

Jain Precision and Forgings Pvt. Ltd.

M-134, MIDC, Wadi, Avangahad-431136
Pre-Dispatch Inspection Report

Part name: JBKACERT K-19 Assembly	Invoice Date	Doc No
Part Number: F205100970	Invoice Qty	Rev No/ DR
		Page No
		Customer Name: Endurance technology ltd
		JPF/MFG/003
		01/29/01/2021

Sr.No	Parameter	Frequency	Inspection Method	Visual Inspection					Remark
				1	2	3	4	5	
1	No Burr, Sharp Edges	100%	Visual						
2	Step/Debt On machining face	100%	Visual						
3	Ensure Free from Welding B/H	100%	Visual						
4	Free From Powder coating, Debris, smooch, peddelt, Overflow.	100%	Visual						

Sr.No	Drawing Specification	Special Char.	Open Tolerance	Frequency	Inspection Method	Functional Check					Remark
						1	2	3	4	5	
1	C/D		1700 ± 0.10	100%	HTG WITH PIPE ASSEMBLY						
4	C/D		50 ± 0.10	100%	HTG WITH PIPE ASSEMBLY						
5	Parallelity		0.05	As per sampling	HTG WITH PIPE ASSEMBLY						
6	Parallelity		0.15 (200 MM LENGTH)	100%	HTG WITH PIPE ASSEMBLY						

Dimensional Inspection

Sr.No	Drawing Specification	Special Char.	Open Tolerance	Frequency	Inspection Method	JPFPL Observation					Remark
						1	2	3	4	5	
1	Pressing Height		206-0.5	100%	Height Gauge/ TL Gauge						
2	WIDTH		24	100%	DVC/ SG						
3	LD		0.300 ± 0.1	As per sampling	DERP/ DVC						
4	OD		28+0.020/±0.053	100%	SESG/ MM						
5	OD		25-0.033	100%	SESG/ MM						
6	OD Threading		23.5-0.050/13	100%	SESG/ MM						
7	M25 Threading Length		M 25 X 1 -6g	100%	T.R.G						
8	Tapping Length		12 ± 1	As per sampling	DVC/ Profile projector						
9	Metric Dia		M 10 X 1.6H (Through)	100%	TPG						
10	23.5 mm OD length		9.20±0.2	100%	PCG						
11	Tapping		M 10 X 1.25 6H (Through)	As per sampling	DVC/ Flush pin gauge						
12	Tapping (ASS)		M 10 X 1.25-6H (2X)	100%	TPG						
13	Tapping		M 6 X 1-6H	100%	TPG						
14	Sliding Chamfer		1.5 X 45°	100%	Visual / Compass						
15	Angle		72°±1/160°	As per sampling	Bevel & H Gauge/ Gauge						
16	Chamfer		2 X 10°	100%	Visual / Compass						
17	Chamfer		0.5 X 45°	100%	Visual / Compass						
18	Tapping (Through)		M 6 X 1-6H	100%	TPG						

Conclusion : Accepted / Rejected

Inspected By :

Approved By :