

SHARP ENGINEERS Unit-II

G-29, MIDC, WALUJ, AURANGABAD -431 136

PART NAME: Fork Bolt ABW04	M/C Name: CNC	PROCESS NAME: Turning	Format No: FQ/507
PART NO: F2D2-045120	M/C No: SE/CNC1	PROCESS NO. AS PER C.P.: 02	Rev. No.: 01
OPERATOR NAME: CNC - Tst	SHEET: 1st	DATE: 08.12.2024	Rev Date:

FIRST PIECE AND HOURLY INSPECTION REPORT

RESPONSIBILITY: QA SUPERVISOR

PRODUCT PARAMETER	OD	ID	ID	Roll	OD	Total length	FD	Groove Dia	Groove Dia	ID Thread	Inner Diameter	REMARK
SPECIFICATIONS	96.5-0.2	93-0.1	28±0.05	M3X1.5	26±0.2	94.5±0.1	+0.01	10.8-0.03	12.4±0.1	11.5±0.05	M12X1.5	Visual
OBSERVATION	96.42	92.95	28.02	OK	26.05	94.54	10.79	12.42	11.60	OK	OK	OK
OK/NOT OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
CORRECTIVE ACTION	None											

QA SUPERVISOR SIGN: *[Signature]*

B. HOURLY INSPECTION

RESPONSIBILITY: OPERATOR

PRODUCT PARAMETER	1	2	3	4	5	6	7	8	9	10	11	12	REMARK
OD (96.5-0.2)	96.42	96.45	96.41	96.45	96.44	96.42	96.45	96.41	96.44	96.45	96.44	96.45	OK
OD (93-0.1)	92.95	92.95	92.94	92.95	92.97	92.95	92.95	92.95	92.97	92.95	92.95	92.95	OK
OD (28±0.05)	28.02	28.10	28.09	28.01	28.03	28.04	28.01	28.03	28.01	28.02	28.03	28.01	OK
Roll (M3X1-5)	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
OD (20±0.2)	20.05	20.02	20.05	20.08	20.03	20.02	20.05	20.01	20.07	20.03	20.05	20.03	OK
Total (94.5±0.1)	94.55	94.52	94.55	94.52	94.55	94.52	94.55	94.51	94.55	94.55	94.52	94.50	OK
ID (10.8-0.03)	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
FD (12.4±0.1)	12.45	12.42				12.42	12.44						OK
Groove Dia (10.8-0.03)	11.60	11.61				11.61	11.62						OK
FD Thread (M12X1-5)	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
Visual	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
QA SIGN	<i>[Signature]</i>												