

TUBE INVESTMENTS OF INDIA
LIMITED
PLOT NO 45, PK8 SONAL ESTATE
KHODA, SANAND

SAMPLE INSPCETION REPORT



Doc.No.:TIGE/OA/PDI/01

CUSTOMER NAME :- ENDURANCE TECHNOLOGIESLTD	INVOICE NO :	3027010043969
MODEL NAME :- FORK PIPE MACHINING	DATE :	11-01-2024
CUSTOMER PART NO :- F2FA190330	LOT SIZE :	100 Nos
MODEL :- KOPG	SAMPLE SIZE :	05 NOS
REV. :- XD	SUPPLIER CODE :	101109

Bl.No	Parameters	Specification	Checking Instrument/L.c	Observation					Remarks
				1	2	3	4	5	
1	Total Length	288.3±0.2	Height Gauge	288.33	288.41	288.32	288.33	288.45	OK
2	Drilling length	50.50 ± 0.2	Vernier Caliper	50.68	50.62	50.61	50.52	50.68	OK
3	Hole Dia	1.5	plug gauge/Vernier	OK	OK	OK	OK	OK	OK
4	Caulking Side Run Out	0.08	Dial gauge with fixture	0.04	0.05	0.06	0.08	0.05	OK
5	Caulking Side OD	28.5	Snap Gauge/ Micrometer	28.55	28.54	28.5	28.55	28.51	OK
6	Caulking ID	26.05±0.05	plug gauge/Vernier	OK	OK	OK	OK	OK	OK
7	RM ID	24	Vernier Caliper	23.87	23.97	23.94	23.96	23.91	OK
8	Roughness	0.8	Roughness Tester	0.452	0.287	0.397	0.205	0.489	OK
9	Roughness	3.2 Ra	Roughness Tester	1.532	1.271	1.873	1.540	1.112	OK
10	RM OD	30.10 +0.05	Micrometer	30.107	30.134	30.126	30.102	30.111	OK
11	Circularaty	0.01	Calculated with Micro meter	0.004	0.006	0.005	0.007	0.004	OK
12	Straightness	0.06/200	Dial gauge with fixture	0.040	0.050	0.020	0.030	0.020	OK
13	Groove Width	8.6	Contracer	8.6601	8.9596	8.4140	8.4300	8.4492	OK
14	Radius	R17	Contracer	17.0358	17.9116	17.9924	17.9024	17.8221	OK
15	Roughness	Rz 25	Roughness Tester	5.420	5.262	5.266	5.413	5.334	OK
16	OD	29.0±0.1	PP	29.032	29.028	29.121	29.079	29.016	OK
17	Chamfer	0.2±0.2 x 45°±0'30'	Contracer	0.3814 * 45°26'33"					OK
18	angle	2° ± 1°	Contracer	1°33'49"	1°34'11"	1°33'26"	1°34'52"	1°31'31"	OK
19	Caulking side width	4 ± 0.1	Contracer	4.082	4.090	4.097	4.094	4.090	OK
20	Caulking side width	10 ± 0.2	Contracer	10.095	9.973	10.052	10.028	10.042	OK
21	Outer Chamfer	0.25±0.2 x 45°±0'30'	Contracer	0.1646 * 45°18'40"	0.1617 * 45°28'52"	0.2746 * 45°00'45"	0.1583 * 45°23'50"	0.1715 * 45°26'24"	OK
22	Inner Chamfer	0.50±0.2 x 45°±0'30'	Contracer	0.5851 * 45°12'44"	0.6738 * 45°05'53"	0.6020 * 45°02'23"	0.6591 * 45°26'32"	0.6124 * 45°25'47"	OK
23	Caulking Bore Depth	46.10 + 0.10	plug gauge/Vernier Caliper	46.15	46.14	46.12	46.13	46.14	OK
24	Groove Width	10.00 ± 0.2	PP	9.970	10.100	10.062	10.100	10.006	OK
25	Dimension	1 ± 0.2	Contracer	1.184	1.194	1.179	1.190	1.189	OK
26	Angle	15°±0'30'	Contracer	14°49'41"	15°26'49"	15°22'14"	14°39'47"	14°55'43"	OK
27	Radius	R 0.65 ± 0.2	Contracer	0.4980	0.4070	0.4467	0.4581	0.4762	OK
28	Radius	R 6 ± 0.5	Contracer	6.4324	6.4421	6.4123	6.3243	6.4574	OK
29	Roughness	Rz 25	Roughness Tester	12.166	11.669	12.046	12.623	11.942	OK
30	Dimension	1 ± 0.2	Contracer	1.1460	1.1040	1.1041	1.1421	1.1235	OK
31	chamfer	45°±0'30'	Contracer	45°25'45"	45°11'40"				OK
32	Clip Side total boring	26.3±0.1	ID Gun	26.338	26.342	26.348	26.337	26.359	OK
33	Clip Side total borinh ID	27.5±0.1	Contracer	24.4632	274956	27.4481	27.3482	27.51	OK
34	Chamfer	30°±0'30'	Contracer	30°21'36"	30°10'16"				OK
35	Clip Side boring	26.5±0.1	ID Gun	26.489	26.53	26.51	26.349	26.469	OK
36	Groove Dia	28.20 -0.2	PP	28.162	28.083	28.095	28.145	28.139	OK
37	Clip Size	1.85	Contracer	1.5174	1.5938				OK

38	ID Depth	3+0.1	Contracer	3.081	3.092	3.012	3.062	3.037	OK
39	Runout	0.1 wrt OD	HG/Dial	0.05	0.04	0.07	0.04	0.06	OK
40	Dimension	19+0.2/-0	Vernier Caliper	19.13	19.12	19.04	19.10	19.17	OK
41	angle	5° ± 1°	PP	5°14'36"	5°47'29"	5°29'40"	5°39'42"	5°14'31"	OK
42	Caulking SideOD	29.92 ± 0.2	PP	29.96	29.83	29.94	29.98	29.95	OK
43	Radius	25.71	Contracer	25.243	25.771	25.057	25.053	25.659	OK
44	Caulking side width	14.72	Contracer	15.567	14.559	15.807	15.559	15.069	OK
45	Free From Burr, Dent & Scratch Mark after Machining		Visual	OK	OK	OK	OK	OK	OK
46	No Leakage at 5kgf/cm2 Min Air Pressure		Visual	OK	OK	OK	OK	OK	OK
47	Apply Rust Preventive Oil		Visual	OK	OK	OK	OK	OK	OK

Remark :- OK



INSPECTED BY :- Abishek Yadav



APPROVED BY :- Palak Shah