

# Specification of measuring tooling equipment

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## 1. General direction

General direction for tools, models and fixtures are specified in the tool design and construction information or at 2D-drawings which are prepared by Mubea Carbo Tech.

Description MCRP1, MCRP2 etc.

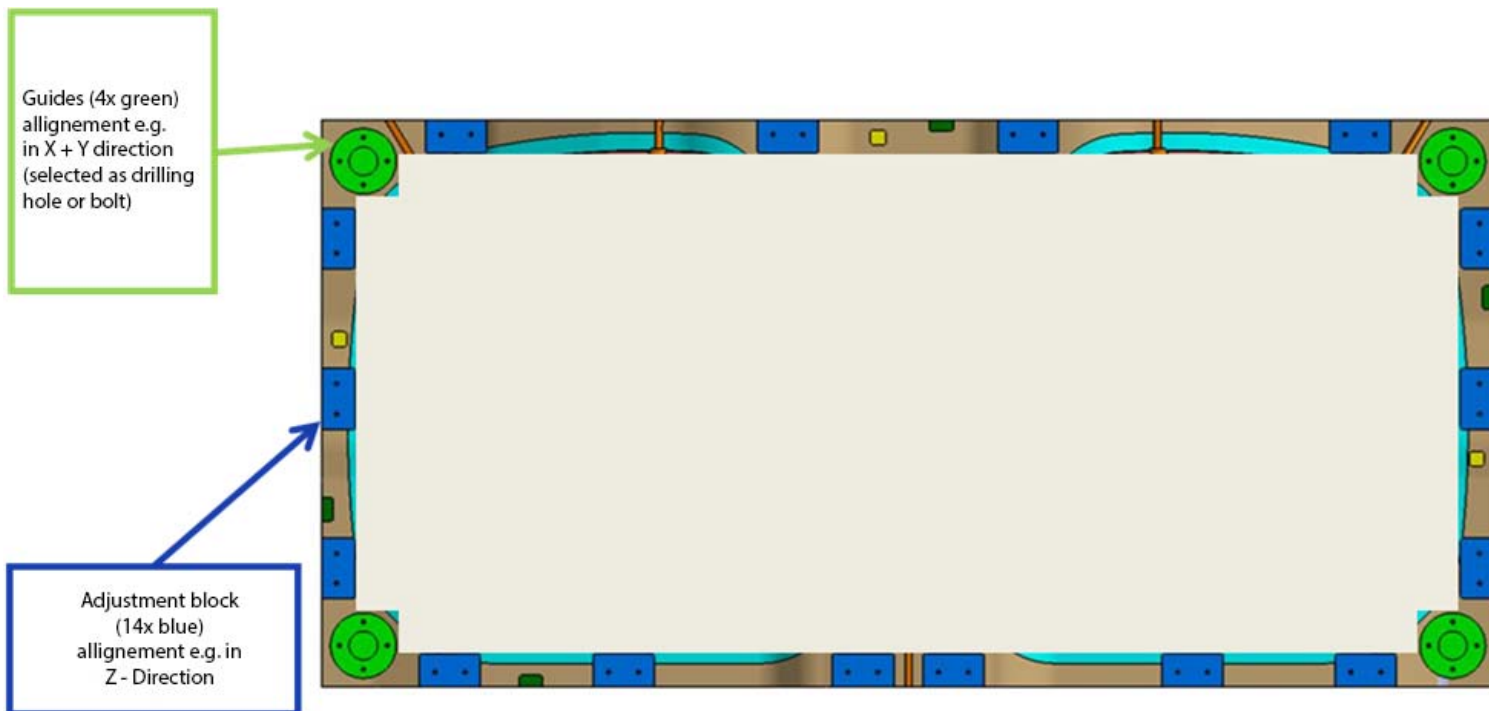


Fig 1. Direction for tools, models and fixtures

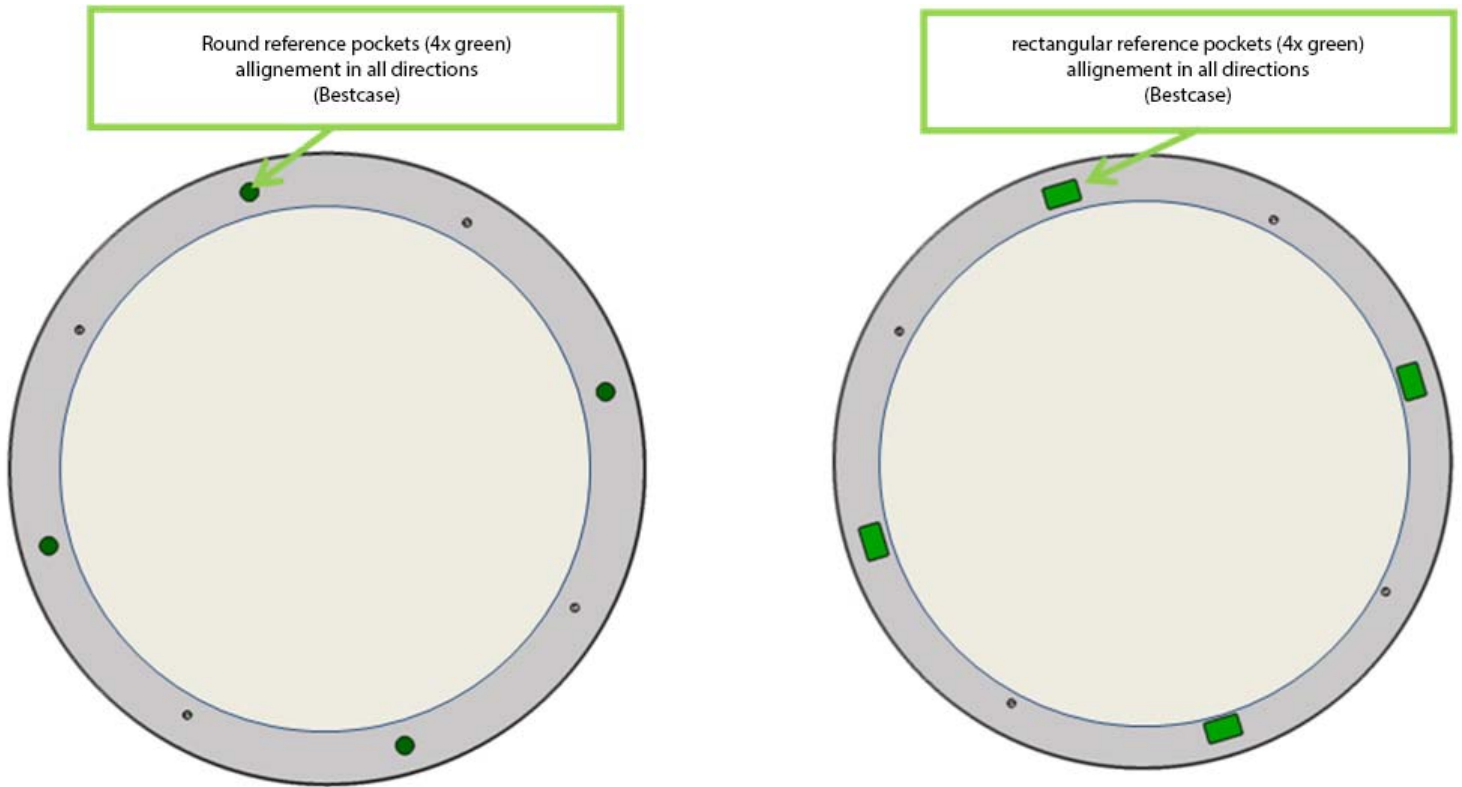


Fig 2. Direction for tools, models and fixtures

## 2. Measuring surface

### 2.1. Measuring pattern

The measuring pattern are according to component size which are shown in table below.

Description MCP1, MCP2 etc.

Specification of measuring pattern according to component size				
	from/to	from/to	from/to	from/to
dimension mm	100-400	400-750	750-1200	ab 1200
	all	all	all	all
point of measurement mm	50	75	100	150

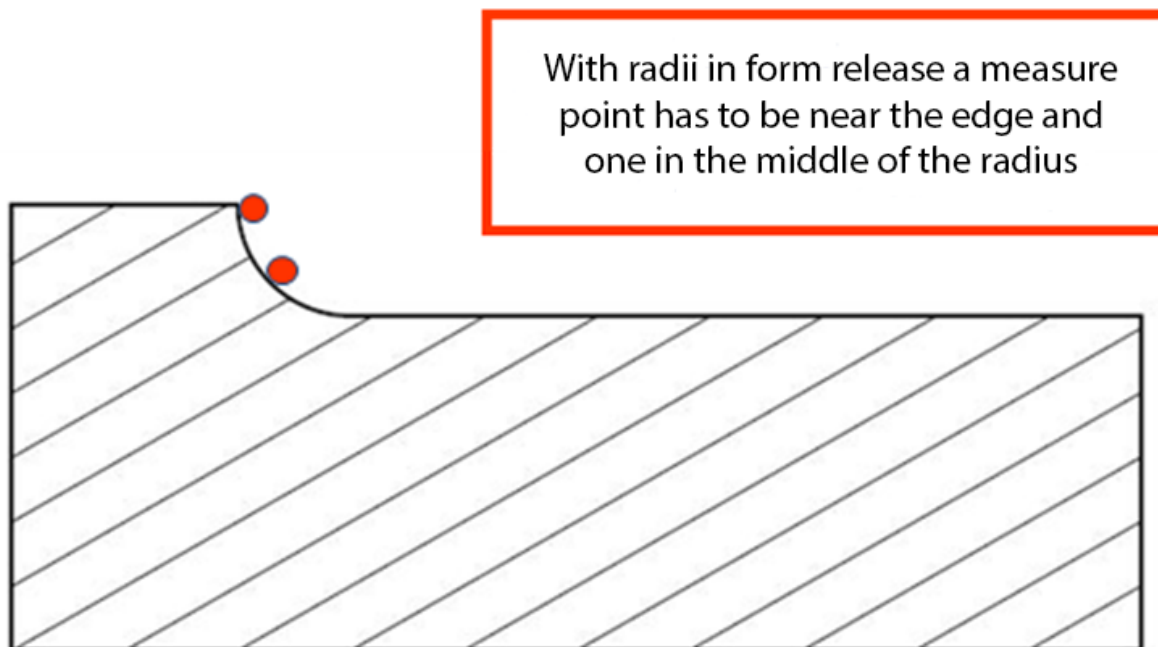
#### Attention!

The dimensions are in relation of component size, not of outer dimension of the tool, model or fixture.

For example: component size 500x1050mm addict measuring pattern of 75x100mm

## 2.2. Radius at mould release

Description MCPR1 etc.



## 2.3. Measuring drilling

100% measuring of drilling inside of part which are bigger than 5mm.

Description MCKR1 etc.

## 3. Measuring return or mould release

For measurements of return or mould release 30% of drilling have to include one surface point next to drilling.

Description MCKRE1 (drilling) or MCPRE1 (surface point) etc.

## 4. Submission and release of measuring reports

Measuring reports have to be sent, prior to the delivery to responsible buyer.

The release for delivery must be given by the Quality Assurance department, after checking of the measuring report.

A delivery of tooling without release is only allowed in exceptional cases and after consulting of the Quality Assurance department.

signed Karin Leupold, 19.04.2016

approved MCT/QM, date