CHIRAG DIE CAST PVT.LTD.

INPROCESS INSPECTION REPORT

CASTING PROCESS

Doc. No : FM-QA-11			
Rev. No : 00			
Date : 01-06-2017			
PART NAME:-	Core Plate (HMSI)	M/C No. :-	07
PART No. :-	520AE04002	Tool.Number:-	M2
INSP. NAME:	Tarun.	SHIFT :	A
DATE :	05/08/22		

S.No.	PRODUCT / PROCESS PARAMETER	SPECIFICATION LSL	SPECIFICATION USL	M.Inst.	Cavity	FPA	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	REMARKS
1	Claw Thickness	2.300	2.400	MIC	1	2 315/361	2 315/361	2 313/364	2 317/360	2 310/359	2 313/371	2 309/368	2 312/371	2 316/369	2 311/370	2 314/368	2 317/370	2 315/369	OK
					2	2 305/374	2 305/374	2 308/369	2 310/364	2 301/365	2 305/371	2 304/365	2 311/370	2 300/359	2 308/365	2 305/361	2 308/364	2 310/361	OK
2	Base Thickness	1.750	1.850	MM	1	1 750/791	1 750/791	1 750/793	1 752/796	1 750/789	1 753/794	1 750/789	1 752/790	1 750/793	1 751/790	1 752/788	1 750/790	1 753/790	OK
					Variation .05 max	0.041	0.041	0.043	0.044	0.039	0.041	0.039	0.038	0.043	0.039	0.036	0.040	0.037	OK
					2	1 752/787	1 752/787	1 750/789	1 751/793	1 750/788	1 753/789	1 750/788	1 751/792	1 750/788	1 752/791	1 750/785	1 752/789	1 750/789	OK
					Variation .05 max	0.035	0.035	0.039	0.042	0.038	0.036	0.038	0.041	0.038	0.039	0.035	0.037	0.039	OK
	BISCUT THICKNESS	10.000	20.000	MM	VC	10.50	10.50	10.65	10.55	10.59	10.71	10.57	10.45	10.64	10.59	10.53	10.61	10.58	OK
3	Hardness	52 HRB	62 HRB	HT	-	46 n 58 (Variation More than 10 points)													Δ
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	OK

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

CHECKED BY : Kaama.

APPROVED BY :