

Balloon	Detail	RPN	Key	Operator				Inspection			
* 1.	∅ .193/.197 - HOLD TO .194/.196	56	Key	.1960 Pin Gage				.1960 Pin Gage			
				.1940 Pin Gage				.1940 Pin Gage			
				INTRIMIK MIC BORE GAGE .178 - .				INTRIMIK MIC BORE GAGE .178 - .			
* 2.	TP ∅ .002 A B bring into inspection 2 times a shift	64	Key	CMM				CMM			
* 3.	ROUND .0015 bring into inspection 2 times a shift	56	Key	CMM				CMM			
* 4.	1.01 ± .01	64		1-2 Depth Micrometer				1-2 Depth Micrometer			
* 5.	2.12 ± .01	64		6" Caliper				6" Caliper			
* 6.	FLAT .0005	42	Key	SHEFFIELD DOUBLE AIR COLUMN				CMM			
* 7.	Micro 63	56	Key	PROFILOMETER				PROFILOMETER			
* 8.	ROUND .0015 AT .105 DP. bring into inspection 2 times a shift	56	Key	CMM				CMM			
* 9.	TP ∅ .002 (AT .105 DP) bring into inspection 2 times a shift	64	Key	CMM				CMM			
10.	45° ± 15'	64		MOLD Comparator				MOLD Comparator			
* 11.	∅ 1.240 ± .005	64		1.2450 Pin Gage				CMM			
				1.2360 Pin Gage							
* 12.	∅ .906 ± .010	96		.8960 PIN GAGE				.8960 PIN GAGE			
				.9160 PIN GAGE				.9160 PIN GAGE			
* 13.	∅ .125 ± .005	64		.1280 Pin Gage				.1280 Pin Gage			
				.1220 Pin Gage				.1220 Pin Gage			
* 14.	.31 ± .01 DP.	64		.1220 Pin Gage				.1220 Pin Gage			
				6" Caliper				6" Caliper			
15.	TP ∅ .05 A B Y bring into inspection 2 times a shift	64		CMM				CMM			
* 16.	(4X) ∅ .211/.220	64		.2200 Pin Gage				.2200 Pin Gage			
				.2110 Pin Gage				.2110 Pin Gage			
* 17.	(4X) .75 ± .01 DP.	64		.2110 Pin Gage				.2110 Pin Gage			
				6" Caliper				6" Caliper			
* 18.	(4X) C'Sink ∅ .295 ± .005	64		.3000 Pin Gage				Comparator			
				.2900 Pin Gage							
19.	(4X) Cham 45° ± .5°	64		MOLD Comparator				MOLD Comparator			
* 20.	(4X) 1/4 - 28 UNF 2B	144	Key	1/4 - 28 UNF 2B Thread Gage P.I				1/4 - 28 UNF 2B Thread Gage P.I			
				.2311				.2311			

PH = process dimension

* = appears on operator check sheet

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* 21.	(4X) .62 Min DP	64	Key	1/4 - 28 UNF 2B Thread Gage P.I. .2311 6" Caliper				1/4 - 28 UNF 2B Thread Gage P.I. .2311 6" Caliper			
22.	TP ϕ .01 A B C bring into inspection 2 times a shift	64		CMM				CMM			
23.	BSC 45 ° bring into inspection 2 times a shift	64		CMM				CMM			
24.	.937 \pm .005 bring into inspection 2 times a shift	64		CMM				CMM			
25.	(3X) BSC 90 ° bring into inspection 2 times a shift	64		CMM				CMM			
26.	(4X) Rad BSC .97 bring into inspection 2 times a shift	64		CMM				CMM			
27.	BSC 103 ° bring into inspection 2 times a shift	64		CMM				CMM			
* 41.	ϕ 1.499/1.501	56	Key	1.20 - 1.60 Digital Bore Matic - Hea				1.20 - 1.60 Digital Bore Matic - Hea			
* 42.	ROUND .0015 AT .060 DP bring into inspection 2 times a shift	56	Key	CMM				CMM			
* 43.	ROUND .002 AT .200 DP. bring into inspection 2 times a shift	56	Key	CMM				CMM			
44.	TP ϕ .04 A T bring into inspection 2 times a shift	64		CMM				CMM			
* 45.	.61 \pm .01	64		1-2 Depth Micrometer				1-2 Depth Micrometer			
* 46.	.91 \pm .01	64		0 - 1 Depth Micrometer				0 - 1 Depth Micrometer			
47.	C/R .005/.010	64		MOLD Comparator				MOLD Comparator			
* 48.	NOTE # 2	64		NOTED				NOTED			
* 49.	NOTE # 3	64		NOTED				NOTED			
* 50.	10 KEY CHARS.	64		NOTED				NOTED			
* 51.	<u>PII</u> hold to 20 micro	64	Key								

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28.	BSC 1.00 bring into inspection 2 times a shift	64		CMM				CMM				
29.	.275 ± .005 (TOOLING PTS.) bring into inspection 2 times a shift	64		CMM				CMM				
* 30.	(2X) Ø .211/.220	64		.2200 Pin Gage .2110 Pin Gage				.2200 Pin Gage .2110 Pin Gage				
* 31.	(2X) .93 ± .02	64		.2110 Pin Gage 6" Caliper				.2110 Pin Gage 6" Caliper				
* 32.	C Bore Ø .266 ± .005	64		.2610 Pin Gage .2710 Pin Gage				.2610 Pin Gage .2710 Pin Gage				
* 33.	(2X) .08 ± .01	64		.2610 Pin Gage 6" Caliper				.2610 Pin Gage 6" Caliper				
* 34.	(2X) 1/4 - 28 UNF 28	64		1/4 - 28 UNF 28 Thread Gage P.I .2311 1/4 - 28 UNF - 28 LIETECH THD. PLU				1/4 - 28 UNF 28 Thread Gage P.I .2311 1/4 - 28 UNF - 28 LIETECH THD. PLU				
* 35.	(2X) .75 MIN. FULL THD.	64		1/4 - 28 UNF 28 Thread Gage P.I .2311 6" Caliper 1/4 - 28 UNF - 28 LIETECH THD. PLU				1/4 - 28 UNF 28 Thread Gage P.I .2311 6" Caliper 1/4 - 28 UNF - 28 LIETECH THD. PLU				
36.	TP Ø .05 Z T Y bring into inspection 2 times a shift	64		CMM				CMM				
37.	BSC Ø 2.261	64		6" Caliper				CMM				
38.	BSC 2.00 bring into inspection 2 times a shift	64		CMM				CMM				
39.	BSC 1.00 bring into inspection 2 times a shift	64	Key	CMM				CMM				
40.	BSC .99 (TOOLING PT.) bring into inspection 2 times a shift	64		CMM				CMM				