

MEASUREMENT OF DIFFERENT TRAY STACKS CENTRICITY . TRAYS FROM THE SAME FAMILY. TO VERIFY IF THE TRAY STACKS WILL FIT INTO THE JKT A2 TRAY DENESTER SET UP.



A2

DATE	UPDATED 24.01.2017 04.10.2015	LENGTH	227,5	WIDTH	178,5	LENGHT	229	WIDHT	180
RAPPORT NO	JKT TRAY REFERENCE MEASUREMENT - TEST MEASUREMENT DEVICE SET UP.					JKT ACCEPTED			
PROJECT	CENTRICITY MEASUREMENT OF DIFFERENT TRAY STACKS		1,5	1,5		229	180		
COMMENTS	MEASUREMENT CARRIED OUT WITH A TRAY STACK AT 50 MM. H		-1	-1		226,5	177,5		
	Test results with the LARGEST tolerances, is used below LTR	JKT MAXIMAL ACCEPTABLE TRAY STACK CENTRICITY TOLERANCE	2,5	2,5	2,5				
DOCUMENT TITLE	JKT TRAY STACK CENTRICITY 2227 Fam. LTR 2017-01								
SIGN	FAAC								
	TEST RESULTS - PERFORMED BY JKT - WITH REFERENCE TILL THE JKT TEST SET UP								
	DATA, FROM THE TRAYS RESPECTIVE DATA SHEETS, TO BE FILLED IN MANUALLY								
	TRAY STACK ALLOWED CENTRICITY MEASUREMENT MIN. / MAX. WITH REFERENCE TILL THE DATA SHEET								
	BEFORE TEST - THE TRAY STACK MEASUREMENT FITS INTO THE JKT TEST SET UP	Q	BEFORE TEST / THE TRAY STACK CENTRICITY L-W MEASUREMENT IS EXCEEDING (+/-) THE JKT TEST SET UP						
	AFTER TEST - THE TRAY STACK MEASUREMENT IS - OK COMPARED TO THE TRAYS DATA SHEET	R	AFTER TEST / THE TRAY STACK CENTRICITY L - W MEASUREMENT IS EXCEEDING (+/-) THE TRAY DATA SHEET						
	THE TRAY STACK ACTUAL CENTRICITY TOLERANCE - COMPARED TO THE TRAY NOMINEL MEASUREMENT								
	TEST RESULTS - THE TRAY STACKS- ALL THE WARIATIONS- WILL FIT INTO THE JKT A2 TRAY DENESTER	V	TEST RESULTS - THE TRAY STACK WILL NOT FIT INTO THE JKT A2 TRAY DENESTER						
			THE TRAYS IS STILL DENESTABLE, IN ANOTHER JKT A2 TRAY DENESTER SET UP						
			THE TRAYS IS STILL DENESTABLE						

TRAY STACK NUMBER	JKT TEST RESULTS	TRAY STACK NUMBER	TRAY MANUFACTURER	TRAY CODE	DATA SHEET AVAILABLE	TRAY ITEM NUMBER	TRAY COLOUR, COMPARTMENT HIGHT	TRAY NOMINEL MEASUREMENT	TRAY DATA SHEET CENTRICITY TOLERANCES PLUS	TRAY DATA SHEET CENTRICITY TOLERANCES MINUS	TRAY STACK MAXIMUM MEASUREMENT WITH REF. TILL THE TRAYS DATASHEET	TRAY STACK MINIMUM MEASUREMENT WITH REF. TILL THE TRAYS DATASHEET	JKT TEST RESULTS	BEFORE TESTING, THE TRAY STACK NOMINEL MEASUREMENT COMPARED TO THE JKT TEST SET UP	AFTER TEST THE TRAY STACK ACTUAL MEASUREMENT	THE TRAY STACK CENTRICITY TOLERANCE COMPARED TO THE TRAY NOMINEL MEASUREMENT	TOLERANCES EXCEEDING THE TRAY DATA SHEET INFO PLUS	TOLERANCES EXCEEDING THE TRAY DATA SHEET INFO MINUS	JKT TEST RESULTS	TOLERANCES EXCEEDING FROM THE JKT ACCEPTED PLUS	TOLERANCES EXCEEDING FROM THE JKT ACCEPTED MINUS		
													Q	R					V				
1	L	1,42	TRAY STACK	1	FP	2227-1A	Y	2227012010	W-1-30	227,50	0,90	-0,90	228,40	226,60	1,42	227,50	228,92	1,42	0,52	1,42			
	W	1,32		2	FP	2227-1D	Y	2227012074	W-1-50	227,50	0,40	-0,40	227,90	227,10	-0,05	227,50	227,45	-0,05		-0,05			
	2	L		-0,05	3	FP	2227-1F	Y	2227012027	W-1-59	227,10	0,70	-0,70	227,80	226,40	0,10	227,50	227,60	0,50		0,10		
		W		0,50	4	FP	2227-2C	Y	2227023022	B-2-30	226,70	0,70	-0,70	227,40	226,00	-0,24	227,50	227,26	0,56		-0,24		
	3	L		0,10	5	FP	2227-2F	Y	2227022076	B-2-43	226,90	0,90	-0,90	227,80	226,00	0,94	227,50	228,44	1,54	0,64	0,94		
		W		0,49	6	FP	2227-2F	Y	2227022077	W-2-43	226,90	0,90	-0,90	227,80	226,00	0,50	227,50	228,00	1,10	0,20	0,50		
	4	L		-0,24	7	FP	2227-3F	Y	2227032004	B-3-43	227,40	0,70	-0,70	228,10	226,70	-0,15	227,50	227,35	-0,05		-0,15		
		W		0,80	8	FP	2227-3K	N	2227032000	W-3-53	227,80	0,70	-0,70	228,50	227,10	0,09	227,50	227,59	-0,21		0,09		
	5	L		0,94	9	FP	2227-3F	N	2227032005	W-3-43	227,50	0,70	-0,70	228,20	226,80	-0,04	227,50	227,46	-0,04		-0,04		
		W		0,97	10	MCP	.2016	N		B-1-36	227,50	0,70	-0,70	228,20	226,80	0,02	227,50	227,52	0,02		0,02		
	6	L		0,50	11																0,00		
		W		1,29	12																0,00		
7	L	-0,15	DATA FROM THE TRAYS DATA SHEET																				
8	W	-0,51	TRAY STACK CENTRICITY MEASUREMENT CALCULATION, AND COMPARED TO THE TRAYS DATA SHEET																				
9	L	0,09	JKT VERIFICATION																				
9	W	0,09	TRAY STACK	1	FP	2227-1A	Y	2227012010	W-1-30	178,50	0,90	-0,90	179,40	177,60	1,32	178,50	179,82	1,32	0,42	1,32			
	10	L		-0,04	2	FP	2227-1D	Y	2227012074	W-1-50	179,00	0,40	-0,40	179,40	178,60	0,50	178,50	179,00	0,00		0,50		
		W		-0,08	3	FP	2227-1F	Y	2227012027	W-1-59	177,50	0,70	-0,70	178,20	176,80	0,49	178,50	178,99	1,49	0,79	0,49		
	11	L		0,02	4	FP	2227-2C	Y	2227023022	B-2-30	177,90	0,70	-0,70	178,60	177,20	0,80	178,50	179,30	1,40	0,70	0,80		
		W		0,13	5	FP	2227-2F	Y	2227022076	B-2-43	178,10	0,90	-0,90	179,00	177,20	0,97	178,50	179,47	1,37	0,47	0,97		
	12	L			6	FP	2227-2F	Y	2227022077	W-2-43	178,10	0,90	-0,90	179,00	177,20	1,29	178,50	179,79	1,69	0,79	1,29		
		W			7	FP	2227-3F	Y	2227032004	B-3-43	178,20	0,70	-0,70	178,90	177,50	-0,51	178,50	177,99	-0,21		-0,51		
	12	L			8	FP	2227-3K	N	2227032000	W-3-53	177,90	0,70	-0,70	178,60	177,20	0,09	178,50	178,59	0,69		0,09		
		W			9	FP	2227-3F	N	2227032005	W-3-43	178,60	0,70	-0,70	179,30	177,90	-0,08	178,50	178,42	-0,18		-0,08		
					10	MCP	.2016	N		B-1-36	178,50	0,70	-0,70	179,20	177,80	0,13	178,50	178,63	0,13		0,13		
					11																0,00		
					12																0,00		

