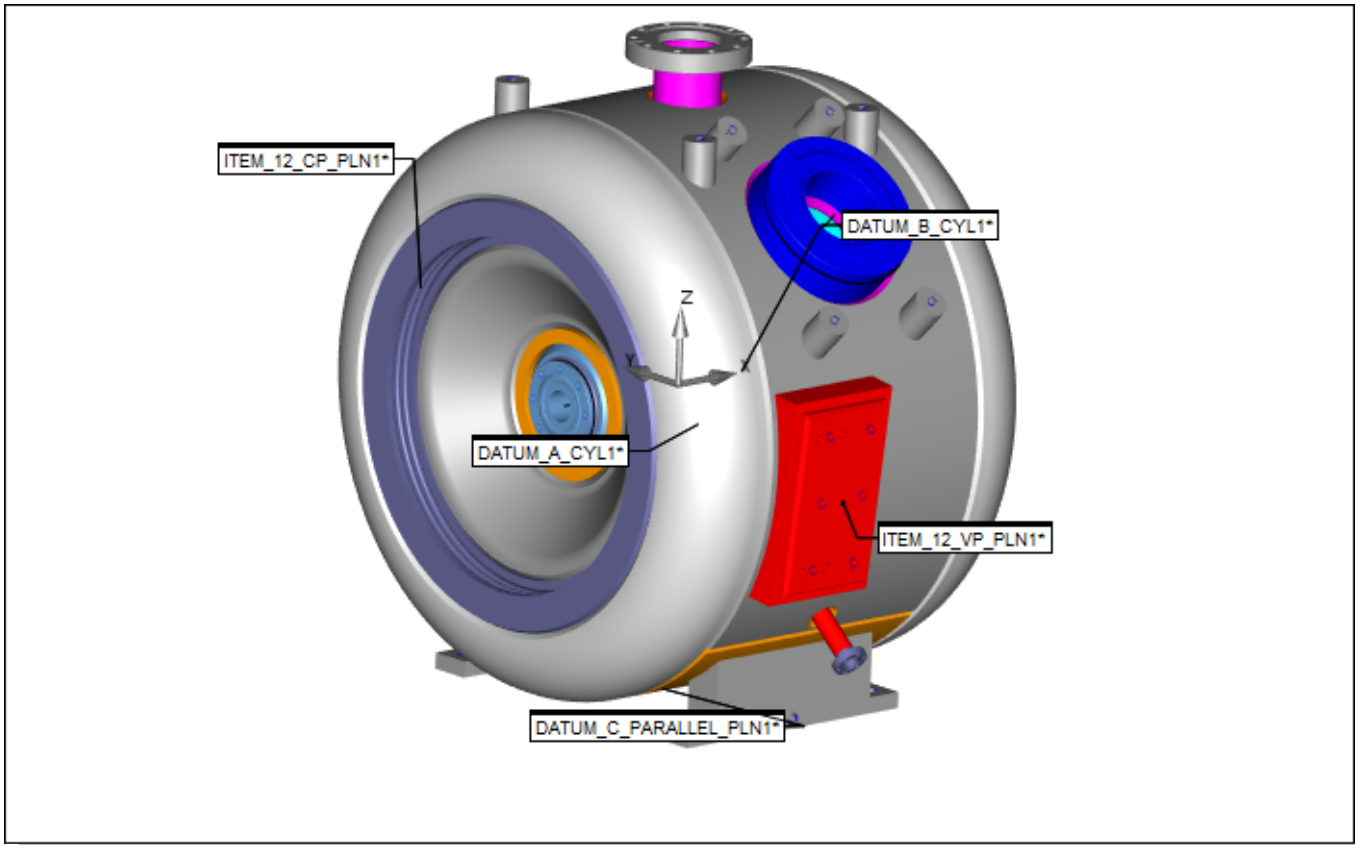
pc-dmis	PART NAME : F00494433_A_S1H-NR-114		December 07, 2015	13:49
	REV NUMBER :	SER NUMBER :	STATS COUNT :	1

PROJECT X SSR1
TUNER SUPPORT
SERIAL NUMBER= S1H-NR-114 TYPE "B"

RF#98912 SAMPLE#1
INSPECTOR: O. LIRA



********** TABLE 1 DIMENSIONS **********

****

⌖	MM	1 - DAT_A_BS_CIR1
AX	NOMINAL	MEAS
Y	0.00	0.00
Z	0.00	0.00
D	85.60	85.56
RN	0.00	0.03

⌖	MM	2 - DAT_A_RS_CIR2
AX	NOMINAL	MEAS
Y	0.00	0.00
Z	0.00	0.00
D	85.60	85.51
RN	0.00	0.01

********** TABLE 2 DIMENSIONS **********

****

⌖	MM	3 - DAT_B_CP_CIR1
AX	NOMINAL	MEAS
PA	-135.00	-134.96
D	151.64	151.54

⌖	MM	4 - DAT_B_VP_CIR1
AX	NOMINAL	MEAS
PA	45.00	44.97
D	151.64	151.49

****

⌖	MM	8 - TBB_PNT1
AX	NOMINAL	MEAS
X	-146.00	-146.61

⌖	MM	9 - RBB_PNT2
AX	NOMINAL	MEAS
X	-146.00	-146.62

⌖	MM	10 - DBB_PNT3
AX	NOMINAL	MEAS
X	-146.00	-146.59

⌖	MM	11 - LBB_PNT4
AX	NOMINAL	MEAS
X	-146.00	-146.57

⊥	MM	PERP1 - DAT_A_BS_FLANGE_PLN1 TO DATUM_A_CYL1
AX	NOMINAL	MEAS
M	0.00	0.05

▱	MM	FLAT1 - DAT_A_BS_FLANGE_PLN1
AX	NOMINAL	MEAS
M	0.00	0.00

∠	DEG	ANGL1 - BS_TAP_HOLE_LIN1 TO DATUM_C_PARALLEL_PLN1
AX	NOMINAL	MEAS
A	90.00	90.44

****

	MM	12 - TBR_PNT1
AX	NOMINAL	MEAS
X	146.00	144.43

	MM	13 - RBR_PNT4
AX	NOMINAL	MEAS
X	146.00	144.41

	MM	14 - DBR_PNT3
AX	NOMINAL	MEAS
X	146.00	144.47

	MM	15 - LBR_PNT2
AX	NOMINAL	MEAS
X	146.00	144.48

	MM	PERP2 - DAT_A_RS_FLANGE_PLN1 TO DATUM_A_CYL1
AX	NOMINAL	MEAS
M	0.00	0.07

	MM	FLAT2 - DAT_A_RS_FLANGE_PLN1
AX	NOMINAL	MEAS
M	0.00	0.00

	MM	PARL2 - DAT_A_RS_FLANGE_PLN1 TO DAT_A_BS_FLANGE_PLN1
AX	NOMINAL	MEAS
M	0.00	0.12

	DEG	ANGL2 - RS_TAP_HOLE_LIN1 TO DATUM_C_PARALLEL_PLN1
AX	NOMINAL	MEAS
A	90.00	89.81

	MM	31 - DAT_A_RS_CIR2				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Y	0.00	0.15			0.15	
Z	0.00	0.19			0.19	
DF	85.60	85.51	0.50	0.50	-0.09	0.00
RN	0.00	0.01	0.50	0.00	0.01	0.00
TP	RFS	0.48	0.50		0.48	0.00

****

⊥	MM	PERP3 - DAT_B_FLANGE_CP_PLN1 TO DATUM_B_CYL1
AX	NOMINAL	MEAS
M	0.00	1.60

▱	MM	FLAT3 - DAT_B_FLANGE_CP_PLN1
AX	NOMINAL	MEAS
M	0.00	0.29

⌖	MM	16 - TC_PNT2
AX	NOMINAL	MEAS
Z	307.23	295.70

⌖	MM	17 - DC_PNT4
AX	NOMINAL	MEAS
Z	307.23	295.09

⌖	MM	18 - BC_PNT3
AX	NOMINAL	MEAS
Z	307.23	295.63

⌖	MM	19 - RC_PNT1
AX	NOMINAL	MEAS
Z	307.23	295.23

****

⊥	MM	PERP4 - DAT_B_FLANGE_VP_PLN1 TO DATUM_B_CYL1
AX	NOMINAL	MEAS
M	0.00	0.80

▱	MM	FLAT4 - DAT_B_FLANGE_VP_PLN1
AX	NOMINAL	MEAS
M	0.00	0.33

//	MM	PARL1 - DAT_B_FLANGE_VP_PLN1 TO DAT_B_FLANGE_CP_PLN1
AX	NOMINAL	MEAS
M	0.00	1.12

⌖	MM	20 - TV_PNT2
AX	NOMINAL	MEAS
Z	307.23	295.91

⌖	MM	21 - DV_PNT4
AX	NOMINAL	MEAS
Z	307.23	296.60

⌖	MM	22 - BV_PNT3
AX	NOMINAL	MEAS
Z	307.23	296.60

⌖	MM	23 - RV_PNT1
AX	NOMINAL	MEAS
Z	307.23	296.57

	MM	25 - LL3_PNT1
AX	NOMINAL	MEAS
Z	277.10	277.27

	MM	26 - LL4_PNT1
AX	NOMINAL	MEAS
Z	277.10	277.10

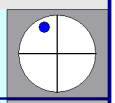
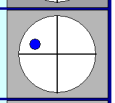
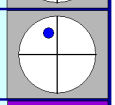
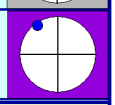
	MM	27 - LL1_PNT1
AX	NOMINAL	MEAS
Z	277.10	277.26

	MM	28 - LL2_PNT1
AX	NOMINAL	MEAS
Z	277.10	277.15

	DEG	ANGL3 - LL1_THRU_LL4_PLN1 TO DATUM_B_CYL1
AX	NOMINAL	MEAS
A	-45.00	-44.97

	MM	PROF1 - LL1_THRU_LL4_PLN1 FORMANDLOCATION
AX	NOMINAL	MEAS
M	0.00	0.17

FCFLOC1 Position	MM	Ø0.5 A BB

Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
LL3_CIR1	0.00	0.38	0.50		0.38	0.00	
LL4_CIR1	0.00	0.31	0.50		0.31	0.00	
LL1_CIR1	0.00	0.31	0.50		0.31	0.00	
LL2_CIR1	0.00	0.46	0.50		0.46	0.00	

FCFLOC1 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON

Feature	AX	NOMINAL	MEAS	DEV
LL3_CIR1	X	-100.00	-100.09	-0.09
	Y	-130.00	-129.83	0.17
LL4_CIR1	X	-100.00	-100.14	-0.14
	Y	130.00	130.06	0.06
LL1_CIR1	X	100.00	99.94	-0.06
	Y	-130.00	-129.86	0.14
LL2_CIR1	X	100.00	99.87	-0.13
	Y	130.00	130.19	0.19

****

⌖	MM	136 - LL7_PNT1
AX	NOMINAL	MEAS
Z	289.00	289.34

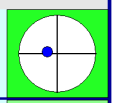
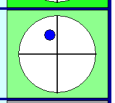
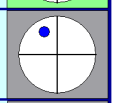
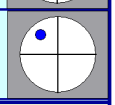
⌖	MM	137 - LL8_PNT1
AX	NOMINAL	MEAS
Z	288.62	289.21

⌖	MM	138 - LL5_PNT1
AX	NOMINAL	MEAS
Z	289.00	289.33

⌖	MM	139 - LL6_PNT1
AX	NOMINAL	MEAS
Z	289.00	289.20

∠	DEG	ANGL4 - LL5_THRU_LL8_PLN1 TO ZAXIS
AX	NOMINAL	MEAS
A	90.00	89.96

⌓	MM	PROF2 - LL5_THRU_LL8_PLN1 FORMANDLOCATION		
AX	NOMINAL	MEAS	MAX	MIN
M	0.00	0.34	0.34	0.20

FCFLOC2 Position	MM	⌖ Ø0.5 A B					
Feature	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL	
LL7_CIR1	0.00	0.13	0.50		0.13	0.00	
LL8_CIR1	0.00	0.26	0.50		0.26	0.00	
LL5_CIR1	0.00	0.34	0.50		0.34	0.00	
LL6_CIR1	0.00	0.34	0.50		0.34	0.00	

FCFLOC2 Summary FIT TO DATUMS=ON, DEV PERPEN CENTERLINE=ON

Feature	AX	NOMINAL	MEAS	DEV
LL7_CIR1	X	-60.00	-60.06	-0.06
	Z	-105.00	-104.99	0.01
LL8_CIR1	X	-60.00	-60.05	-0.05
	Z	105.00	105.12	0.12
LL5_CIR1	X	60.00	59.91	-0.09
	Z	-105.00	-104.85	0.15
LL6_CIR1	X	60.00	59.89	-0.11
	Z	105.00	105.13	0.13

****

	MM	30 - ITEM_12_CP_PLN1
AX	NOMINAL	MEAS
Y	295.00	295.28
FL	0.00	0.02

	DEG	ANGL5 - ITEM_12_CP_PLN1 TO ZAXIS
AX	NOMINAL	MEAS
A	37.50	37.52

	MM	PROF3 - ITEM_12_CP_PLN1 FORMANDLOCATION		
AX	NOMINAL	MEAS	MAX	MIN
M	0.00	1.45	-1.37	-1.45

	MM	34 - ITEM_12_ZP_CP_LIN1
AX	NOMINAL	MEAS
Z	90.00	89.88

	MM	35 - ITEM_12_ZM_CP_LIN1
AX	NOMINAL	MEAS
Z	-90.00	-90.05

	MM	DIST3 - ITEM_12_XM_CP_LIN1 TO ITEM_12_XP_CP_LIN1 (XAXIS)
AX	NOMINAL	MEAS
M	100.00	99.97

	MM	DIST4 - HIGH_POINT_MINUS_X TO ITEM_12_XM_CP_LIN1 (XAXIS)
AX	NOMINAL	MEAS
M	100.00	99.50

****

	MM	41 - ITEM_12_VP_PLN1
AX	NOMINAL	MEAS
Y	-295.00	-295.13
FL	0.00	0.02

	DEG	ANGL6 - ITEM_12_VP_PLN1 TO ZAXIS
AX	NOMINAL	MEAS
A	37.50	37.52

	MM	PROF4_S7 - ITEM_12_VP_PLN1 FORMANDLOCATION				
AX	NOMINAL	MEAS	+TOL	-TOL	MAX	MIN
M	0.00	1.86	0.25	0.25	1.86	1.78

	MM	DIST14 - ITEM_12_CP_PLN1 TO ITEM_12_VP_PLN1 (YAXIS)
AX	NOMINAL	MEAS
M	590.00	590.41

	MM	42 - ITEM_12_ZP_VP_LIN1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Z	90.00	90.10	0.00	0.10	0.10	0.10

	MM	43 - ITEM_12_ZM_VP_LIN1				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
Z	-90.00	-89.86	0.10	0.00	0.14	0.04

	MM	DIST9 - ITEM_12_XM_VP_LIN1 TO ITEM_12_XP_VP_LIN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	100.00	99.94	0.00	0.10	-0.06	0.00

	MM	DIST10 - HIGH_POINT_MINUS_X TO ITEM_12_XM_VP_LIN1 (XAXIS)				
AX	NOMINAL	MEAS	+TOL	-TOL	DEV	OUTTOL
M	100.00	99.60	0.50	0.50	-0.40	0.00

********** TABLE 11 DIMENSIONS **********

****

⌖	MM	44 - DATUM_C_PARALLEL_PLN1		
AX	NOMINAL	MEAS	MAX	MIN
Z	-290.40	-290.48	-290.17	-290.78

∡	DEG	ANGL7 - DATUM_C_PARALLEL_PLN1 TO DATUM_B_CYL1	
AX	NOMINAL	MEAS	
A	-45.00	-44.97	

↔	MM	DIST15 - SUPPORT_INN_LIN1 TO SUPPORT_INN_LIN2 (YAXIS)		
AX	NOMINAL	MEAS	MAX	MIN
M	270.00	268.64	269.30	267.97

↔	MM	DIST15 - SUPPORT_OUT_LIN1 TO SUPPORT_OUT_LIN2 (YAXIS)		
AX	NOMINAL	MEAS	MAX	MIN
M	350.00	349.22	349.82	348.61

********** TABLE 12 -GENERAL DIMENSIONS- **********

****

↔	MM	DIST17_R1 - BS_PLN1 TO RS_PLN1 (XAXIS)
AX	NOMINAL	MEAS
M	420.00	418.74

↔	MM	DIST18_R2 - RS_PLN1 TO DATUM_B_CYL1 (XAXIS)
AX	NOMINAL	MEAS
M	210.00	209.55

↔	MM	DIST19_R3 - BS_PLN1 TO DATUM_B_CYL1 (XAXIS)
AX	NOMINAL	MEAS
M	210.00	209.19

⌖	MM	47 - ITEM_16_PLN1
AX	NOMINAL	MEAS
PR	330.00	324.37

AX	I	J	K
V	-0.03	-0.76	-0.65

∡	DEG	ANGL8 - LIN7 TO LIN8
AX	NOMINAL	MEAS
A	85.00	84.93

↔	MM	DIST17_U1 - ITEM_15_TF_P_PLN1 TO DATUM_C_PARALLEL_PLN1 (ZAXIS)
AX	NOMINAL	MEAS
M	620.40	619.34

⌖	MM	12A - BS_PLN1
AX	NOMINAL	MEAS
X	-210.00	-209.19

⌖	MM	12B - ITEM_15_TF_P_CIR1
AX	NOMINAL	MEAS
Y	0.00	2.39
D	117.47	117.18

FCFPARL1_12C	MM	// 0.2 C
Feature	NOMINAL	MEAS
ITEM_15_TF_P_PLN1	0.00	1.37

********** TABLE 13 -THREADED HOLES- **********

****

ARE TAPPED HOLES OK?

IF NOT PLEASE LIST THE ONES THERE NOT

: YES