

EXAMPLE HELMEL TURNKEY PROJECT

Helmel
Design/Build
Fixture



Example Summary Page

		ACTUAL	DEVIATION	NOMINAL	+TOL	-TOL	TOUCHFORDETAILS	
TRAPEZOID DATUM SIDE PROFILE		0.020	0.020	0.000	-0.000			
TRAPEZOID DATUM SIDE ANGLE (deg)		12.955	-0.005	13.000	0.750	-0.750	To Details Page >>>	
TRAPEZOID OPPOSITE DATUM SIDE PROFILE		0.044	0.044	0.000	0.500			
TRAPEZOID OPPOSITE DATUM SIDE ANGLE (deg)		13.004	0.004	13.000	0.750	-0.750		
LOCK SLOT TRUE POSITION TOP		15.978	-0.072	16.050	0.100	-0.100		
LOCK SLOT LOCATION TOP		148.886	-0.325	148.610	0.200	-0.200		
LOCK SLOT DEPTH TOP		18.353	0.058	18.255	0.300	-0.300		
LOCK SLOT RADIUS TOP		12.829	1.029	11.800	1.000	-1.000		
LOCK SLOT WIDTH TOP		3.440	0.292	3.185	0.065	-0.065		
LOCK SLOT CHAMFER CHECK TOP - UPPER		Chamfer is OK						
LOCK SLOT CHAMFER CHECK TOP - LOWER		Chamfer is OK						
LOCK SLOT TRUE POSITION BOTTOM		2.290	-0.075	2.555	0.100	-0.100		
LOCK SLOT LOCATION BOTTOM		148.493	-0.117	148.610	0.200	-0.200		
LOCK SLOT DEPTH BOTTOM		10.360	0.105	10.255	0.300	-0.300		
LOCK SLOT RADIUS BOTTOM		12.873	1.073	11.800	1.000	-1.000	To Details Page >>>	
LOCK SLOT WIDTH BOTTOM		3.432	-0.227	3.185	0.065	-0.065		
LOCK SLOT CHAMFER CHECK BOTTOM - UPPER		Chamfer is OK						
LOCK SLOT CHAMFER CHECK BOTTOM - LOWER		Chamfer is OK						
PIN BORE TRUE POSITION ABC		-0.129	-0.130	0.000	0.100	-0.015	To Details Page >>>	
PIN BORE DIAMETER		18.940	0.007	18.947	0.032			
PIN BORE ROUNDNESS		0.000	0.000	0.000	0.012			
PIN BORE TAPER (In Line)		0.004	0.004	0.000	0.007			
CRANK BORE TRUE POSITION		0.291	-0.291	0.000	0.100			
CRANK BORE PERPENDICULARITY		0.006	0.006	0.000	0.040			
CRANK BORE DIAMETER (Top In Line)		47.118	-0.011	47.129	0.030	-0.030	To Details Page >>>	
CRANK BORE DIAMETER (Bottom In Line)		47.115	-0.014	47.129	0.030	-0.030		
CRANK BORE ROUNDNESS		0.001	0.001	0.000	0.012			
CRANK BORE TAPER (In Line)		0.003	0.003	0.000	0.007			
PIN BORE TWIST		0.013	0.013	0.000	0.040			
PIN BORE BEND		0.003	0.003	0.000	0.034			
PIN BORE CENTER DISTANCE		129.250	0.000	129.250	0.050		To Details Page >>>	
PIN BORE TRUE POSITION AD		0.001	0.001	0.000	0.100			

Example Details Page

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CRANK BORE DETAILS

RUN DATE & TIME: 03/05/2015 19:26:40
Reaction Plan

ACTUAL	DEVIATION	NOMINAL	+TOL	-TOL
0.040	0.040	0.000	0.100	

True Position

CRANK BORE POSITION X

-0.002	-0.002	0.000	
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CRANK BORE POSITION Y

148.630	0.020	148.610	
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CRANK BORE PERPENDICULARITY

0.006	0.006	0.000	0.040
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CRANK BORE DIAMETER

	Top / Bottom
47.127	-0.002 47.129 0.030 -0.030
47.123	-0.006 47.129 0.030 -0.030

CRANK BORE ROUNDNESS

0.000	0.000	0.000	0.012
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CRANK BORE TAPER

ACTUAL	DEVIATION	NOMINAL	+TOL	-TOL
0.004	0.004	0.000	0.013	