

Guidelines for Measurement Points 测量点指导方针	CHECKING FIXTURE DESIGN SPECIFICATION 检具设计规范
1、 Definition of level 1,2, 3 & 4 points 1、2、3、4级点的定义	1.1 Level 2 are a sub set of level 1, Level 3 are a sub set of level 2, and so on. 2级点是1级点的子集，3级点是2级点的子集，以此类推。 1.2 Level 1: Are the maximum number of points to be measured to verify every component feature e.g. trim lines, ribs etc meet design intent. 1级点：用于模具开发初期，供应商调整模具精度。 1.3 Level 2: Are used for quality assessment e.g. Die Buyoff, PSW sign. 2级点：又名全尺寸测量点，用于计算零件PIST 1.4 Level 3: Are used for PSW to assure process consistency and should be continued to be measured until Process Capability is demonstrated. 3级点：用于衡量过程能力是否稳定。 1.5 Level 4. Are the minimum number of points that must be measured to assure on going process control. 4级点：在线生产过程控制的测量点
2、 L2 Measurement Points 2级测量点	2.1 Cut lines on outer skin panels are to be read out for margin and flushness as follows: 外板件的间隙和段差测量点确定规则如下： <ul style="list-style-type: none"> ● At 50mm intervals for straight areas. 直面间隔50mm ● At 25mm intervals for sweeping areas or radii. 对于圆弧面和曲面,间隔25mm 2.2 Mating surfaces, seal surfaces, flanges, and trim lines are to be read out at 50mm intervals. 配合面/密封面,翻边,切边间隔50mm 2.3 Holes, other than weight-reduction holes, are to be measured for location and size. 减重孔除外, 孔的位置和尺寸要测量出来 2.4 A point within 2mm of the tangent of each radius must be measured. 圆弧切线2mm以内的点需要测量 2.5 All form features are to have at least three points per line. 所有特征形面每线至少测量3点 2.6 Grid the product surface into 100mm and check at least one point 产品表面100mm的网格至少有一个测量点 2.7 Level 2 points are a subset of level 1 points and must include level 3 points. 二级点是一级点的子集且包括三级点