



FIRST FIVE PIECE CUM INSPECTION CHECK SHEET

Machine no :	10	Date :	18/02/23	Format no	F/QA/02
Drg. Rev on :	XA	Shift :	7 th	Rev. date	23.02.23
Part No :	F2FA088050	Part name	k-9207	Rev. no	01
Operator Name :	सजय राजपुत	QA Inspector	[Signature]	Date	

Sr. No	Product Parameter	Spec.	Measurement Method	Actual Observation											Remark	Process Parameter	Specification	Observation	
				First Five Piece					2 Piece / 1 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	547.31	547.33	547.34	547.31	547.35	547.31	547.34	547.37	547.31	547.37	547.31	547.35	OK	Spindle RPM	2200 to 2600	2600
2	Caulking Side OD	28.5±0.2	Snap Gauge/ Micrometer	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	Cutting speed	220 to 240	240
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	0.20
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	29
5	Caulking Side Run Out	0.08	Dial gauge with fixture	0.06	0.07	0.06	0.07	0.05	0.04	0.03	0.04	0.03	0.04	0.04	0.03	OK	Clamping pressu	18~20 kg/cm2	19
6	OD Length-1	4.0	Vernier	4.00	4.01	3.99	3.98	4.00	4.01	3.99	3.98	4.01	4.00	4.02	4.00	OK			
7	OD Length-2	10	Vernier	10.00	10.01	10.00	10.01	9.99	9.98	10.00	10.01	10.00	9.98	9.99	10.01	OK	Spindle RPM	1200 to 1400	1400
8	R OD	29.0+0.1	Snap Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	Hydraulic Pressu	28 ~ 30 Bar	30
9	Run out	0.1	Dial gauge with fixture	0.07	0.07	0.08	0.07	0.06	0.08	0.07	0.06	0.07	0.08	0.06	0.07	OK	Clamping pressu	18~20 kg/cm2	19
10	Drilling Distance	32.3+/-0.2	Vernier	32.31	32.32	32.30	32.33	32.34	32.31	32.35	32.31	32.30	32.34	32.31	32.30	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	25.12+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	8.51	8.51	8.54	8.54	8.54	8.56	8.51	8.57	8.54	8.50	8.51	8.54	OK			
15	ID Total Depth	27+1	depth Plug Gauge	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	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) Inspected 2 sample and reading 1 sample

Operator sing	[Signature]	Supervisor sing	[Signature]	QC Engineer	[Signature]
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