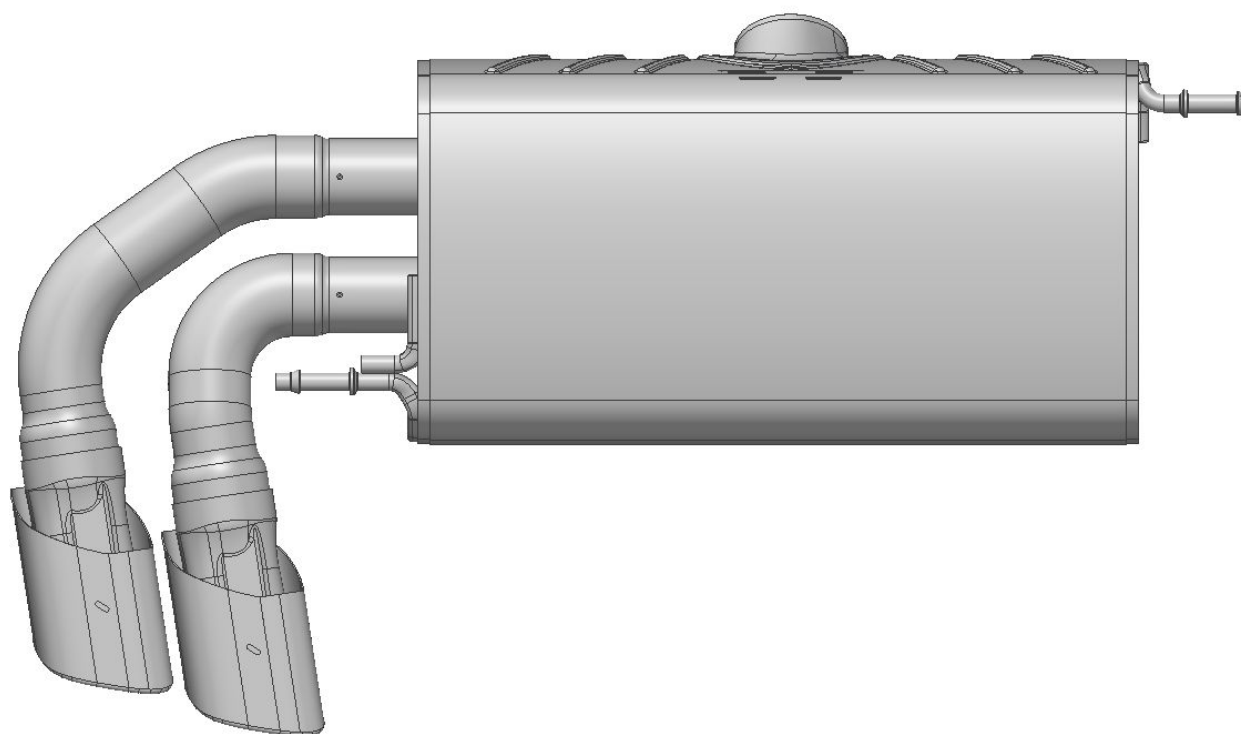


# MEASUREMENT REPORT

Subject :

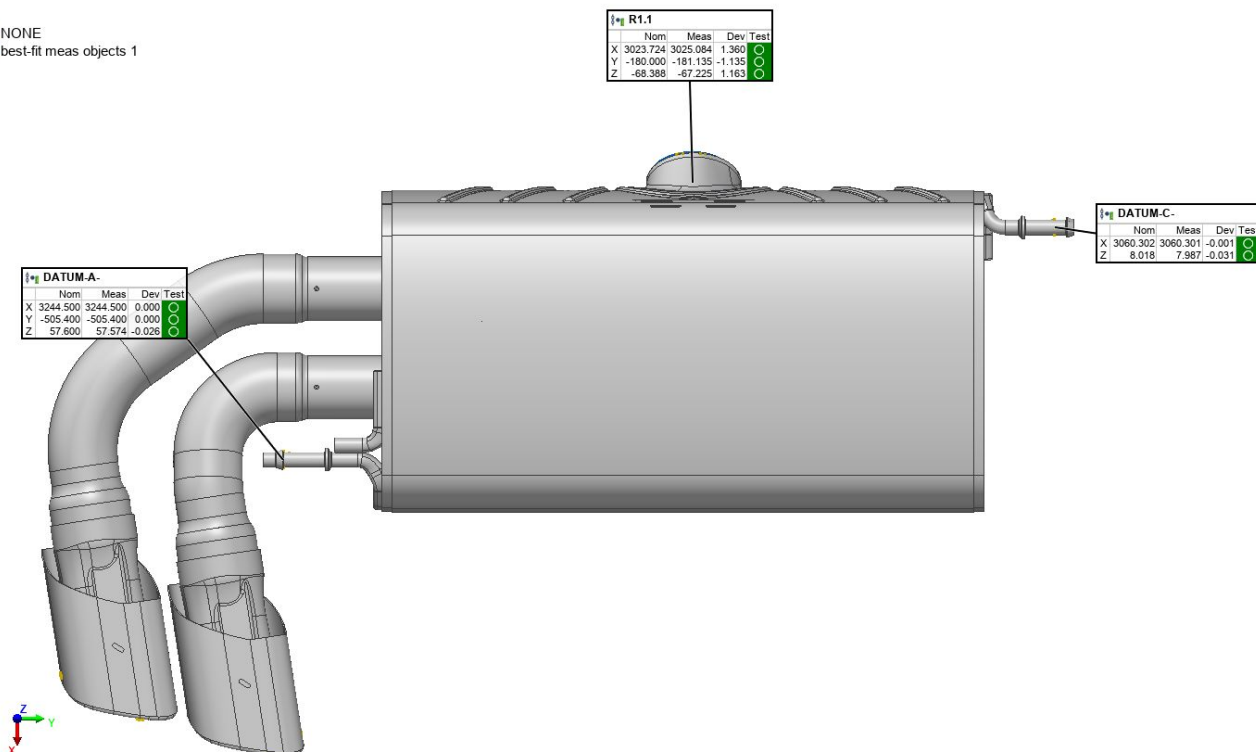


Customer: FORVIA SJC  
Operator: Felipe Martinez  
E-mail: felipe.martinez@mess.com.mx  
Workspace: PROGRAMA\_AUDI V6TFSI\_068  
Project: R4 TDI\_68\_OP20\_SINGLE

Part name: R4 TDI  
Part number: OP20  
Drawing : S/R  
Device: MESS-BRAA-003



NONE  
best-fit meas objects 1



## Feature Table

Length Units    Millimeters

### • DATUM-A-

| Control | Nom      | Meas     | Tol    | Dev    | Test |
|---------|----------|----------|--------|--------|------|
| X       | 3244.500 | 3244.500 | ±0.200 | 0.000  | Pass |
| Y       | -505.400 | -505.400 | ±0.200 | 0.000  | Pass |
| Z       | 57.600   | 57.574   | ±0.200 | -0.026 | Pass |

### • DATUM-C-

| Control | Nom      | Meas     | Tol    | Dev    | Test |
|---------|----------|----------|--------|--------|------|
| X       | 3060.302 | 3060.301 | ±2.000 | -0.001 | Pass |
| Z       | 8.018    | 7.987    | ±0.200 | -0.031 | Pass |

### • B-AUX

| Control   | Nom     | Meas    | Tol    | Dev    | Test |
|-----------|---------|---------|--------|--------|------|
| Diameter  | 70.600  | 69.707  | ±1.000 | -0.893 | Pass |
| X/Y Angle | 180.000 | 179.891 | ±1.000 | -0.109 | Pass |

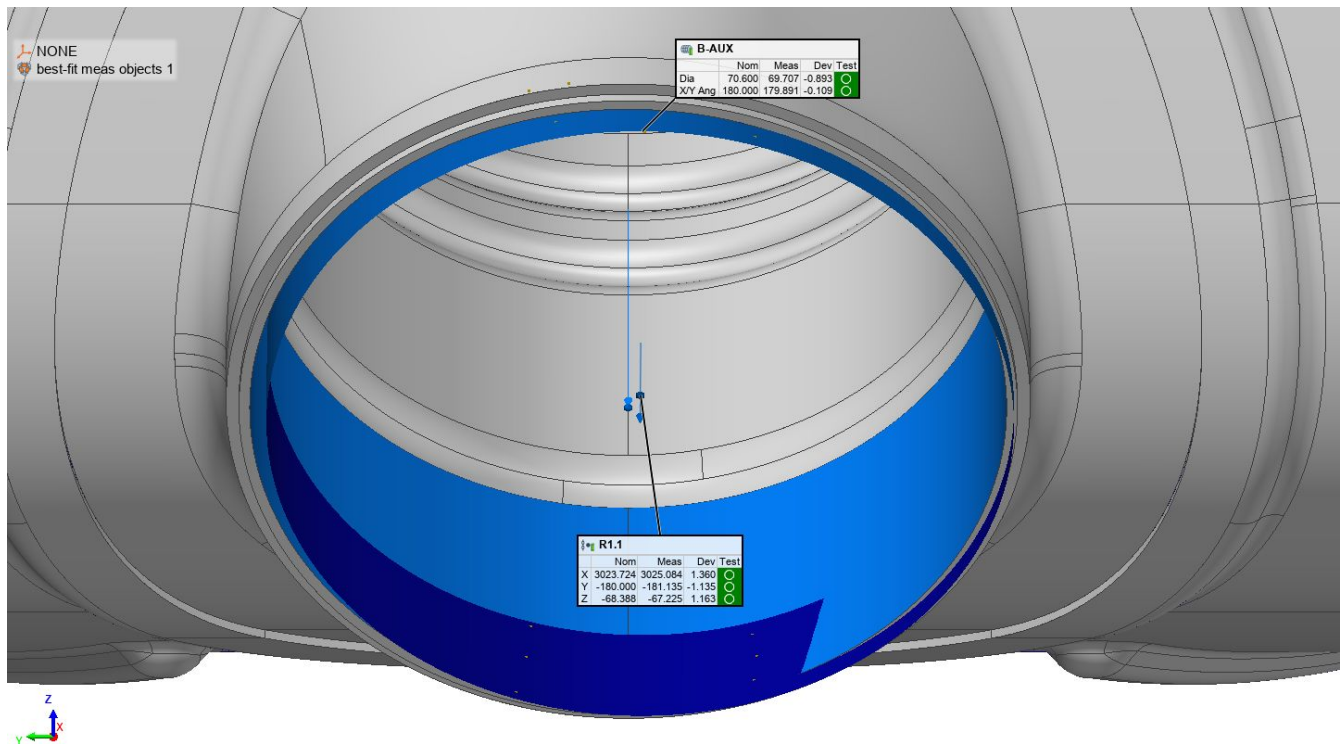
Customer: FORVIA SJC  
Operator: Felipe Martinez  
E-mail: felipe.martinez@mess.com.mx

Part name: R4 TDI  
Part number: OP20  
Piece: piece 2



• R1.1

| Control | Nom      | Meas     | Tol    | Dev    | Test |
|---------|----------|----------|--------|--------|------|
| X       | 3023.724 | 3025.084 | ±2.000 | 1.360  | Pass |
| Y       | -180.000 | -181.135 | ±2.000 | -1.135 | Pass |
| Z       | -68.388  | -67.225  | ±2.000 | 1.163  | Pass |

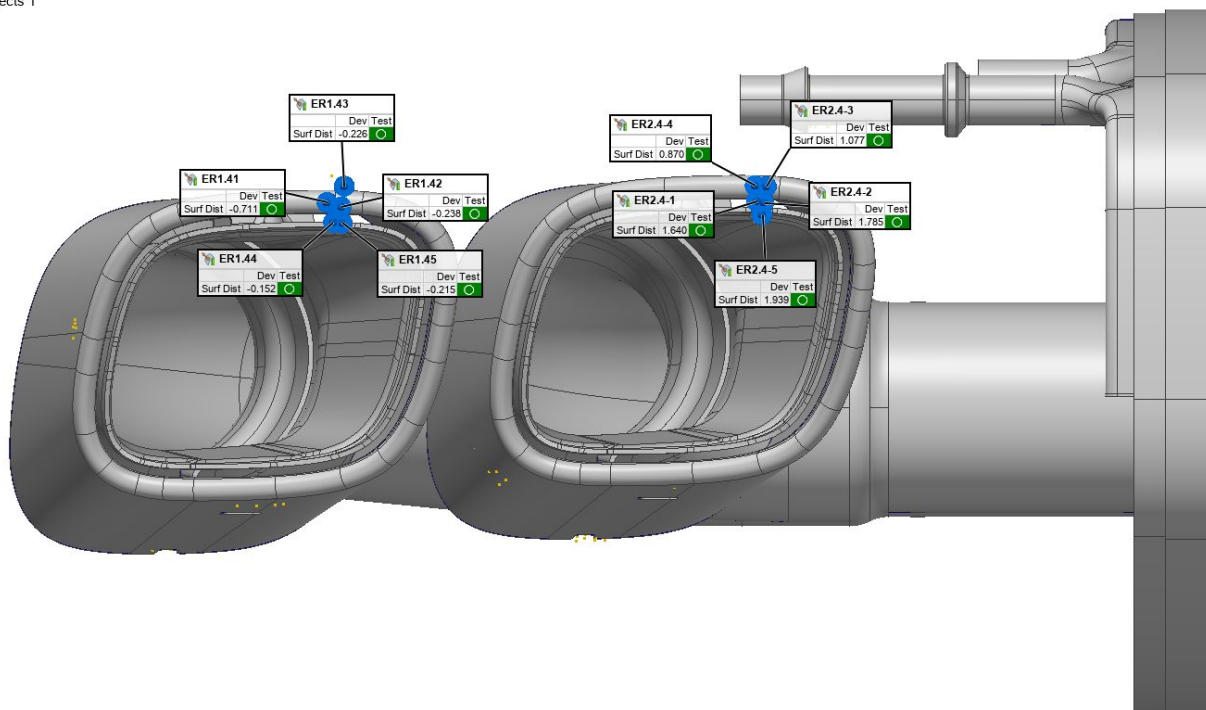


Customer: FORVIA SJC  
Operator: Felipe Martinez  
E-mail: felipe.martinez@mess.com.mx

Part name: R4 TDI  
Part number: OP20  
Piece: piece 2



NONE  
best-fit meas objects 1



## Comparison Point Table

Units Millimeters

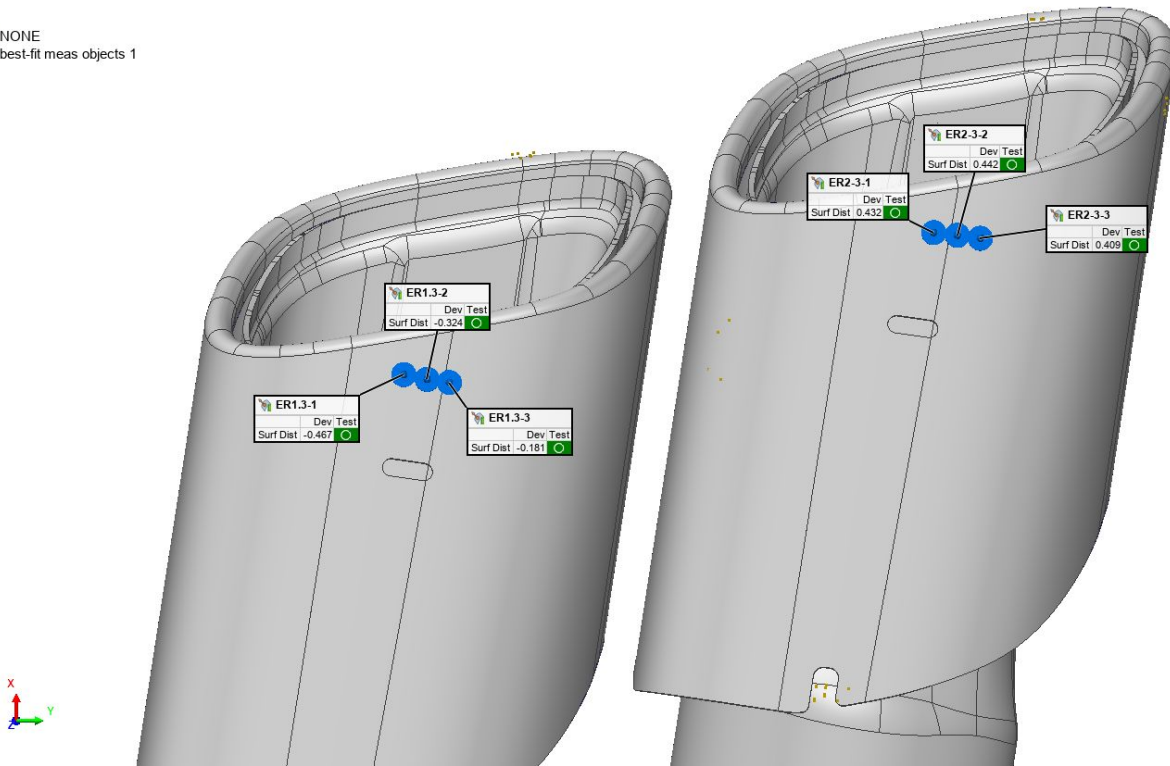
| Name    | Control          | Nom | Meas   | Tol    | Dev    | Test |
|---------|------------------|-----|--------|--------|--------|------|
| ER1.41  | Surface Distance |     | -0.711 | ±2.000 | -0.711 | Pass |
| ER1.42  | Surface Distance |     | -0.238 | ±2.000 | -0.238 | Pass |
| ER1.43  | Surface Distance |     | -0.226 | ±2.000 | -0.226 | Pass |
| ER1.44  | Surface Distance |     | -0.152 | ±2.000 | -0.152 | Pass |
| ER1.45  | Surface Distance |     | -0.215 | ±2.000 | -0.215 | Pass |
| ER2.4-1 | Surface Distance |     | 1.640  | ±2.000 | 1.640  | Pass |
| ER2.4-2 | Surface Distance |     | 1.785  | ±2.000 | 1.785  | Pass |
| ER2.4-3 | Surface Distance |     | 1.077  | ±2.000 | 1.077  | Pass |
| ER2.4-4 | Surface Distance |     | 0.870  | ±2.000 | 0.870  | Pass |
| ER2.4-5 | Surface Distance |     | 1.939  | ±2.000 | 1.939  | Pass |

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Part number: OP20  
Piece: piece 2



NONE  
best-fit meas objects 1



## Comparison Point Table

Units Millimeters

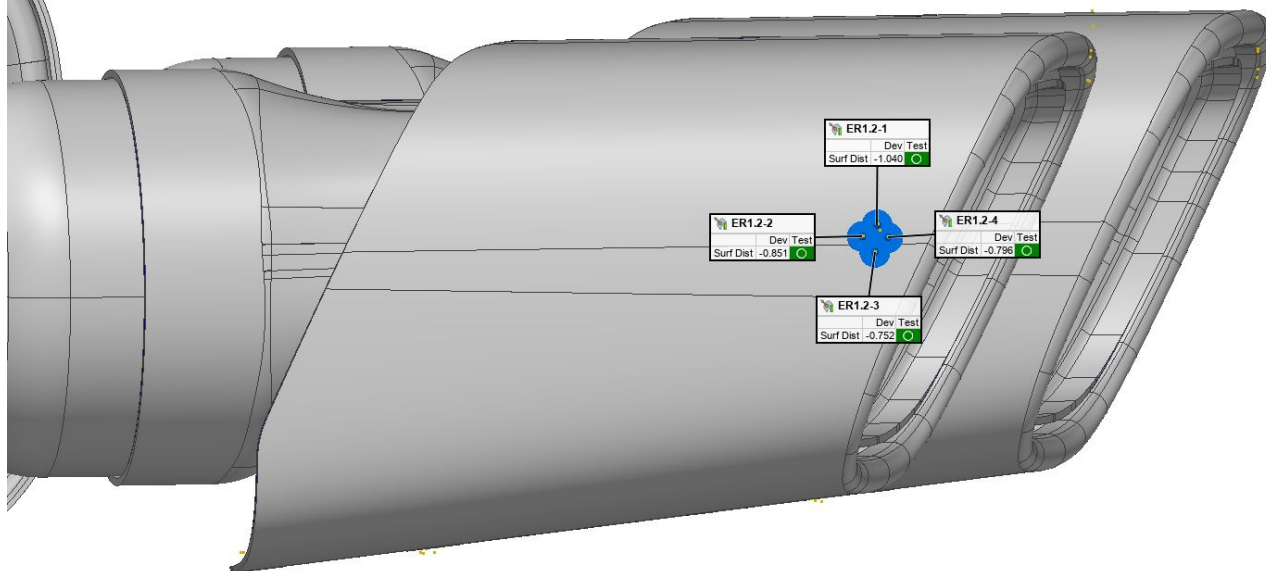
| Name    | Control          | Nom | Meas   | Tol    | Dev    | Test |
|---------|------------------|-----|--------|--------|--------|------|
| ER1.3-1 | Surface Distance |     | -0.467 | ±2.000 | -0.467 | Pass |
| ER1.3-2 | Surface Distance |     | -0.324 | ±2.000 | -0.324 | Pass |
| ER1.3-3 | Surface Distance |     | -0.181 | ±2.000 | -0.181 | Pass |
| ER2-3-1 | Surface Distance |     | 0.432  | ±2.000 | 0.432  | Pass |
| ER2-3-2 | Surface Distance |     | 0.442  | ±2.000 | 0.442  | Pass |
| ER2-3-3 | Surface Distance |     | 0.409  | ±2.000 | 0.409  | Pass |

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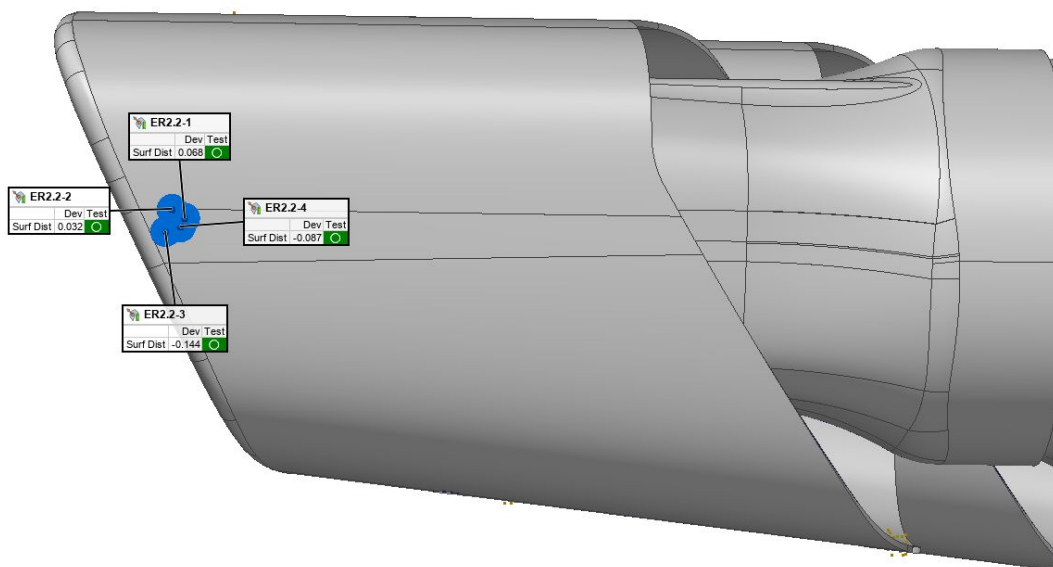
Part name: R4 TDI  
Part number: OP20  
Piece: piece 2



NONE  
best-fit meas objects 1



NONE  
best-fit meas objects 1



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Part name: R4 TDI  
Part number: OP20  
Piece: piece 2

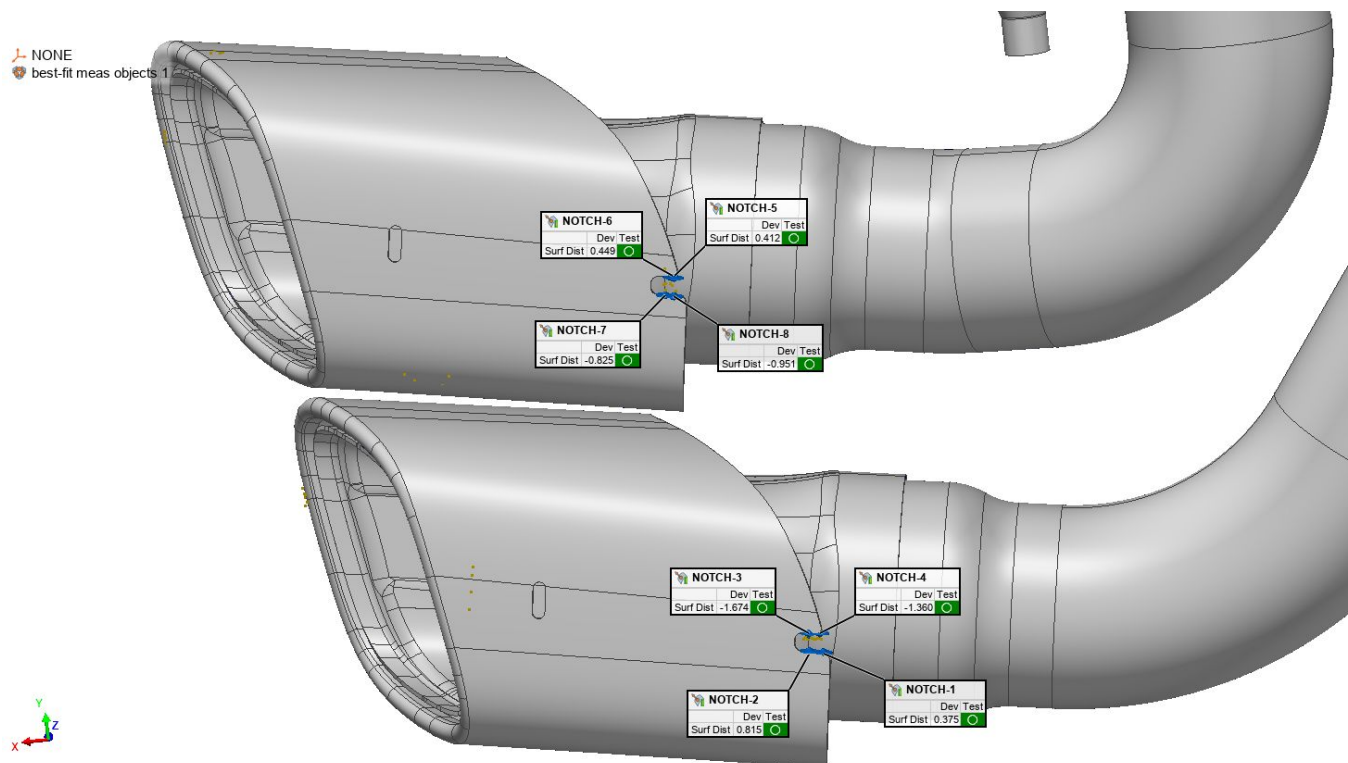




## Comparison Point Table

Units Millimeters

| Name    | Control          | Nom | Meas   | Tol    | Dev    | Test |
|---------|------------------|-----|--------|--------|--------|------|
| ER1.2-1 | Surface Distance |     | -1.040 | ±2.000 | -1.040 | Pass |
| ER1.2-2 | Surface Distance |     | -0.851 | ±2.000 | -0.851 | Pass |
| ER1.2-3 | Surface Distance |     | -0.752 | ±2.000 | -0.752 | Pass |
| ER1.2-4 | Surface Distance |     | -0.796 | ±2.000 | -0.796 | Pass |
| ER2.2-1 | Surface Distance |     | 0.068  | ±2.000 | 0.068  | Pass |
| ER2.2-2 | Surface Distance |     | 0.032  | ±2.000 | 0.032  | Pass |
| ER2.2-3 | Surface Distance |     | -0.144 | ±2.000 | -0.144 | Pass |
| ER2.2-4 | Surface Distance |     | -0.087 | ±2.000 | -0.087 | Pass |



## Comparison Point Table

Units Millimeters

| Name    | Control          | Nom | Meas   | Tol    | Dev    | Test |
|---------|------------------|-----|--------|--------|--------|------|
| NOTCH-1 | Surface Distance |     | 0.375  | ±2.000 | 0.375  | Pass |
| NOTCH-2 | Surface Distance |     | 0.815  | ±2.000 | 0.815  | Pass |
| NOTCH-3 | Surface Distance |     | -1.674 | ±2.000 | -1.674 | Pass |
| NOTCH-4 | Surface Distance |     | -1.360 | ±2.000 | -1.360 | Pass |
| NOTCH-5 | Surface Distance |     | 0.412  | ±2.000 | 0.412  | Pass |
| NOTCH-6 | Surface Distance |     | 0.449  | ±2.000 | 0.449  | Pass |
| NOTCH-7 | Surface Distance |     | -0.825 | ±2.000 | -0.825 | Pass |
| NOTCH-8 | Surface Distance |     | -0.951 | ±2.000 | -0.951 | Pass |

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Part number: OP20  
Piece: piece 2

