

MADE TO MEASURE INSPECTION REPORT

Customer :

Valued Customer

123 Measure Dr., Precision IL 60245

Part Number:
123456

Revision:
MM

Part Name:
HOUSING

Quantity :
3

Date :
9/1/2020

Report Number :
12345-6

We trust that these results meet your satisfaction, please call should you require additional information or clarification.

This is to certify that the inspection procedure performed on the item noted above was completed in compliance with ISO/IEC 17025:2017, and in accordance with the drawings, specifications and other applicable documents as supplied.

The uncertainty of measurement associated with the measurement result reported in this certificate is available from the organization upon request.

All measurements were performed under environmental control, at a stable atmosphere of 20°C ±2° and a relative humidity less than 50%.

All equipment used for this inspection procedure is in calibration and traceable to SI Units through NIST.

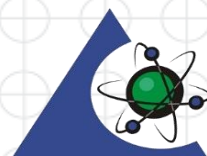
GD&T understanding is according to ASME Y14.5-2018 unless otherwise specified.



302 E. Main St., East Dundee, IL 60118
(847) 851-1160

www.measure911.com

Managing Director : **Sven Bley**



PJLA
Testing

Accreditation# 59334

Reviewed By :

precision  delivered



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Customer:

Valued Customer

Part Number : 123456	Revision :	Inspector : Mark Precise
	MM	Title : Metrologist
Part Name : HOUSING	Units of measure:	Signature :
	mm	Date: 9/1/2020

INSPECTION REPORT #12345-6

ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
1	9.5	0.2	0.2	9.44		9.37		9.34		CMM-5		
2	2.5	0.2	0.2	2.44		2.43		2.44		CMM-5		
3	2.0	0.2	0.2	1.95		1.94		1.95		CMM-5		
4	65.96			65.93		65.88		65.86		CMM-5		
5	55.17			55.16		55.16		55.16		CMM-5		Ø3.80
				55.15		55.15		55.15		CMM-5		R5.00
6	3.58			3.51		3.52		3.51		CMM-5		Ø3.80
				3.56		3.63		3.56		CMM-5		R4.50
7	Ø3.20	0.10	0.10	3.26		3.26		3.26		GP		
8	⊥ 0.1 A			0.01		0.00		0.00		CMM-5		
9	R3.5	0.1	0.1	3.51		3.47		3.56		CMM-5		
10	⊕ 0.2 A B C			0.03		0.05		0.14		CMM-5		
	0.00			0.01		-0.03		0.07		CMM-5		
	0.00			0.00		0.00		0.02		CMM-5		
11	11.74			11.74		11.74		11.74		CMM-5		Ø3.80
				11.74		11.72		11.74		CMM-5		R4.50
12	R4.5	0.1	0.1	4.49		4.55		4.49		CMM-5		
	MMC BONUS			0.09		0.15		0.09				
13	⊕ 0.2 M A B C			0.03		0.10		0.04		CMM-5		
	3.58			3.56		3.63		3.56		CMM-5		

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ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
	11.74			11.74		11.72		11.74		CMM-5		
14	4.2	0.1	0.1	4.24		4.24		4.24		CMM-5		
15	R4.3	0.1	0.1	4.20		4.24		4.26		CMM-5		
	MMC BONUS			0.00		0.04		0.06				
16	\varnothing 0.2 (M) A B C			0.10		0.19		0.23		CMM-5		MMC APPLIED
	65.96			65.93		65.88		65.86		CMM-5		
	0.00			-0.04		-0.05		-0.05		CMM-5		
17	3.20	0.10	0.10	3.28		3.28		3.28		GP		
	MMC BONUS			0.17		0.18		0.19				
18	\varnothing 0.1 (M) A B			0.02		0.01		0.01		CMM-5		
	0.00			-0.01		-0.01		0.00		CMM-5		
19	36.32			36.28		36.31		36.32		CMM-5		Ø3.80
				36.26		36.29		36.29		CMM-5		R5.00
20	R5.0	0.1	0.1	4.95		4.96		4.96		CMM-5		
	MMC BONUS			0.05		0.06		0.06				
21	\varnothing 0.4 (M) A B C			0.13		0.08		0.07		CMM-5		
	55.17			55.15		55.15		55.15		CMM-5		
	36.32			36.26		36.29		36.29		CMM-5		
22	2x 3.80	0.10	0.10	3.86		3.86		3.86		GP		A
	MMC BONUS			0.20		0.20		0.20				
23	\varnothing 0.20 (M) A B C			0.09		0.03		0.02		CMM-5		
	55.17			55.16		55.16		55.16		CMM-5		
	36.32			36.28		36.31		36.32		CMM-5		
	3.80	0.10	0.10	3.86		3.86		3.86		GP		B
	MMC BONUS			0.20		0.00		0.20				
	\varnothing 0.20 (M) A B C			0.13		0.12		0.13		CMM-5		
	3.58			3.51		3.52		3.51		CMM-5		
	11.74			11.74		11.74		11.74		CMM-5		

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ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
24	2.0	0.1	0.1	1.95		1.96		1.95		CMM-5		
25	22.5	0.2	0.2	22.45		22.44		22.44		CMM-5		
26	39.4	0.3	0.3	39.23		39.24		39.23		CMM-5		
27	28.7	0.2	0.2	28.73		28.73		28.73		CMM-5		
28	31.1°	0.5°	0.5°	31.05		31.05		31.07		CMM-5		
29	2x Ø3.00	0.2	0.2	3.24	0.04	3.26	0.06	3.17		GP		
	MMC BONUS			0.37		0.40		0.37				
30	$\text{Ø} 0.5 \text{ (M) A B C}$			0.14		0.20		0.33		CMM-5		
	32.50			32.47		32.43		32.41		CMM-5		
	37.50			37.44		37.42		37.36		CMM-5		
	Ø3.00	0.2	0.2									1 PLACE ONLY
	MMC BONUS											
	$\text{Ø} 0.5 \text{ (M) A B C}$											
31	32.5			32.47		32.43		32.41		CMM-5		
32	37.5			37.44		37.42		37.36		CMM-5		
33	10.5			10.43		10.43		10.43		CMM-5		
34	Ø3.3	0.2	0.2	3.40		3.40		3.40		GP		
	MMC BONUS			0.40		0.40		0.40				
35	$\text{Ø} 0.5 \text{ (M) A B C}$			0.15		0.14		0.16		CMM-5		
	27.90			27.87		27.88		27.87		CMM-5		
	10.50			10.43		10.43		10.43		CMM-5		
36	27.9			27.87		27.88		27.87		CMM-5		
37	90.0°			90.05		90.05		90.04		CMM-5		
38	$\text{Ø} 0.30 \text{ A B C}$			0.20		0.61	0.31	0.78	0.48	CMM-5		PNT1
B	40.58			40.50		40.35		40.29		CMM-5		
C	-3.29			-3.27		-3.26		-3.25		CMM-5		

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ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
A	-10.96			-11.02		-11.16		-11.22		CMM-5		
	⊕ 0.30 A B C			0.24		0.04		0.43	0.13	CMM-5		PNT2
B	38.40			38.32		38.39		38.25		CMM-5		
C	-50.29			-50.28		-50.29		-50.27		CMM-5		
A	-12.64			-12.72		-12.66		-12.79		CMM-5		
	⊕ 0.30 A B C			0.33	0.03	0.05		0.72	0.42	CMM-5		PNT3
B	44.21			44.09		44.23		43.95		CMM-5		
C	-48.75			-48.73		-48.74		-48.71		CMM-5		
A	-18.86			-18.98		-18.85		-19.11		CMM-5		
	⊕ 0.30 A B C			0.09		0.09		0.09		CMM-5		PNT4
B	26.66			26.69		26.69		26.69		CMM-5		
C	-54.81			-54.80		-54.80		-54.80		CMM-5		
A	-3.98			-4.01		-4.01		-4.01		CMM-5		
	⊕ 0.30 A B C			0.02		0.03		0.03		CMM-5		PNT5
B	23.13			23.12		23.12		23.12		CMM-5		
C	-10.40			-10.39		-10.39		-10.39		CMM-5		
A	3.74			3.74		3.75		3.75		CMM-5		
	⊕ 0.30 A B C			0.03		0.05		0.05		CMM-5		PNT14
B	30.27			30.26		30.25		30.25		CMM-5		
C	-11.66			-11.66		-11.66		-11.66		CMM-5		
A	2.29			2.30		2.28		2.28		CMM-5		
	⊕ 0.30 A B C			0.16		0.12		0.19		CMM-5		PNT15
B	32.95			32.90		32.91		32.89		CMM-5		
C	-45.26			-45.23		-45.24		-45.23		CMM-5		
A	-3.54			-3.59		-3.58		-3.61		CMM-5		
	⊕ 0.30 A B C			0.34	0.04	0.15		0.62	0.32	CMM-5		PNT16
B	41.31			41.19		41.26		41.08		CMM-5		
C	-29.71			-29.70		-29.70		-29.69		CMM-5		

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ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
A	-11.34			-11.46		-11.39		-11.55		CMM-5		
	⊕ 0.30 A B C			0.41	0.11	0.30		0.64	0.34	CMM-5		PNT17
B	41.61			41.55		41.65		41.46		CMM-5		
C	-55.22			-55.18		-55.18		-55.17		CMM-5		
A	-14.01			-14.20		-14.15		-14.29		CMM-5		
	⊕ 0.30 A B C			0.64	0.34	0.69	0.39	0.94	0.64	CMM-5		PNT18
B	44.77			44.84		45.00		44.68		CMM-5		
C	-54.70			-54.64		-54.64		-54.63		CMM-5		
A	-17.08			-17.39		-17.33		-17.54		CMM-5		
	⊕ 0.30 A B C			0.30		0.43	0.13	0.55	0.25	CMM-5		PNT19
B	37.92			37.90		37.80		37.76		CMM-5		
C	-8.93			-8.89		-8.90		-8.89		CMM-5		
A	-5.97			-6.11		-6.15		-6.19		CMM-5		
	⊕ 0.30 A B C			0.39	0.09	0.60	0.30	0.78	0.48	CMM-5		PNT20
B	41.09			41.08		40.98		40.87		CMM-5		
C	-8.43			-8.40		-8.39		-8.39		CMM-5		
A	-9.05			-9.24		-9.32		-9.37		CMM-5		
	⊕ 0.30 A B C			0.43	0.13	0.21		0.69	0.39	CMM-5		PNT21
B	42.45			42.35		42.45		42.25		CMM-5		
C	-50.22			-50.13		-50.14		-50.11		CMM-5		
A	-14.37			-14.54		-14.44		-14.63		CMM-5		
	⊕ 0.30 A B C			0.37	0.07	0.48	0.18	0.70	0.40	CMM-5		PNT22
B	39.72			39.57		39.52		39.44		CMM-5		
C	-12.15			-12.07		-12.08		-12.09		CMM-5		
A	-8.05			-8.12		-8.17		-8.25		CMM-5		
	⊕ 0.30 A B C			0.10		0.10		0.12		CMM-5		PNT23
B	-0.15			-0.15		-0.16		-0.15		CMM-5		
C	-61.97			-61.92		-61.92		-61.92		CMM-5		

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ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
A	6.50			6.51		6.51		6.53		CMM-5		
	\varnothing 0.30 A B C			0.14		0.14		0.17		CMM-5		PNT24
B	9.90			9.90		9.90		9.90		CMM-5		
C	-61.17			-61.10		-61.10		-61.10		CMM-5		
A	6.50			6.51		6.51		6.55		CMM-5		
	\varnothing 0.30 A B C			0.02		0.02		0.05		CMM-5		PNT25
B	-26.05			-26.05		-26.04		-26.04		CMM-5		
C	-49.93			-49.92		-49.92		-49.91		CMM-5		
A	6.50			6.50		6.50		6.50		CMM-5		
	\varnothing 0.30 A B C			0.09		0.08		0.10		CMM-5		PNT26
B	-12.41			-12.38		-12.38		-12.38		CMM-5		
C	-58.16			-58.13		-58.13		-58.12		CMM-5		
A	6.50			6.51		6.51		6.51		CMM-5		
	\varnothing 0.30 A B C			0.07		0.10		0.12		CMM-5		PNT27
B	-13.47			-13.50		-13.51		-13.51		CMM-5		
C	-12.48			-12.46		-12.45		-12.45		CMM-5		
A	6.50			6.49		6.48		6.47		CMM-5		
	\varnothing 0.30 A B C			0.12		0.15		0.14		CMM-5		PNT28
B	-26.58			-26.64		-26.65		-26.64		CMM-5		
C	-34.22			-34.21		-34.20		-34.20		CMM-5		
A	6.50			6.48		6.48		6.47		CMM-5		
	\varnothing 0.30 A B C			0.13		0.12		0.13		CMM-5		PNT29
B	0.88			0.91		0.89		0.91		CMM-5		
C	-5.74			-5.68		-5.68		-5.68		CMM-5		
A	6.50			6.50		6.50		6.50		CMM-5		
	\varnothing 0.30 A B C			0.14		0.12		0.13		CMM-5		PNT30
B	16.49			16.45		16.45		16.45		CMM-5		
C	-11.25			-11.20		-11.21		-11.20		CMM-5		

INSPECTION REPORT #12345-6												
ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
A	6.50			6.50		6.50		6.50		CMM-5		
	NOTES:											
	UNLESS OTHERWISE SPECIFIED											
1	<ST> SIGNIFICANT CHARACTERISTICS ACCORDING TO CONTINENTAL SPECIFICATION CAP0500130-01											
2	<p>ANY CHANGES OF DESIGN FEATURES WHICH MAY AFFECT TOOL LIFE OR PERFORMANCES MUST BE REVIEWED AND APPROVED BY CONTINENTAL MECHANICAL ENGINEERING.</p> <p>=C101=-ANY CHANGES OF DESIGN FEATURES WHICH MAY AFFECT TOOL LIFE OR PERFORMANCES MUST BE REVIEWED AND APPROVED BY CONTINENTAL MECHANICAL ENGINEERING.</p> <p>-NO CHANGES SHALL BE ALLOWED ON PRODUCTION MATERIALS, PROCESSES, OR MANUFACTURING LOCATIONS WITHOUT PRIOR APPROVAL BY CONTINENTAL ENGINEERING, QUALITY AND PURCHASING DEPARTMENTS.</p> <p>-THE PPAP LEVEL FOR REPAIR, MODIFICATION AND REARRANGEMENT OF PRODUCTION TOOLING OR EQUIPMENT MUST BE DETERMINED BY CONTINENTAL SQM AND PURCHASING.</p> <p>-MATERIAL INFO MUST BE INCLUDED FOR EVERY ISIR/PPAP SUBMISSION.</p>											

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ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
3	PART MARKING AREA FOR DATE CODE, PART NUMBER, REVISION, CAVITY ID AN MATERIAL CODE WILL BE SELECTED IN AGREEMENT WITH CONTINENTAL. ALL MARKING NEEDS TO BE DEPRESSED. PART REVISION MUST BE REPLACEABLE.											
4	PART NEED TO BE FREE OF OIL, PART CLEANNESS ACCORDING TO ISO 16232 CCC = N (H-I 250)											
5	REFER TO CAD MODEL FOR DIMENSIONS NOT SHOWN ON DRAWING. UNLESS OTHERWISE SPECIFIED. ALL MATH DATA IS ASSUME BASIC: ANY DISCREPANCIES BETWEEN DRAWING AN CORRESPONDING REVISION MODEL MUST BE REPORTED TO CONTINENTAL MECHANICAL ENGINEERING.											
6	MOLDFLOW ANALYSIS MUST BE PROVIDED TO CONTINENTAL ENGINEERING. GATING, OVERFLOW TABS, PARTING LINES, VENTS, AND EJECTOR PIN LOCATIONS TO BE APPROVED BY CONTINENTAL BEFORE CUT THE TOOL.										1	
7	EJECTOR MARKS TO BE FLUSH OR DEPRESSED MAX. 0.30 MM.			-0.17	0.17	-0.18	0.18	-0.16	0.16	DI-I015		
8	BURRS, FLASH OR PARTING LINES NO BIGGER THAN 0.30 IN HOLES AND EDGES			0.05		0.04		0.05		VS-2/REP		
	BURRS, FLASH OR PARTING LINES IN GENERAL AREAS NOT BIGGER THAN 0.30MM			0.05		0.04		0.05		VS-2/REP		
	NO POOR FILL ALLOWED BIGGER THAN 0.30MM			0.00		0.00		0.00		VL		
	HEAT CHECKS NOT ALLOWED BIGGER THAN 0.40 MM.			0.00		0.00		0.00		VL		

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9	ALL DIMENSIONS AND TOLERANCE PER ASME Y14.5M - 1994. EDGES WITHOUT DIMENSIONS ACCORDING TO DIN ISO 13715			NOTED		NOTED		NOTED				
10	THIS PART NEEDS TO MEET BELOW AGREEMENT OF REQUIREMENTS: GENERAL QUALITY AGREEMENT (GQA) A2C00053611AAAA GENERAL QUALITY REQUIREMENTS (GQR) 10098907AC CATEGORY QUALITY REQUIREMENTS FOR CASTING PARTS 10098896.											

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ITEM	DIMENSION	+ Tol.	- Tol.	SAMPLE 1	Out of tol.	SAMPLE 2	Out of tol.	SAMPLE 3	Out of tol.	METHOD GAGE ID	INSPECTION NOTE	COMMENTS
11	<p>CONTINENTAL SQM & ME DEPARTMENTS MUST APPROVE THE SUPPLIER'S CLEANING PROCESS. THE FOLLOWING REQUIREMENTS MUST BE MET:</p> <p>A. CONTINENTAL SQM & ME MUST PERFORM A PHYSICAL INSPECTION OF THE CLEANING PROCESS AND EQUIPMENT.</p> <p>B. CONTINENTAL SQM & ME MUST REVIEW AND APPROVE THE SUPPLIER'S CONTROL PLAN.</p> <p>C. WHEN AN ACCEPTABLE CLEANLINESS PROCESS HAS MET THE ADHESION REQUIREMENTS AND ITEMS A AND B ABOVE, THE SUPPLIER CAN CORRELATE IT TO THE SURFACE TENSION DYNE NUMBER FOR ON-GOING CLEANLINESS INSPECTION. THE CORRELATED DYNE VALUE CAN BE USED FOR PROCESS CONTROL. BUT A MIN DYNE VALUE OF 38 MN/M IS REQUIRED. NO CHANGE SHALL BE ALLOWED ON THE APPROVED CLEANLINESS PROCESS OR CHEMICALS (CLEANERS, LUBRICANTS, ANTI-CORROSION AGENTS, AND SO ON) WITHOUT APPROVAL FROM CONTINENTAL.</p>										1	
	<u>INSPECTION NOTES</u>											
1	MADE TO MEASURE DOES NOT PROVIDE THIS SERVICE											
2												
3												
	<u>ALIGNMENT DESCRIPTION</u>											
1	ALIGNMENT WAS PERFORMED ACCORDING TO DATUM REFERENCE FRAME INDICATED ON THE DRAWING											
	<u>END OF REPORT</u>											