



Advanced Inspection Services, LLC

The Premiere Dimensional Inspection Lab of the Midwest



15150 25th Avenue North | Suite 200 | Plymouth | MN | 55447 | P: 763.473.2258 | F: 763.249.8150
www.advancedinspect.com

CERTIFICATE OF INSPECTION

Issued to:

Certificate Number:	3031234-001	Pretend Technologies
Cert Revision:	Initial	Ada Shinier
Report Issue Date:	1/8/2024	123 Fake Street
		Frostbite Falls MN 54321

This is to certify that all inspections were performed per industry standards by trained, qualified inspectors using equipment that is traceable to NIST.

Part Name:	Wonder Widget		
Part Number:	123456-001	Date Received:	1/2/2024
Part Revision:	A		

These results relate only to the items inspected or tested referenced in this document.

UNCERTAINTY STATEMENT

In accordance with our procedures, we perform uncertainty tests on our equipment. The following measurement instruments were used to inspect your parts.

Asset #	Description	Serial #	Cal Due	*Uncertainty (µin)
PQI 188	Mitutoyo Digital Caliper 0" - 6"	05419080	6/15/2024	512 + 0*L
PQI 221	Electronic Drop Indicator	004634	11/30/2024	120 + 0*L
PQI 397	OGP Quest 250 X Y	SQ2501057	1/31/2024	67 + 2.9*L
PQI 561	Global S Blue 122210 (scanning)	0422-6535UA	8/30/2024	120 + 3.3*L

*This uncertainty represents an expanded uncertainty expressed at approx. the 95% confidence level using a coverage factor of k=2.

Metrologist:

Talmudge McGulager

Manager:

Diana McInerny

This Certificate of Inspection may not be reproduced, except in full, without the written approval of Advanced Inspection Services.



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GENERAL NOTES:

- As a protection to our clients and Advanced Inspection Services, all client data, reports and drawings are considered and treated as confidential. Retention is 7 years before destruction, unless contracted otherwise.
- A simple acceptance decision rule, in accordance to ASME B89.7.3.1 2001, applies for conformance verification.
- Unless otherwise specified, 5.4_101 Inspection Method was applied during measurement.
- Inspection lab temperature is maintained at 68° F
- Where "Ref" is seen in place of an uncertainty value for any piece of equipment listed on Page 1 of this cert, indicates results obtained with that equipment is outside the scope of our current ISO 17025 accreditation. This is further indicated with an asterisk (*) in the "Scope" column of our report template.
- Definitions: UTAM = Unable To Accurately Measure
 UTDF = Unable To Determine Feature
 FNP = Feature Not Present

REVISION NOTES:

Initial: Initial Release of Report.

INSPECTION NOTES:

Failures remeasured for verification; found similar results



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Inspection Results For Pretend Technologies

Certificate No	3031234-001	Part Name	Wonder Widget
Cert Revision	Initial	Part Number	123456-001
Inspection Date	01/08/2024	Revision	A
Inspector	Talmudge McGulager	Report Units	Inches
Report Issue Date	01/08/2024		

Actual measurement is between 80% and 100% of tolerance.
 Actual measurement is out of tolerance.

[See additional report notes on Page 2 of the certificate.](#)

ITEM #	1		2		3		4	
NOMINAL	1.0000	S	0.2850	S	0.1400	S	0.0800	S
+ TOL.	0.003	T	0.003	T	0.005	T	0.003	T
- TOL.	0.003	A	0.003	A	0.005	A	0.003	A
DESCRIP.	Diameter	T		T		T		T
EQUIP.	DCC CMM	U	Vision CMM	U	Caliper	U	Drop Indicator	U
SCOPE		S		S		S		S
USL	1.0030		0.28800		0.14500		0.08300	
LSL	.9970		0.28200		0.13500		0.07700	
80% USL	1.0024		0.28740		0.14400		0.08240	
80% LSL	.9976		0.28260		0.13600		0.07760	
MEAN	1.0016		0.28448		0.13970		0.08055	
MAX	1.0025		0.28700		0.14200		0.08300	
MIN	1.0000		0.28200		0.13600		0.07600	
RANGE	.0025		0.00500		0.00600		0.00700	
STD_DEV	.0008		0.00168		0.00181		0.00219	
Pp*	1.2238		0.59460		0.91902		0.45736	
PpK*	.5752		0.49154		0.86388		0.37351	
1	1.0024		0.2834		0.139		0.0814	
2	1.0025		0.2838		0.1395		0.0816	
3	1.0019		0.282		0.142		0.083	
4	1.0015		0.283		0.141		0.081	
5	1.0021		0.2832		0.14		0.078	
6	1.0009		0.2862		0.138		0.076	
7	1.0000		0.287		0.136		0.079	
8	1.0012		0.2864		0.141		0.082	
9	1.0024		0.2854		0.139		0.0813	
10	1.001		0.2844		0.1415		0.0822	



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Item	Part / Feature	Equipment Used	Score	Nominal	+Tol	-Tol	Record 1		Record 2	
							Actual	Deviation	Actual	Deviation
1	Diameter	DCC CMM		1.0000	0.0030	0.0030	1.0024	0.0024	1.0021	0.0021
2		Vision CMM		0.5000	0.0030	0.0030	0.5031	0.0031	0.5029	0.0029
3	Diameter (RFS)	DCC CMM		0.2000	0.0030	0.0030	0.2004	0.0004	0.2003	0.0003
	TP .005 A B C	DCC CMM		0.0000	0.0050		0.0028	0.0028	0.0028	0.0028
	X Basic	DCC CMM		0.0000			0.0011		0.0012	
	Y Basic	DCC CMM		0.0000			0.0009		0.0007	
4		Vision CMM		0.2850	0.0030	0.0030	0.2834	-0.0016	0.2838	-0.0012
5		Vision CMM		0.1450	0.0030	0.0030	0.1433	-0.0017	0.1429	-0.0021
6	Profile 0.003 A			0.0000	0.0030	0.0000	0.0022	0.0022	0.0028	0.0028
	Max. Negative Deviation			0.0000	0.0015	0.0015	-0.0009	-0.0009	-0.0008	-0.0008
	Max. Positive Deviation			0.0000	0.0015	0.0015	0.0011	0.0011	0.0014	0.0014
7		Vision CMM		0.2200	0.0030	0.0030	0.2202	0.0002	0.2214	0.0014
8		Caliper		0.1000	0.0050	0.0050	0.1035	0.0035	0.1030	0.0030
9		Caliper		0.1400	0.0050	0.0050	0.1390	-0.0010	0.1395	-0.0005
10		Drop Indicator		0.0800	0.0030	0.0030	0.0814	0.0014	0.0816	0.0016
11	Print Note 2: Cavity ID	Visual	*	Presence	Pass	Fail	Pass		Pass	