

CHIRAG DIE CAST PVT.LTD.

INPROCESS INSPECTION REPORT

CASTING PROCESS

INSP. NAME: Tagun

M/C No. : 01

Tool Number: M2

Core Plate (HMSI)

520AE04002

S.No.	PRODUCT / PROCESS PARAMETER	SPECIFICATION		M.Incl.	Cavity	OBSERVATION												REMARKS
		LSL	USL			9:00 AM	10:00 AM	11:00 AM	12:00 PM	1:00 PM	2:00 PM	3:00 PM	4:00 PM	5:00 PM	6:00 PM	7:00 PM	8:00 PM	
1	Claw Thickness	2.300	2.400	MIC	1	905 2355	905 2351	910 2351	906 2354	910 2351	910 2351	907 2360	902 2350	907 2355	910 2361	913 2364	909 2357	OK
		2.300	2.400	MIC	2	900 2364	901 2368	910 2367	903 2365	910 2368	910 2368	908 2371	910 2373	910 2370	913 2370	905 2369	914 2369	905 2365
2	Base Thickness	1.750	1.850	MM	1	750 1787	753 1790	750 1789	753 1789	750 1789	750 1789	755 1790	751 1789	750 1785	755 1793	752 1789	750 1788	OK
		1.750	1.850	MM	2	752 1796	750 1792	750 1796	753 1794	750 1796	750 1796	753 1798	750 1793	750 1793	750 1795	753 1797	750 1792	752 1796
3	BISCUIT THICKNESS	10.000	20.000	MM	VC	0.044 11.13	0.042 11.24	0.046 11.19	0.041 11.10	0.041 11.10	0.046 11.19	0.045 11.15	0.043 11.25	0.045 10.50	0.044 10.94	0.042 11.17	0.044 10.95	OK
		52 HRB	62 HRB	HT	-	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)	52 u 55 (After 100gm. Mg. Add in 200kg of crucible)
3	Appearance	Free from cold shut, non filling, flow lines, blow holes, shrinkage, soldering, blister, crack, catching, hole block, heat check/die crack marks		Vis.	-	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK

Note:- First pcs approval done for 5 pcs and data recorded min. to max. only.

CHECKED BY: [Signature]

APPROVED BY: [Signature]