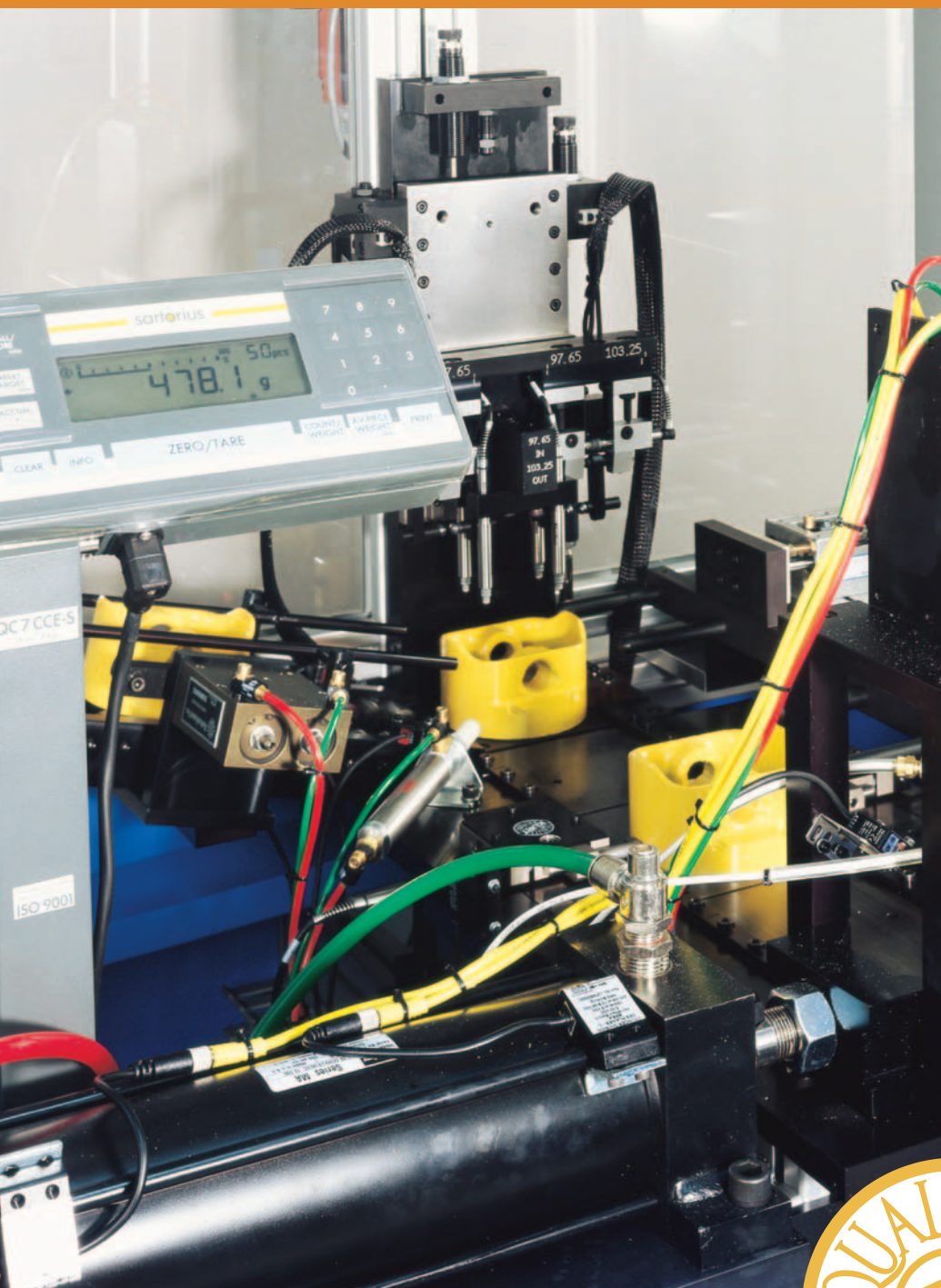


# In Line Inspection after rough turning of piston casting



## Case Study #639

- 100% Variable Inspection
- Attribute check of wrist pin hole
- Marks all parts accepted
- Segregation of all non conforming product
- 4 second cycle time
- Changeover for 5 specific Pistons



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Tolerance	Feature
±0.25mm	Diameter of Piston
±5 grams	Weight of piston
±5 grams	Diameter to weight ratio
±1mm	Ledge height
±1mm	Ledge height parallelism
±0.500mm	Sump depth

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