

**Jain Precision and Forging**  
**OFFSET VALUE INTERLOCK MATRIX**

PERMISSION TO :- OPERATOR						PERMISSION TO :- SUPERVISOR						
SR.NO	OPERATION	TOOL	OFFSET VALUE	RESPONSIBILITY	REMARK	SR.NO	OPERATION	TOOL	OFFSET VALUE	Insert Life / corner	RESPONSIBILITY	REMARK
1	ID 14 mm Boring	TCMT0904	Not allowed	operator		1	ID 14mm Boring	TCMT0904	0.05 to 0.1mm	600nos	Supervisor	
2	ID 24 mm Boring	CCMT09	Not allowed	operator		2	ID 24 mm Boring	CCMT09	0.1 to 0.2mm	600nos	Supervisor	
3	Turning	TNMG .8	Not allowed	operator		3	Turning	TNMG .8	0.08 to 0.15mm	150nos.	Supervisor	
4	Turning	TNMG .4	Not allowed	operator		4	Turning	TNMG .4	0.08 to 0.15mm	150nos.	Supervisor	
5	OD Threading	1.0 ER	Not allowed	operator		5	OD Threading	1.0 ER	0.03 to 0.06mm	170nos.	Supervisor	
6	ID Threading	1.5 ER	Not allowed	operator		6	ID Threading	1.5 ER	0.04 to 0.1mm	600nos.	Supervisor	

PREPARED BY :-

APPROVED BY :-