

PRE DESPATCH INSPECTION REPORT  
M/S. ENDURANCE TECHNOLOGIES LTD.  
CH. SAMBHAJINAGAR

FORMAT : FIQA/PDI REV.00 DATE :- 02.03.2015

SAL INDUSTRIES

MATERIAL SPECIFICATION  
16 Mnc-5

RAW MATERIAL OWN/CUSTOMER  
SAL INDUSTRIES

PART NAME: PUSH ROD (BS - III) M & M

PART NUMBER: 520KCO0402 SAI CODE: HT402 SUPPLIER CODE: 100264 REPORT NO. F451

REVISION NO.: A08 07 2010 IDENTIFICATION MARK: GROOVE ON O.D. TO D. INSTRUMENTS / GAUGES L.C. C.O.F. C. NO. I.D. NO. IMPORTANT CRITICAL MAJOR KEY METALLURGICAL REPORT DATE: 28/07/14 NUMBER: 50851 QTY: 50 Pcs MODE OF PACKING: 1 Box

SR. NO.	PARAMETER	SPECIFICATIONS	INSTRUMENTS / GAUGES	C.O.F. C. NO.	I.D. NO.	OBSERVATIONS									
						1	2	3	4	5	6	7	8	9	10
1	LENGTH	56.00±.20	SPECIAL GAUGE VERNIER CALIPER .04	SI/SHG/402	5610	5611	5612	5610	5612	5612	5608	5612	5612	5612	5612
2	MILLING WIDTH	3.50±.70	WIDTH GAUGE	SI/MG/05	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
3	GROOVE WIDTH	1.10±.24	PROFILE PROJECTOR / SPECIAL GAUGE	SI/S/G/400	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
4	OUTER DIAMETER	9.90±.10	MICROMETER(0.01)	SI/EM/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
5	PERPENDICULARITY	0.020 W.R.T. O.D. 16	V BLOCK & DIAL(0.01)	SI/LD/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
6	SURFACE FINISH ON FACE	Ra 0.80	RUBERT CHART/VISUALLY	SI/RG/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
7	DISTANCE	20.60±.02	PROFILE PROJECTOR / SPECIAL GAUGE	SI/PP/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
8	OUTER DIAMETER	15.96±.15	AIR RING GAUGE(0.001) / PLAIN RING GAUGE	SI/RG/402	15.96	15.98	15.98	15.98	15.98	15.98	15.98	15.98	15.98	15.98	15.98
9	LENGTH	7.70±.90	VERNIER CALIPER(0.01)	SI/VC/02	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
10	SURFACE FINISH ON GR. DIA.	Ra 1.60	RUBERT CHART/VISUALLY	SI/RG/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
11	SURFACE FINISH ON O.D. 16	Ra 0.80	SURFACE FINISH TESTER(0.01) / RUBERT CHART	SI/SFT/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
12	CHAMFER	0.20 X 45° & 0.50 X 45°	VISUALLY	SI/RG/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
13	SYMMETRY	0.1	V BLOCK & DIAL(0.01)	SI/LD/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
14	MILLING DEPTH	7.90±.10	VERNIER CALIPER(0.01)	SI/VC/02	7.80	8.00	8.00	8.02	8.02	8.02	8.04	8.02	8.04	8.02	8.02
15	PARALLELITY	0.20 W.R.T. O.D. 16	V BLOCK & DIAL(0.01)	SI/LD/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
16	GROOVE DIAMETER	11.90±.12	PROFILE PROJECTOR / SPECIAL GAUGE	SI/S/G/291	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
17	LENGTH	8.90±.10	PROFILE PROJECTOR	SI/PP/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
18	GROOVE DIAMETER	15.09±.15	PROFILE PROJECTOR / SNAP GAUGE	SI/S/G/285	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
19	GROOVE WIDTH	2.90±.10	VERNIER CALIPER / WIDTH GAUGE	SI/S/G/291	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
20	CASE DEPTH & CORE HARDNESS	0.47 TO 0.66 & 35 TO 45 HRC	REFER T.C.		61	61	62	61	61	61	61	61	61	61	61
21	HARDNESS	55 TO 63 HRC	HARDNESS TESTER(1HRC)	SI/HT/01	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
22	SURFACE TREATMENT	ANTIRUST OIL	VISUALLY		OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
23	FREE FROM	GRINDING CHATTERING, BURNING MARK, BURRS DEBITS, DAMAGES, RUSTY SPOTS, SHARP EDGES	VISUALLY		OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
24	FREE FROM		VISUALLY		OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK

SURFACE PROTECTION: OILED / PLATING / PHOSPHATING / POWER COATING / BLACK OXIDIZING / ANTI RUSTING

SUPPLIER'S REMARK: SAMPLE CHECKED - DIMENSIONAL: 10

DATE: 28/07/14

SIGN: Devendra G. AINSPECTOR

DATE: 28/07/14

INSPECTOR: Devendra G. AINSPECTOR

DATE: 28/07/14

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