

CASCADE PRECISION PROCESS INSPECTION SHEET

PART# BMP2.5

REV: D

LATHE OP 1		SAMPLE		OPERATOR 1ST ART. MEASUREMENT
DIMENSION	TOLERANCE	SIZE	METHOD OF INSPECTION	
2.228 X 2	+0.001/-0	EVERY 1	2-3" MIC (HOLD 2.228-2.229)	
1.997	+0.003/-0	EVERY 3	1-2" BLADE MIC (HOLD TO 1.997-2.000)	
.255 2X	+0.02/-0	EVERY 10	CALIPERS (HOLD TO .250-.260)	
.471	+/-0.005	EVERY 5	CALIPERS (HOLD .466-.476)	
.550	+0.015/-0	EVERY 10	CALIPERS (HOLD .550-.565)	
.090 2X	+/-0.005	EVERY 5	CALIPERS (HOLD TO .085-.095)	
1.500	+/-0.005	EVERY 5	CALIPERS (HOLD TO 1.495-1.505)	
2.465 X 4	+/-0.005	EVERY 5	CALIPERS (HOLD TO 2.460-2.470)	
.786	+/-0.005	EVERY 5	CALIPERS (HOLD .781-.791)	
.630	+0.005/-0	EVERY 5	PINS (GO=.630 NO-GO=.636)	
.132 DP	+/-0.005	EVERY 5	DIAL INDICATOR STAND (HOLD TO .127-.137)	
MAKE SURE NO DINGS, DENTS, SCRATCHES OR TOOL MARKS ON PART				
INSPECTION FEATURES CHECKED IN QC				
<i>R.050 2X</i>	<i>+/-0.005</i>		<i>OPTICAL COMPARATOR</i>	
<i>R.030 2X</i>	<i>+/-0.005</i>		<i>OPTICAL COMPARATOR</i>	
<i>R.015 6X</i>	<i>+/-0.005</i>		<i>OPTICAL COMPARATOR</i>	

*OPERATOR CHECKED ALL DIMENSIONS TO PRINT INITIALS: _____ DATE: _____