

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

SAMPLE INSPCETION REPORT



CUSTOMER NAME :-	ENDURANCE TECHNOLOGIES LTD	INVOICE NO :	3027010044424
MODEL NAME-	Fork Pipe Machined	DATE :	23-Jan-24
CUSTOMER PART NO :-	F1FA013330	LOT SIZE :	110 NOS
MODEL:-	(K86A)	SAMPLE SIZE :	05 NOS
REV. :-	XB		

Sr.No	Parameters	Specification	Inspection Method	Observation					Remarks
				1	2	3	4	5	
1	RM OD	30.1 +0.05	Micrometer	30.15	30.14	30.14	30.16	30.14	OK
2	RM ID	24	Vernier Caliper	23.88	23.88	23.91	23.89	23.91	OK
3	Total Length	288.3 ± 0.2	Height Gauge	288.35	288.45	288.46	288.34	288.36	OK
4	Caulking Side OD	28.5	Snap Gauge/ Vernier	28.60	28.66	28.60	28.59	28.54	OK
5	Caulking ID	26.05+0.05	plug gauge/Vernier	26.07	26.08	26.07	26.07	26.07	OK
6	Caulking Side Run Out	0.08	Dial gauge with fixture	0.04	0.05	0.03	0.03	0.05	OK
7	Drilling length	50.50 ± 0.2	Vernier Caliper	50.50	50.60	50.57	50.55	50.58	OK
8	Drill Hole	1.5	STD Pin	1.48	1.52	1.54	1.50	1.48	OK
9	Caulking side surface RA	3.2	Roughness Tester	1.33	1.334	1.977	1.495	1.547	OK
10	RM ID RA	0.8	Roughness Tester	0.215	0.121	0.187	0.290	0.347	OK
11	Circularity	0.01	Micrometer	0.008	0.006	0.007	0.009	0.004	OK
12	Straightness	0.06/200	Dial gauge with fixture	0.01	0.03	0.04	0.04	0.03	OK
13	OD after turning	29.92	PP	29.851	29.989	29.924	29.937	29.955	OK
14	OD turning length	4	Contracer/PP	4.084	4.097	4.094	4.098	4.073	OK
15	OD turning length	10	Contracer/PP	10.188	10.191	9.956	10.132	10.030	OK
16	OD turning length	14.72	Contracer	17.7281	15.8933	16.1135	16.1398	17.8638	OK
17	Radius	R25.71	Contracer/ Machine Program	25.8706	25.2722	25.1808	25.6244	25.0878	OK
18	chamfer	0.25X45°	Contracer/PP	0.2245*45°11'47"	0.2038*44°41'47"	0.2125*44°47'50"	0.2027*44°56'17"	0.2157*44°45'36"	OK
19	chamfer	0.5X45°	Contracer/PP	0.5861*45°12'44"	0.5421*45°11'38"	0.5011*45°18'37"	0.5523*44°37'39"	0.5567*45°28'54"	OK
20	Angle	2°	Contracer/PP	1°10'30"	1°55'43"	1°15'22"	1°10'54"	1°28'39"	OK
21	Roughness	3.2 Ra	Roughness Tester	1.705	1.209	1.240	1.267	1.125	OK
22	Radius	R17	Contracer/PP	17.7097	17.8916	17.8746	17.3117	17.3056	OK
23	Chamfer	0.2X45°	Contracer/PP	0.2155*45°17'40"	0.2052*44°41'44"	0.2027*44°45'47"	0.2249*45°14'48"	0.2368*45°21'26"	OK
24	Grove	8	PP/Vernier Caliper	8.08	7.76	8.03	7.80	7.79	OK
25	Drill Radius OD	29 ± 0.1	Vernier Caliper	29.08	29.07	29.10	29.09	29.06	OK
26	Caulking Bore Depth	46.10 +0.10	plug gauge/Vernier	46.14	46.15	46.17	46.15	46.11	OK
27	Threading Side ID	26.3+0.1	Inside vernie Caliper / ID Gun	26.33	26.34	26.36	26.37	26.38	OK
28	OD turning length	3	Contracer/PP	3.057	3.078	3.012	3.014	3.011	OK
29	ID Depth	7±0.2	Contracer/PP/Vernier Caliper	6.98	7.10	6.95	7.09	6.82	OK
30	Threading length	20 + 0.1	Contracer/PP/plug gauge	20.15	20.11	20.16	20.14	20.55	OK
31	Total depth	24+0.2	Vernier Caliper	24.17	24.14	24.03	24.12	24.11	OK
32	Groove Width	10.0±0.2	Contracer/PP/Vernier Caliper	10.19	10.19	9.96	10.13	10.03	OK
33	Run out	0.1	Dial gauge with fixture	0.097	0.081	0.091	0.069	0.083	OK
34	Angle	30°	Contracer/ Machine Program	30°12'51"	30°26'50"	30°23'48"	30°30'57"	30°26'33"	OK
35	Angle	30°	Contracer/ Machine Program	30°21'50"	29°40'50"	29°45'28"	29°55'51"	30°20'34"	OK
36	Radius	R6	Contracer/ Machine Program	5.31	5.37	5.33	5.27	5.32	OK
37	Roughness	3.2 Ra	Roughness Tester	1.705	1.209	1.240	1.267	1.125	OK
38	Thread side chamfer angle	0.5X45°	Contracer/PP/ Machine Program	0.5861*45°12'44"	0.5244*45°17'40"	0.5111*45°14'25"	0.5030*45°11'34"	0.5734*45°11'34"	OK
39	Dimension	1	Contracer/PP/ Machine Program	1.024	1.058	1.058	1.055	1.044	OK
40	Dimension	1	Contracer/PP/ Machine Program	1.022	0.9875	0.9752	1.002	1.046	OK
41	Angle	5°	Contracer/PP/ Machine Program	5°39'55"	5°34'52"	5°30'46"	5°37'04"	5°29'31"	OK
42	Threading	M26x1-6H	Threading Plug Gauge	OK	OK	OK	OK	OK	OK
46	Threading Side ID	28.2-0.2	Contracer/PP/Vernier Caliper	28.11	28.17	28.13	28.12	28.13	OK
43	Free From Burr, Dent & Scratch Mark after		Visual	OK	OK	OK	OK	OK	OK
44	Apply Rust Preventive Oil		Visual	OK	OK	OK	OK	OK	OK

Remark :-

INSPECTED BY :- Abishek Yadav

APPROVED BY :- Palak Shah