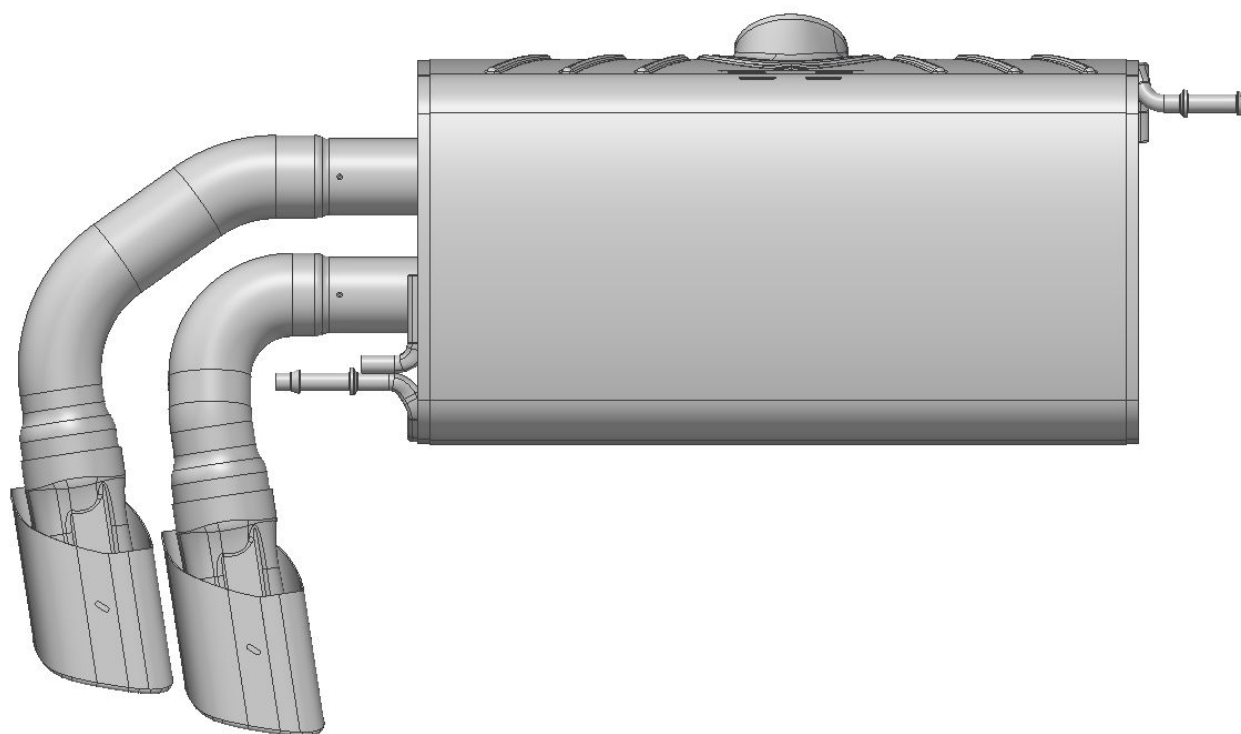


MEASUREMENT REPORT

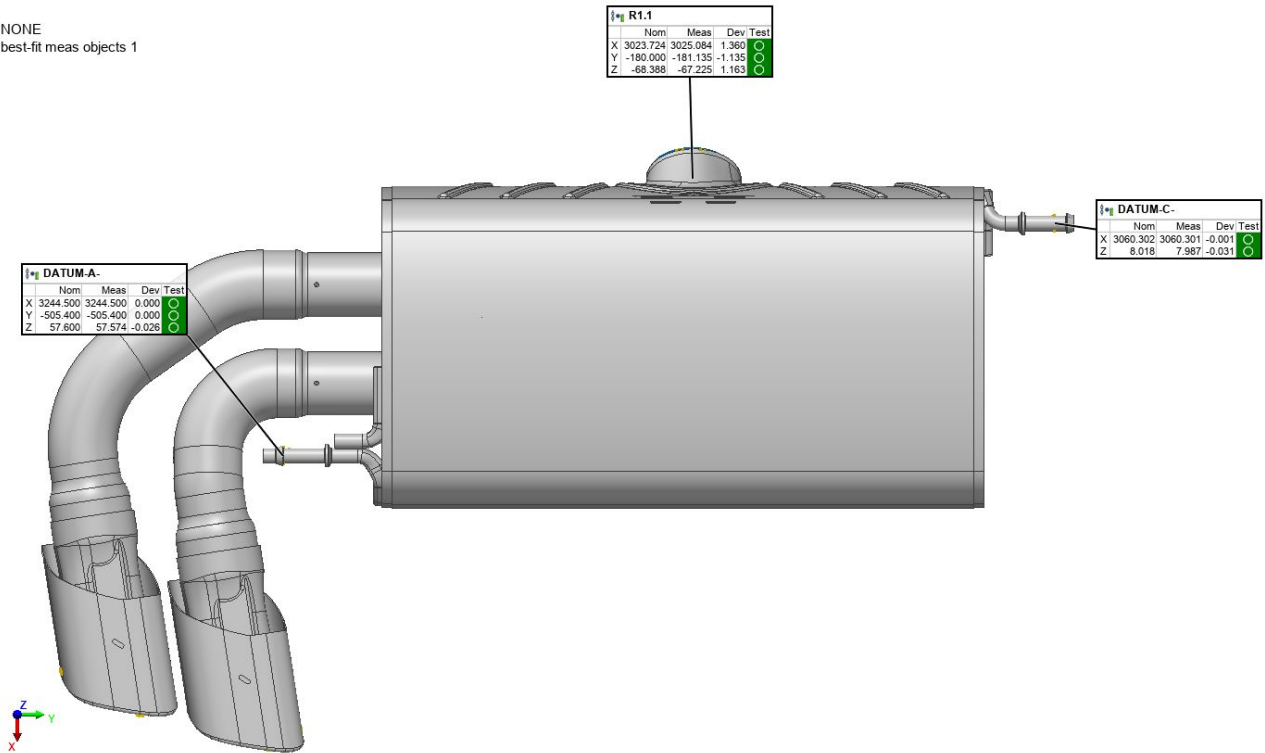
Subject :



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

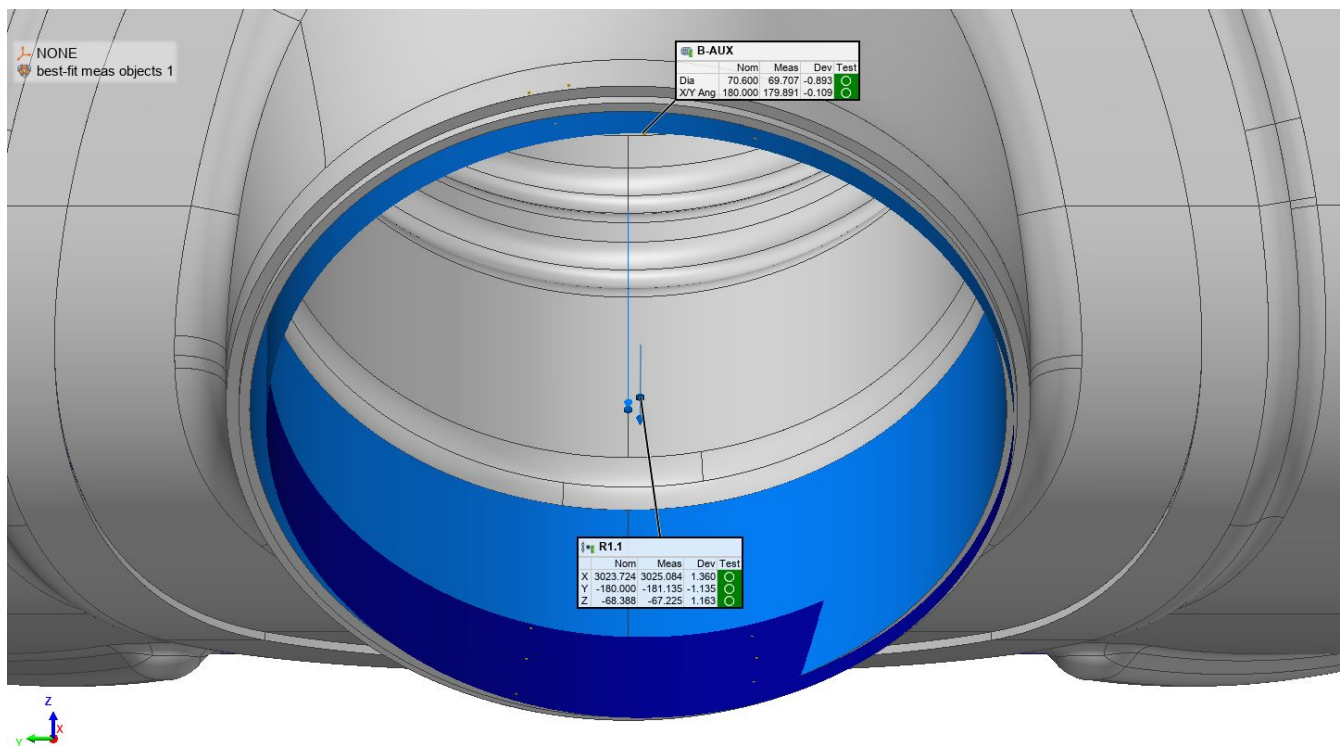
Control	Nom	Meas	Tol	Dev	Test
Diameter	70.600	69.707	±1.000	-0.893	Pass
X/Y Angle	180.000	179.891	±1.000	-0.109	Pass

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

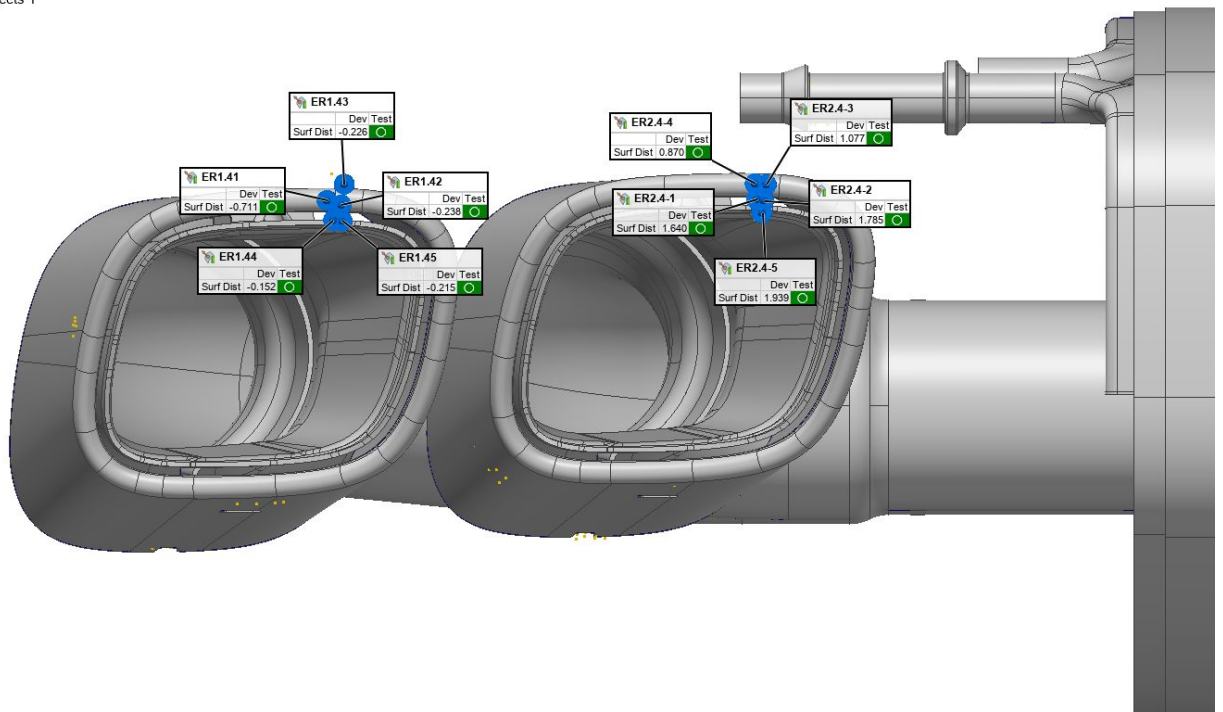
Control	Nom	Meas	Tol	Dev	Test
X	3023.724	3025.084	±2.000	1.360	Pass
Y	-180.000	-181.135	±2.000	-1.135	Pass
Z	-68.388	-67.225	±2.000	1.163	Pass



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

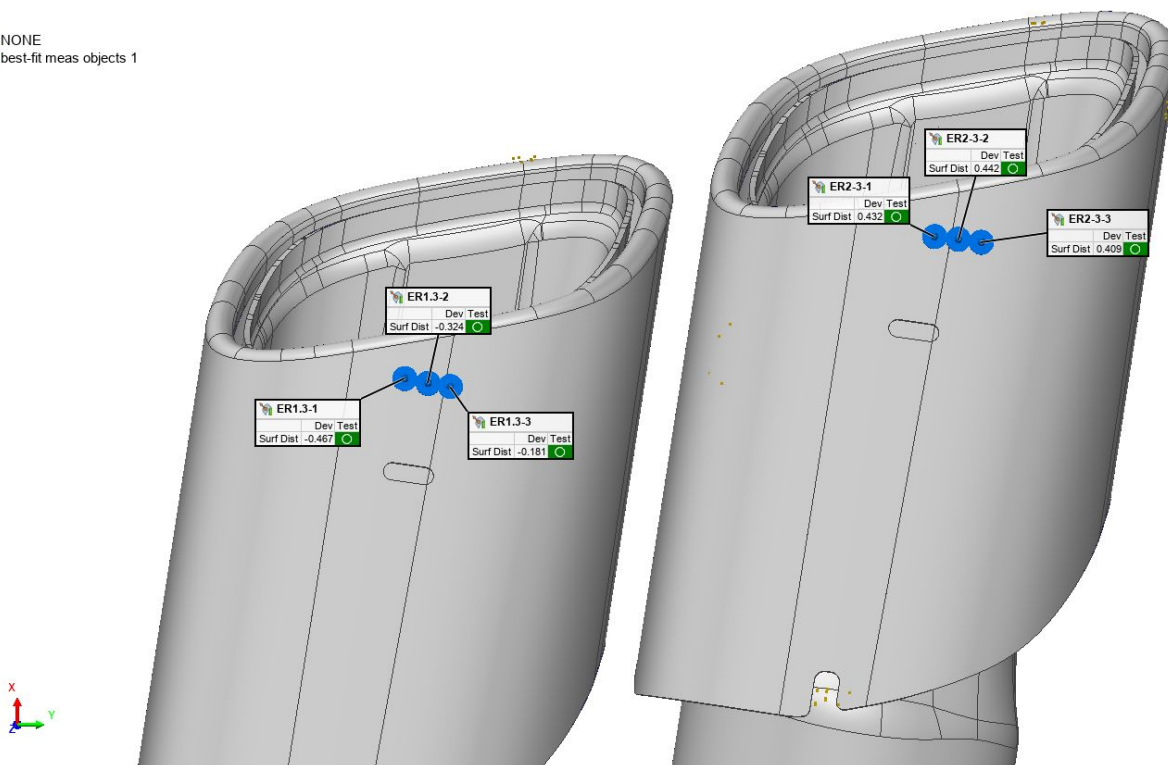
Units Millimeters

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

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

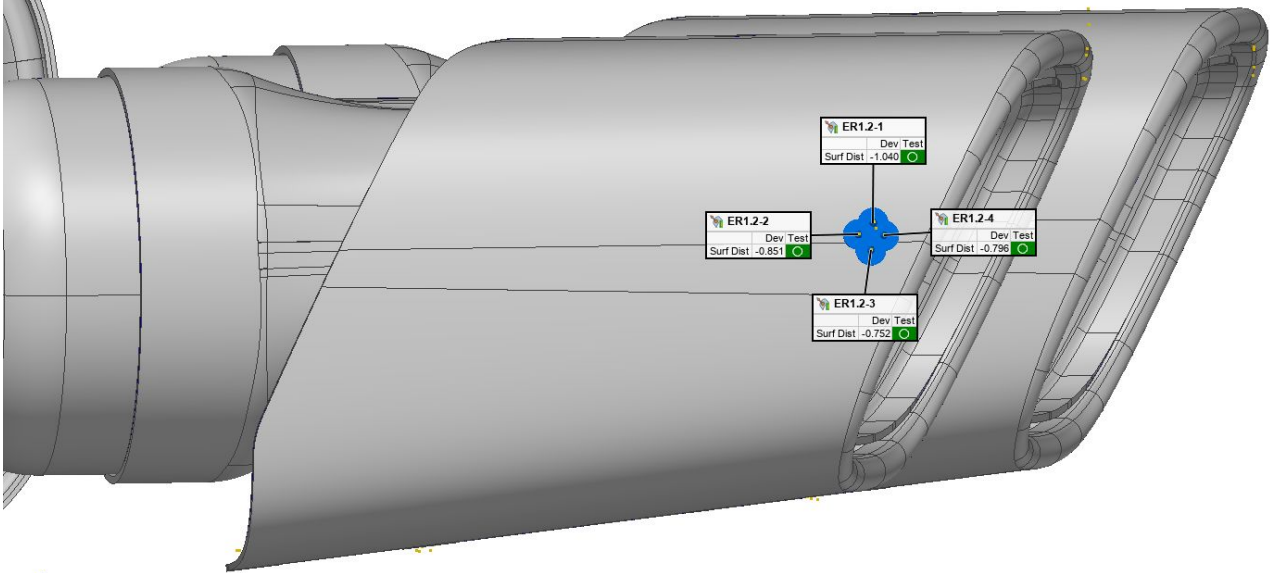
Units Millimeters

Name	Control	Nom	Meas	Tol	Dev	Test
ER1.3-1	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

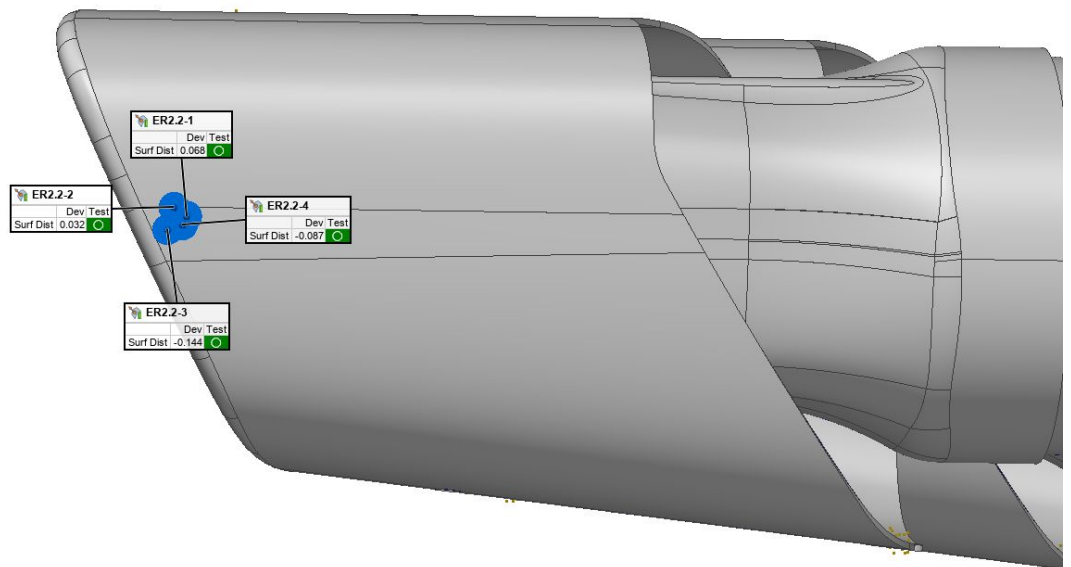
Customer: FORVIA SJC
 Operator: Felipe Martinez
 E-mail: felipe.martinez@mess.com.mx

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

NONE
 best-fit meas objects 1



NONE
 best-fit meas objects 1



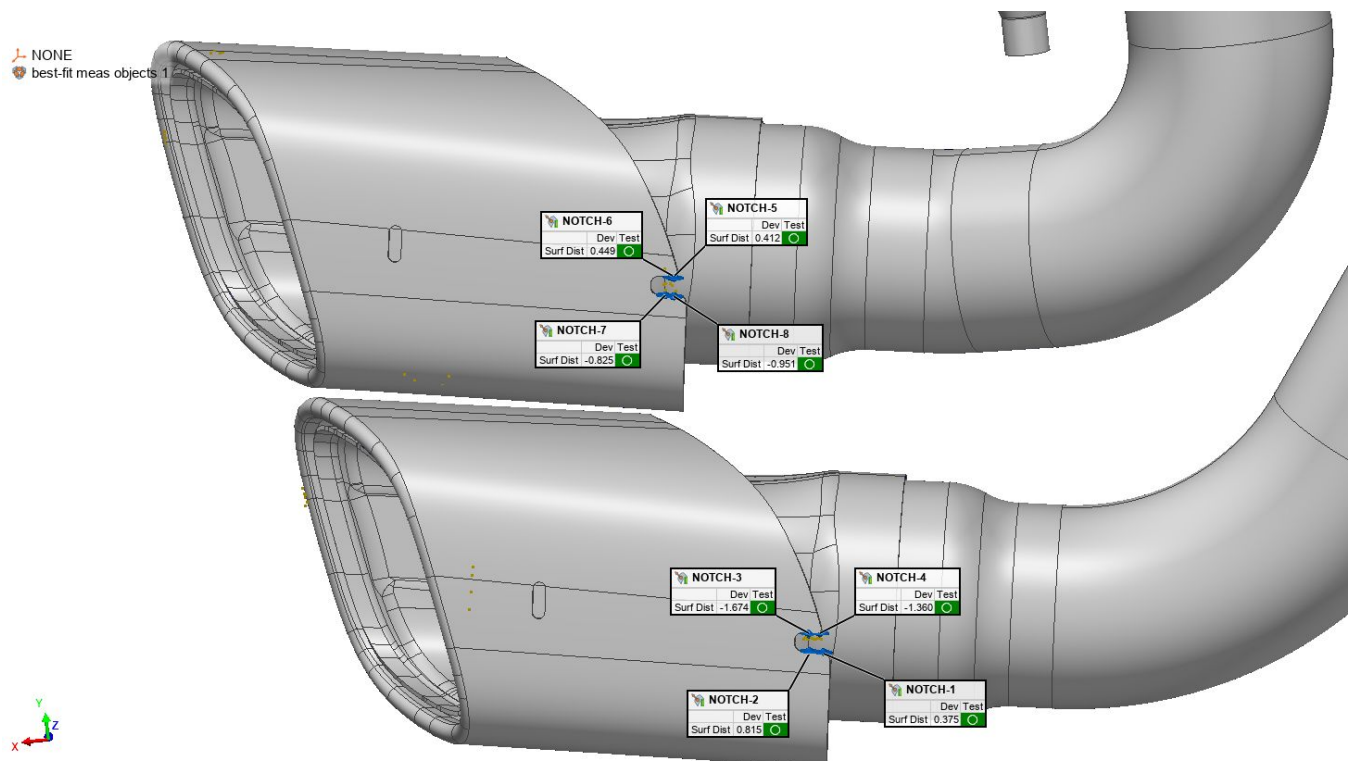
Customer: FORVIA SJC
 Operator: Felipe Martinez
 E-mail: felipe.martinez@mess.com.mx

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

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

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