AAR CEE ENGINEERING WORKS | Plot No. 59, Gali No. W-9-B, Sarurpur Industrial Area, Faridabad (Hr.)

TRIMMING INSPECTION REPORT

Customer : ENDURANCE TECHNOLOGY PVT. LTD | Part Name : CORE PLATE K-70 PP-02 | Date : 20.04.2022

Part No. : 520AE00100/C | C-220 C-220 | Sample Size : 1 Pcs. / Each Cavity

APR/19E

S. No.	PARAMETER (as per Inspection std.)	Specification	Method of Inspection	OBSERVATION 10:00 AM C1	C2	C3	C4	12:00 PM C1	C2	C3	C4	2:00 PM C1	C2	C3	C4	4:00 PM C1	C2	C3	C4	6:00 PM C1	C2	C3	C4	8:00 PM C1	C2	C3	C4	REMARKS
	DIMENSIONAL																											
1	DIAMETER	Ø107.50-0.50	DVC	107.11	107.14	107.06	107.09	107.10	107.10	107.00	107.12	107.16	107.10	107.16	107.14	107.12	107.16	107.14	107.03	107.12	107.14	107.14	107.11					
	DIAMETER 101.50 +0.80	~~Ø100.50+0.80~~	DVC	101.55	101.61	101.60	101.54	101.56	101.59	101.60	101.55	101.57	101.58	101.54	101.59	101.52	101.58	101.55	101.62	101.64	101.60	101.66	101.62					
	DIAMETER	Ø98.50-0.50	DVC	98.11	98.10	98.14	98.11	98.10	98.10	98.12	98.12	98.10	98.06	98.11	98.14	98.11	98.10	98.16	98.10	98.11	98.14	98.10	98.12					
	INNER DIAMETER	Ø77.0+0.50	DVC	77.11	77.06	77.11	77.14	77.10	77.14	77.11	77.14	77.12	77.10	77.12	77.06	77.09	77.10	77.14	77.12	77.14	77.06	77.14	77.16					
	CLAW WIDTH	14.0-0.1/0.2	DVC	13.86	13.88	13.87	13.86	13.82	13.86	13.81	13.85	13.80	13.84	13.87	13.88	13.81	13.87	13.86	13.85	13.82	13.88	13.86	13.88					
	FLATNESS	0.1 Max.	GAP G./FG	0.16	0.12	0.14	0.16	0.06	0.09	0.11	0.06	0.08	0.09	0.06	0.09	0.08	0.10	0.06	0.08	0.09	0.06	0.16	0.08					

SHOT BLASTING INSPECTION REPORT

S. No.				C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	
	DIMENSIONAL & VISUALLY																											
2	BLACKNESS & BLACK SPOT	COMPONENT SHOULD BE FREE FROM BLACK SPOT & DARK BLACKNESS	VISUALLY	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok					
	FLATNESS	0.1 Max.	GAP G./FG	0.09	0.11	0.14	0.10	0.11	0.10	0.06	0.08	0.06	0.09	0.11	0.06	0.08	0.10	0.10	0.06	0.05	0.11	0.12	0.10	0.06	0			

HEAT TREATMENT INSPECTION REPORT

S. No.				C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	C1	C2	C3	C4	
	DIMENSIONAL & VISUALLY																											
3	TEMPERATURE	270±20°C	VISUALLY					✓				✓				✓				✓								
	DIAMETER	Ø107.50-0.50	DVC					107.16	107.14	107.12	107.10	107.12	107.12	107.11	107.14	107.14	107.11	107.15	107.17	107.16	107.14	107.14	107.15					
	DIAMETER 101.50 +0.80	~~Ø100.50+0.80~~	DVC					101.62	101.64	101.64	101.54	101.60	101.58	101.55	101.55	101.53	101.58	101.54	101.56	101.52	101.54	101.56	101.56					
	DIAMETER	Ø98.50-0.50	DVC					98.11	98.14	98.16	98.16	98.14	98.11	98.12	98.10	98.11	98.12	98.12	98.16	98.22	98.14	98.10	98.12					
	INNER DIAMETER	Ø77.0+0.50	DVC					77.11	77.14	77.15	77.12	77.16	77.14	77.16	77.18	77.11	77.16	77.14	77.18	77.16	77.18	77.14	77.19					
	CLAW WIDTH	14.0-0.1/0.2	DVC					13.88	13.90	13.87	13.89	13.86	13.88	13.88	13.91	13.84	13.88	13.91	13.88	13.88	13.90	13.89	13.85					
	FLATNESS	0.1 Max.	GAP G./FG					0.08	0.09	0.06	0.08	0.10	0.08	0.10	0.06	0.05	0.08	0.09	0.06	0.08	0.08	0.07	0.06					
	Ravelue (4 places of the Core Plate)	2-3 micron Tester						2.24	2.31	2.35	2.19	2.31	2.44	2.24	2.33	2.14	2.28	2.21	2.44	2.35	2.31	2.44	2.33					

Inspected By | Approved By

DOCUMENTS NO: ACE/Q.C/F/04 NOTE : ALL DIMENSIONS ARE IN MM