

# PATROL INSPECTION SHEET



Helical  
Springs Waluj

<b>PART NAME</b>	<b>Main Spring</b>	<b>OPERATOR NAME</b>		<b>DATE</b>		<b>OPERATION</b>	<b>COILING</b>
<b>PART NO.</b>	<b>F1GN011020 - XE</b>	<b>M/C NO.</b>		<b>SHIFT</b>			

S. NO	Description	Specification	Insp. Method	OBSERVATION PER FOUR HOURS												JUDG.	REMARK
1	Wire Dia.	3.20 ± 0.030	MM/DVC														
2	Coil OD	23.45 ± 0.10	DVC														
3	Coil OD-2 (OPEN SIDE END COIL)	22.60 ~ 22.80	DVC														
4	Taper Coil OD (CLOSED SIDE END COIL)	20.70 ~ 20.90	VC/Gauge														
5	NO. OF TOTAL COIL	33.1±0.25	COUNTING														
6	TOTAL CLOSE COIL	16 Ref	COUNTING														
7	DIRECTION OF WIND	RH	VISUAL														
8	FREE LENGTH	222.0 ± 2.0 mm	VC/LCG														
9	NO. OF TAPER COIL	2.0~3.0 TOWARDS CLOSER PITCH SIDE	VISUAL														
10	HEIGHT AT 16 <sup>TH</sup> COIL	89.0 ± 1.0 mm	DVC														
11	APPEARANCE	FREE FROM VISUAL DEFECTS	VISUAL														

## GRINDING

1	Free Length	218.0 ref	DVC													
2	E2	0.5 mm Max	DG													
3	Grinding Angle	270° min	COUNT													
	End Condition	Squared & Ground	Visual													

<b>VARIFIED BY Q.A. INCHARGE</b>		PRODUCTION QTY.-		<b>Sign. Of Q.C. Inspector</b>	1ST Observation	2nd Observation	3rd Observation	4th Observation
		REJECTION QTY.-						