

		PROCESS VALIDATION		Doc No: F/PROD/13 Rev No : 01 Date : 01/05/2024		
Operation Name : Drill Hole Burr						
M/C Name : CNC Machine						
Model Name : J1A,J1C,J1D				Date:- 25.10.2024		
Fix Parameters						
Sr No	Parameters	Specification				
1	RPM	1400 to 2000				
2	Cutting Speed	Manual				
3	Coolant	Yes				
Trial -3600 Qty.						
Sr. No.	Process Condition	Specification	Observation			Remark
			Visual	ID line mark	Part to part Variation drill hole Burr.	
1	RPM	1400 to 2000	OK	OK	3600 Out Of 3562----- OK	Obseved part 38 Part Hole burr
2	Cutting Speed	Manual				
3	Coolant	Yes				
Trial -3400 Qty.						
Sr. No.	Process Condition	Specification	Observation			Remark
			Visual	ID line mark	Part to part Variation drill hole Burr.	
1	RPM	1400 to 2000	OK	OK	3400 Out Of 3386----- OK	Obseved part 14 Part Hole burr
2	Cutting Speed	Manual				
3	Coolant	Yes				
Trial -3200 Qty.						
Sr. No.	Process Condition	Specification	Observation			Remark
			Visual	ID line mark	Part to part Variation drill hole Burr.	
1	RPM	1400 to 2000	OK	OK	3200 Out Of 3198----- OK	Obseved part 2 Part Hole burr
2	Cutting Speed	Manual				
3	Coolant	Yes				
Trial -3000 Qty.						
Sr. No.	Process Condition	Specification	Observation			Remark
			Visual	ID line mark	Part to part Variation drill hole Burr.	
1	Spindel RPM	1400 to 2000	OK	OK	3000 Out Of 3000----- OK	Obseved part all Part ok
2	Cutting Speed	Manual				
3	Coolant	Yes				
Result : 1) The range is decided for Drill resharping 3000						
Verified by:				Approved by:		