

AAR CEE ENGINEERING WORKS

TRIMMING INSPECTION REPORT

Customer: E.T.L.

Part Name: Core Plate

LML REGU.

Date: 03 Oct 2015

P.P.NO. 67

Part No.: 520AE01502

HEAT NO.:

TAGE NO.:

8:00AM

11:00PM

2:00PM

5:00PM

OP. NAME

REMARK

S.No	PARAMETER (as per Inspection std.)	Specification	Method of inspection	8:00AM				11:00PM				2:00PM				5:00PM				
				C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	
1	DIMENSIONAL	DIAMETER	Ø119.0 ± 0.15	DVC					108.93	108.96	108.97	108.95	108.94	108.93	108.94	108.95				
		DIAMETER	Ø112.0	DVC					110.97	110.96	110.94	110.93	110.95	110.92	110.94	110.94				
		DIAMETER	Ø110 ± 0.15	DVC					109.90	109.95	109.97	109.98	109.93	109.96	109.95	109.91				
		INNER DIAMETER	Ø91.0 + 0.30	DVC					91.02	91.05	91.06	91.05	91.02	91.05	91.02	91.02				
		CLAW WIDTH	15.8 ± 0.05	DVC					15.83	15.81	15.82	15.80	15.81	15.81	15.82	15.81				
2	BLACKNESS AND BLACK SPORT	COMPONENT SHOULD BE FREE FROM BLACKSPORT & DARK BLACKNESS	VISUALLY						OK											
				FLATNESS	0.1 MAX	GAP G/FG					0.10	0.02	0.01	0.10	0.09	0.10	0.10	0.09		

DIMENSIONAL & VISUALLY				SHOT BLASTING INSPECTION REPORT																
				8:00AM				11:00PM				2:00PM				5:00PM				
				C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	
TEMPERATURE				270 ± 20°	VISUALLY															
DIAMETER				Ø119.0 ± 0.15	DVC															
DIAMETER				Ø112.0	DVC															
DIAMETER				Ø110 ± 0.15	DVC															
INNER DIAMETER				Ø91.0 + 0.30	DVC															
CLAW WIDTH				15.8 ± 0.05	DVC															
FLATNESS				0.1 MAX	GAP G/FG															

DIMENSIONAL & VISUALLY				HEAT TREATMENT INSPECTION REPORT																
				8:00AM				11:00PM				2:00PM				5:00PM				
				C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	
TEMPERATURE				270 ± 20°	VISUALLY															
DIAMETER				Ø119.0 ± 0.15	DVC															
DIAMETER				Ø112.0	DVC															
DIAMETER				Ø110 ± 0.15	DVC															
INNER DIAMETER				Ø91.0 + 0.30	DVC															
CLAW WIDTH				15.8 ± 0.05	DVC															
FLATNESS				0.1 MAX	GAP G/FG															

INSPECTED BY: *[Signature]*

APPROVED BY: *[Signature]*

NOTE: ALL DIMENSIONS ARE IN MM