



HARSHAD ENGINEERING CO.
W-14, MIDC, SATPUR, NASHIK:-4222007

In-Process Inspection Report
HEC/QAD/02
Rev No :02
Rev Date :- 31.01.2022

Name of Operator :- Rahul Kumar

Process Name & No. :- 50 Rough Grinding

Mfg. Location :- Plant-1 (W-14) / Plant-3 (F-66)

Date :- 18/9/22
Part No : PRPH
Machine No. :- G-2
Lot No. :-

Shift :- Day

Inspection Details

Observations (In-process inspection is done for 5 Pcs/Hr but records only 1pcs/2 hr)

Sr No.	Inspection Parameters	Inspection Method	Spl. Char. Class	Limits		Set-up approval		In-process Inspection						
				LSL(-)	USL(+)	First Piece	Tool change	9.00	11.00	1.00	3.00	5.00	Last piece Insp.	
1	Shank Dia	Micrometer		14.05	14.15	14.10		14.09	14.11	14.10	14.09	14.10	14.10	14.11
2	Taper	Micrometer		0.05 Max		0.01		0.02	0.01	0.02	0.03	0.02	0.03	
3	Radius at Head Neck	Visual		R 0.5 Max		OK		OK	OK	OK	OK	OK	OK	
4	Unclean Area	Visual		No unclean area		OK		OK	OK	OK	OK	OK	OK	
5	Burning Mark	Visual		No Burning mark		OK		OK	OK	OK	OK	OK	OK	
6	Identification Step (As forged)	Visual		8 to 10 mm		-		-	-	-	-	-	-	
7	Shank Runout wrt Shank Dia.	Dial & stand		0.030 mm		0.02		0.01	0.03	0.02	0.03	0.02	0.01	

DAILY CHECKSHEET

Sr. No.	Parameters	Remark	Sr. No.	Specification	Remark
1	Grinding Wheel speed (1400-1500 RPM)	1440 RPM	5	Dressing Freq. (600 Nos)	600 Nos.
2	Grinding Wheel Grade (A-46/60)	A46	6	Hydraulic oil Level (Must be in Green Zone)	GREEN
3	Regulating Wheel Grade(80RR)	80RR	7	Coolant level (Must be in Green Zone)	GREEN
4	Regulating wheel speed (20-45 RPM)	23 RPM	8	Coolant Conc. (1%-4%)	3.1

Note: SC = Significant Characteristics, SFC = Safety Characteristics

Prepared By Aludal

Note :- Plant 1 :- HEC, W-14 Satpur MIDC, Nashik, Plant 2 :- HEC, F-125, Satpur MIDC, Nashik, :- HEC, F-66, Satpur MIDC, Nashik

Approved By Jeet