



Part : black-pipe  
 Date : 9.09.2008 12:32  
 Name : itp  
 User : ITP Demo.  
 Machine : ITP HA180  
 Part info : Demo. Black Pipe

# Sample Inspection Report

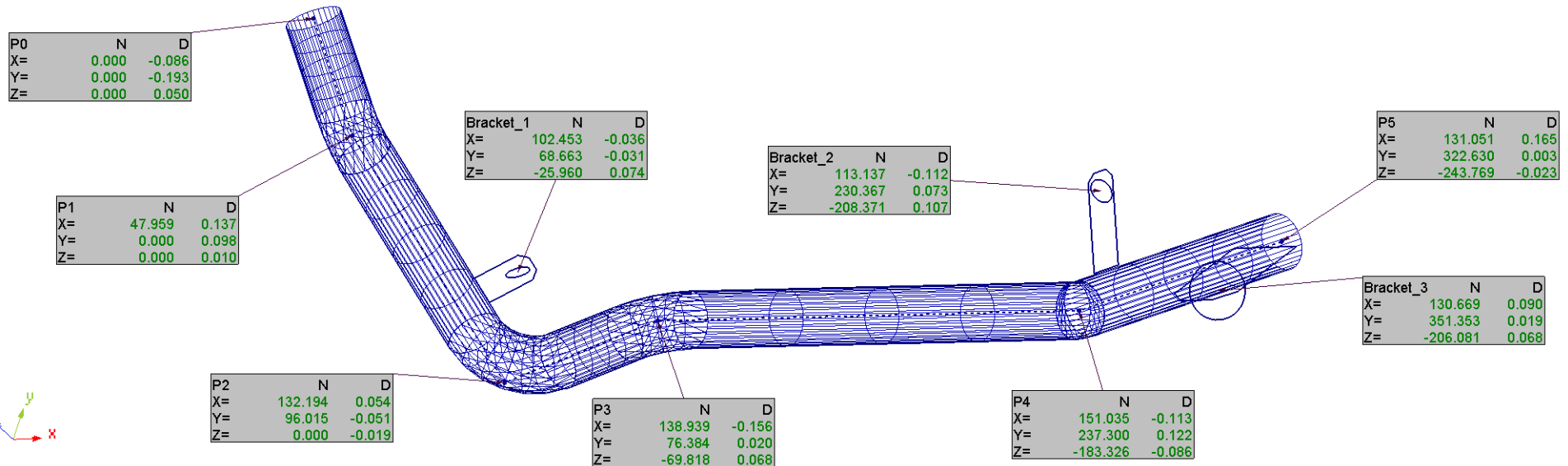
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ISO



Pipe_1 (deviations)	No of data: 0/0 pts	Coordinates: BestFit_coord			B°	C°	Dir°
	dX	dY	dZ	Env1	Env2	Y[mm]	
0	0.09	0.19	-0.05				
1	-0.14	-0.10	-0.01	0.20	0.04	-0.31	0.37
2	-0.05	0.05	0.02	0.04	0.07	0.11	-0.09
3	0.16	-0.02	-0.07	0.03	0.11	0.14	-0.07
4	0.11	-0.12	0.09	0.16	0.12	-0.21	0.14
5	-0.17	0.00	0.02	0.08	0.17	0.16	0.10

Tolerance band 1.00 mm [PASS]  
 Total length of measured tube 533.93 mm  
 Total length of nominal tube 533.99 mm  
 Tangent length 445.22 mm  
 Tangent length nominal 445.10 mm  
 Distance between centres of end faces measured 425.34 mm  
 Distance between centres of end faces nominal 425.07 mm  
 Total bend 231.03°  
 Total rotation 329.46°



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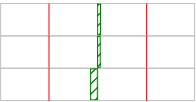
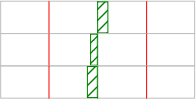

Pipe_1 (nominals)		Coordinates: <machine>						
	X	Y	Z	Y[mm]	B°	C°	Bend	Dia
0	0.00	0.00	0.00					
1	47.96	0.00	0.00	37.99		48.74	22.00	21.67
2	132.19	96.01	0.00	92.39	-104.47	98.14	22.00	21.67
3	138.94	76.38	-69.82	31.98	138.81	70.29	22.00	21.67
4	151.04	237.30	-183.33	179.04	-86.06	14.33	22.00	21.67
5	131.05	322.63	-243.77	103.69				21.67

Pipe_1 (unadjusted)		Coordinates: <element>						
	X	Y	Z	Gap	Y[mm]	B°	C°	Dia
0	0.00	0.00	0.00					
1	48.18	0.00	0.00	0.02	38.30		48.37	21.80
2	132.91	95.36	0.00	0.02	92.28	-104.38	98.16	21.96
3	139.39	75.73	-69.72	0.19	31.85	138.88	70.26	22.01
4	152.59	236.62	-183.44	0.16	179.25	-86.20	14.24	21.81
5	133.45	321.92	-243.87		103.54			21.88

Pipe_1 (adjusted)		Coordinates: BestFit_coord		
	X	Y	Z	
0	-0.09	-0.19	0.05	
1	48.10	0.10	0.01	
2	132.25	95.96	-0.02	
3	138.78	76.40	-69.75	
4	150.92	237.42	-183.41	
5	131.22	322.63	-243.79	

Pipe_1 (deviations)		Coordinates: BestFit_coord							
	dX	dY	dZ	Env1	Env2	Y[mm]	B°	C°	Dir°
0	0.09	0.19	-0.05						
1	-0.14	-0.10	-0.01	0.20	0.04	-0.31		0.37	0.35
2	-0.05	0.05	0.02	0.04	0.07	0.11	-0.09	-0.02	0.02
3	0.16	-0.02	-0.07	0.03	0.11	0.14	-0.07	0.02	0.16
4	0.11	-0.12	0.09	0.16	0.12	-0.21	0.14	0.10	0.02
5	-0.17	0.00	0.02	0.08	0.17	0.16			0.13

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<b>Bracket_1</b>		No of data: 3/3 pts	Coordinates: BestFit_coord					
		Measured	Nominal	Deviation	Up-Tol	Lo-Tol	in/out	
	X	102.417	102.453	-0.036	0.500	-0.500	in	
	Y	68.632	68.663	-0.031	0.500	-0.500	in	
	Z	-25.886	-25.960	0.074	0.500	-0.500	in	
<b>Bracket_2</b>		No of data: 3/3 pts	Coordinates: BestFit_coord					
		Measured	Nominal	Deviation	Up-Tol	Lo-Tol	in/out	
	X	113.025	113.137	-0.112	0.500	-0.500	in	
	Y	230.440	230.367	0.073	0.500	-0.500	in	
	Z	-208.264	-208.371	0.107	0.500	-0.500	in	
<b>Bracket_3</b>		No of data: 3/3 pts	Coordinates: BestFit_coord					
		Measured	Nominal	Deviation	Up-Tol	Lo-Tol	in/out	
	X	130.759	130.669	0.090	0.500	-0.500	in	
	Y	351.372	351.353	0.019	0.500	-0.500	in	
	Z	-206.013	-206.081	0.068	0.500	-0.500	in	