CHECK FIXTURE STANDARDS

1. Supplier is responsible for cost of design and construction of check fixture to the data provided.
2. Design shall be done on CAD. The final CAD design shall be provided upon completion.
    a. 2D and 3D PDF Files
    b. Cad data must be a STEP File
3. Check fixture is to be designed and built to a maximum of 10% of part feature tolerance or .025mm (.001”), whichever is more. Max build surface tolerance to be 0.1 mm or .004”
4. Check fixture will be checked using dimensions of orientation from Datum’s A, B and C (0, 0, 0 start point).
5. Ridgeview design approval is required before beginning construction.
6. 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.
7. Go/no-go plug gages mounted in base plate and identified with feature of size identified on base of fixture.
8. Go/no-go plug gages for slots must check length and width independent from each other.
9. Loose details and the four sides of the base must have RVI part number stamped or engraved
10. Set masters shall be provided to a nominal standard of 31.00mm and marked "**zero set**".
11. Set Master bushing size must be 3/8 diameter & #4-48 Thread
12. All steel components to be treated with Commercial Black Oxide or an equivalent.
13. Locating holes for pins (including zero set and variable data collection points) are to have hardened bushings.
14. All oval pins and bushings must be keyed and /or orientated to suit.
15. Multiple feelers on any gage shall be identified using a stamped letter and colored dot, with the corresponding feeler surface stamped the same. See gage check list for order.
16. All checking surfaces shall be identified with colored “V’s” and/or “Dots”.
17. Feeler pins are to be secured to base and bent to the appropriate angle to facilitate use if applicable.
18. An “information” and “property of / asset” tag shall be affixed on the base in the back or an area not accessible to set parts on to prevent damage, tag information will be supplied.
19. Captured stabs where applicable.
20. If digital indicators are needed, they will be provided by the Check Fixture source.
21. A layout report concerning finished check fixture shall be provided at the time of delivery. All layout reports must be from a certified source.
22. The check fixture design must denote the rotations to “in car” position. All rotations are to come from the same origin.
23. Check fixture certifications layouts are to match how the check fixture was built (“in car” or “out of car”) and must have “IJK” vectors included.

Rev	Date/When	Changes/What	Name/Who
D	11/6/2009	All form was updated for optimization	RVI
E	12/8/2023	Line No. 2 Revised- 2D and 3D PDF Files Cad data must be a STEP File	Russell Voogt
		Line No. 3 Added - Max build surface tolerance to be 0.1 mm or .004”	
		Line No. 7 Replaced - “stamped in” with “identified on”	
		Line No. 9 Replaced with – “Loose details and the four sides of the base must have RVI part number stamped or engraved”	
		Line No. 15 Revised with – “stamped letter and colored dot” & “See gage check list for order”	
		Line No. 16 Revised with- “colored “V’s” and/or “Dots”.	
		Line No. 18 Revised with- A “information” and “property of” tag shall be affixed on the base in the back or an area not accessible to set parts on to prevent damage, tag information will be supplied.	
		Line No. 20 Revised with – “the Check Fixture source”	
		Line No. 21 – Revised to “a certified source”	
		Line No. 23 Added – “must have “IJK” vectors included”	