



CHECK FIXTURE STANDARDS

- Supplier is responsible for cost of design and construction of check fixture to the data provided.
- Design shall be done on CAD. The final CAD design shall be provided upon completion.
 - If 2D data must be DXF or IGES format (PDF may also be included)
 - If 3D data must be STEP or Parasolid (PDF may also be included)
- Check fixture is to be designed and built to a maximum of 10% of part feature tolerance or .025mm (.001"), whichever is more.
- Check fixture will be checked using dimensions of orientation from Datum's A, B and C (0, 0, 0 start point).
- Ridgeview design approval is required before beginning construction.
- Check fixture less than 10 lbs requires no feet, check fixture 10-30 lbs requires feet and a check fixture more than 30 lbs requires 2" high risers.
- Go/no-go plug gages mounted in base plate and identified with feature of size stamped in base of fixture.
- Go/no-go plug gages for slots must check length and width independent from each other.
- Go/no-go plug gages with a greater than .1mm tolerance will only need a go plug gage.
- Set masters shall be provided to a nominal standard of 31.00mm and marked "zero set".
- Set Master bushing size must be 3/8 diameter.
- All steel components to be treated with Commercial Black Oxide or an equivalent.
- Locating holes for pins (including zero set and variable data collection points) are to have hardened bushings.
- All oval pins and bushings must be keyed and /or orientated to suit.
- Multiple feelers on any gage shall be identified using a stamped number with the corresponding feeler surface stamped the same.
- All checking surfaces shall be identified with "V's".
- Feeler pins are to be secured to base and bent to the appropriate angle to facilitate use if applicable.
- A "property of" tag shall be affixed, or the information stamped directly, in an appropriate location on the base. The tag/information to be supplied.
- Captured stabs where applicable.
- If digital indicators are needed, they will be provided by Ridgeview Industries.
- A layout report concerning finished check fixture shall be provided at the time of delivery. All layout reports must be from an ISO 17025 or A2LA certified source.
- The check fixture design must denote the rotations to "in car" position. All rotations are to come from the same origin.
- Check fixture certifications layouts are to match how the check fixture was built ("in car" or "out of car")