



FIRST FIVE PIECE CUM INSPECTION CHECK SHEET

Machine no :		Date :	23/02/23	Format no	F/QA/02
Drg. Rev on :	XA	Shift :	2 st	Rev. date	23.02.23
Part No :	F2FA088050	Part name	k-9207	Rev. no	01
Operator Name :	Pathan	QA Inspector	Vinod Rao RBH	Date	23/02/23

Sr. No	Product Parameter	Spec.	Measurement Method	First Five Piece												Remark	Process Parameter	Specification	Observation
				Actual Observation					5 Piece / 2 hr										
				1	2	3	4	5	7.00	9.00	11.00	1.00	3.00	5.00	7.00				
1	total Length	547.3±0.2	Height Gauge	547.32	547.36	547.37	547.40	547.40	547.38	547.30	547.31	547.30	547.38	547.40	547.40	OK	Spindle RPM	2200 to 2600	2200
2	Caulking Side OD	28.5±0.2	Snap Gauge/ Micrometer	28.54	28.56	28.56	28.55	28.57	28.57	28.56	28.57	28.51	28.54	28.54	28.51	OK	Cutting speed	220 to 240	230
3	Caulking ID	26.05+0.05	plug gauge/Bore Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	Feed rate - mm/revolution	0.16 to 0.20	0.16
4	Caulking Bore Depth	46.10+0.10	plug gauge/Vernier	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	Hydraulic Pressu	28 ~ 30 Bar	28
5	Caulking Side Run Out	0.08	Dial gauge with fixture	0.06	0.05	0.05	0.04	0.05	0.03	0.04	0.02	0.04	0.03	0.04	0.05	OK	Clamping pressu	18~20 kg/cm2	18
6	OD Length-1	4.0	Vernier	4.02	4.04	4.02	4.01	4.02	4.01	4.02	4.01	4.02	4.03	4.02	4.04	OK			
7	OD Length-2	10	Vernier	10.04	10.06	10.02	10.06	10.04	10.02	10.03	10.03	10.04	10.03	10.04	10.04	OK	Spindle RPM	1200 to 1400	1200
8	R OD	29.0+0.1	Snap Gauge	29.04	29.03	29.03	29.04	29.02	29.02	29.04	29.02	29.04	29.16	29.04	29.06	OK	Hydraulic Pressu	28 ~ 30 Bar	28
9	Run out	0.1	Dial gauge with fixture	0.08	0.06	0.07	0.06	0.05	0.06	0.07	0.04	0.05	0.04	0.05	0.04	OK	Clamping pressu	18~20 kg/cm2	18
10	Drilling Distance	32.3+/-0.2	Vernier	32.40	32.50	32.40	32.40	32.41	32.40	32.41	32.38	32.35	32.37	32.34	32.50	OK			
11	Drill	3.3	Plug Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK			
12	ID	26.3+0.1	plug gauge/Bore Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK			
13	Bore Dia	26.12+0.08	Plug Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK			
14	ID Depth	8.5+0.2	depth Plug Gauge/Vernier	8.56	8.34	8.34	8.32	8.51	8.54	8.54	8.54	8.54	8.54	8.56	8.52	OK			
15	ID Total Depth	27+1	depth Plug Gauge	27.14	27.14	27.16	27.11	27.16	27.16	27.16	27.19	27.28	27.19	27.20	27.31	OK			
16	Threading Length	17.50	depth Plug Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK			
17	Thriding	M25x1-6H	Thriding Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK			

Remark- 1) threading inspection frequency hourly 5 nos & reding notedown after 2 hour

Operator sing		Supervisor sing		QC Engineer	
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