

PP-FP0151: Y End Plate

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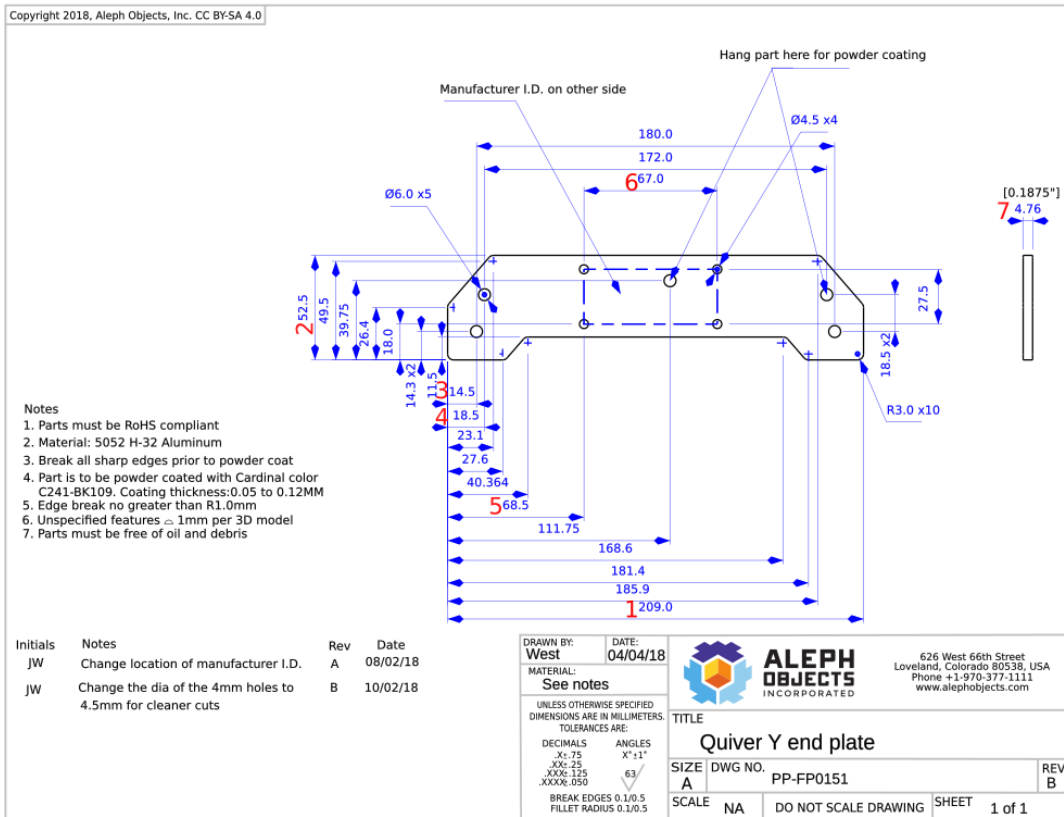


Figure 1: Schematic of PP-FP0153.

1 Dimension 1 & 2

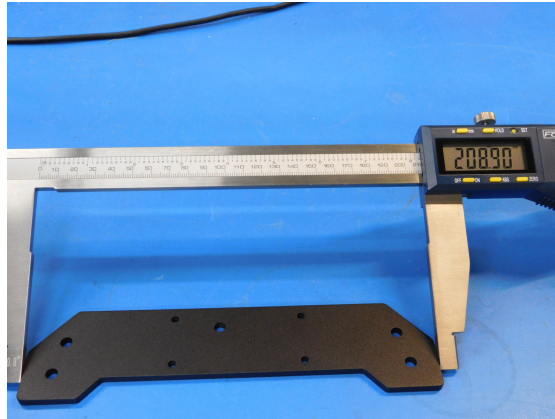


Figure 2: Dimension 01

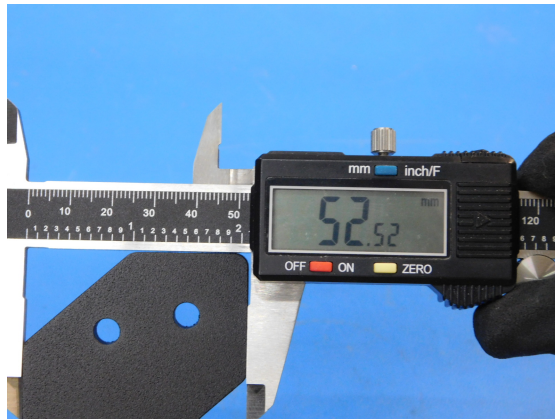


Figure 3: Dimension 02

As shown in Figure [2], using the set of large calipers, measure the length of the part to $209.0 \pm 0.75\text{mm}$. This will create a upper control limit of 209.75mm and a lower control limit of 208.25mm .

Using a set of calipers measure the width of the part as seen in Figure [3], and measure to $52.5 \pm 0.75\text{mm}$. This means the upper control limit will be 51.75mm and a lower control limit of 53.25mm .

2 Dimension 3, 4, & 5



Figure 4: Dimension 03

Using a set of calipers and 4.88mm pin gauge, we will use the back end of the calipers to measure the distance from each edge to the first set of holes since the is symmetric for the outside holes. The two holes for dimension 03 will be measure to $14.5 \pm 0.75mm$ giving us a upper control limit of $15.25mm$ and a lower control limit of $13.75mm$. The next two holes for dimension 4 will be measured to $18.5 \pm 0.75mm$, giving us a upper control limit of $19.25mm$ and a lower control limit of $17.75mm$. Finally for the two holes of dimension 5, we will be measure to $68.5 \pm 0.75mm$ for a upper control limit of $69.25mm$ and a lower control limit $67.75mm$.

3 Dimension 6

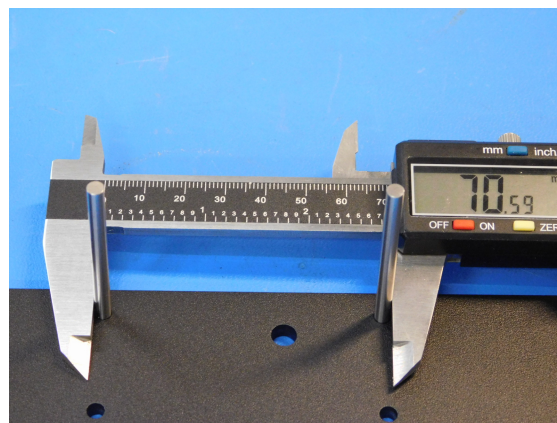


Figure 5: Dimension 06

Using 4.88mm and 4.90mm pin gauges we can measure the distance between the holes, as shown in Figure [5]. We can collect two measurements for these holes for the top and bottom, which will be measured to $67.0 \pm 0.75\text{mm}$. This will result in an upper control limit being 67.75mm and a lower control limit of 66.25mm .

4 Dimension 7

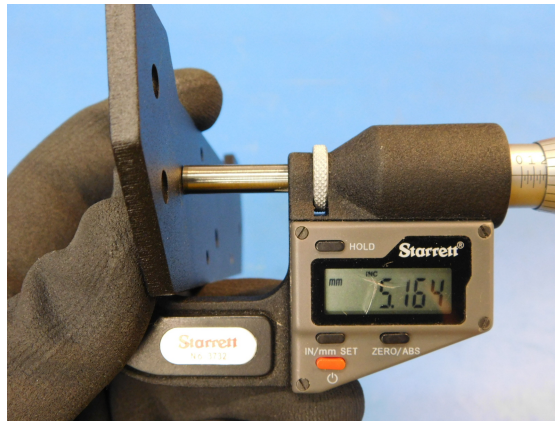


Figure 6: Dimension 07

Using a micrometer we can measure the thickness of the part to $4.76 \pm 0.25\text{mm}$. This will result in an upper control limit of 5.01mm and a lower control limit of 4.51mm .