	nanjay															
Part No.520FW01102							Opr: Rest	rike		Date:						
Part Name: Clutch Box M&M							M/c No.					Shift:				
SET-UP APPROVAL REPORT																
Characterstics	Specifications		Measurement Technique		Observations									-		
Product / Process		Spec Char. Class		1		2		3		4		5		Remarks		
Trouble, Trocess				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max			
Bend	Not allowed		Visual													
Outer plate fitment	Should qualify freely		Visual													
Dent & Damage	Not allowed		Visual													
Outer Diameter	104.25~104.35		DVC													
No.1-	No.1- IN THE DATA RECORDING COLUMNS INDICATE INSPECTION DATA AS PER THE DEFINED FREQUENCY OF INSPECTION															
No.2-	No.2- IN THE DATA RECORDING COLUMNS INDICATE DATA OF RE-VERIFICATION, IN CASE OF ANY CORRECTION OF DISCREPANCIES & DIE / PUNCH CHANGE & LOT RE- INSPECTION															
	Quality I	nsp. Sing						luction Sup.	sign:							
	INPROCESS INPECTION REPORT													1		
	Product Specifications	Spec Char. Class	Measurement Technique	10.00		12.00		Observations 14.30		16.30		18.30				
Characterstics				1	2	1 2		1 2		1 2		1 2		Remarks		
Bend	Not allowed		Visual	1	2	1	2	1	2	1	2	1	2			
Outer plate fitment	Should qualify freely		Visual													
Dent & Damage	Not allowed		Visual													
Outer Diameter	104.25~104.35		DVC													
	1		1							1		1				
LAST FIVE PIECE REPORT																
Characterstics	Product		Measurement			Observations										
	Specifications	Spec Char. Class	Technique		1	2	2	3	3		4	:	5	Remarks		
Bend	Not allowed		Visual													
Outer plate fitment	Should qualify freely		Visual													
Dent & Damage	Not allowed		Visual													
Outer Diameter	104.25~104.35		DVC													
Previous opr.: Induction Hardening Next Opr:- Final Inspection											1					
Prepared By:- Approved By:																

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	nanjay															
Part No.520FW01102						Current	Opr: Rest	rike		Date:						
Part Name: Clutch Box M&M										Shift:						
SET-UP APPROVAL REPORT																
Characterstics	Specifications		Measurement Technique		Observations								-	-		
Product / Process		Spec Char. Class		1		2		3			4		5	Remarks		
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max			
Bend	Not allowed		Visual													
Outer plate fitment	Should qualify freely		Visual													
Dent & Damage	Not allowed		Visual													
Outer Diameter	104.25~104.35		DVC													
Outer Diameter	104.80 ~ 104.96	CC/I	DVC													
No.1- IN THE DATA RECORDING COLUMNS INDICATE INSPECTION DATA AS PER THE DEFINED FREQUENCY OF INSPECTION																
No.2- IN THE DATA RECORDING COLUMNS INDICATE DATA OF RE-VERIFICATION, IN CASE OF ANY CORRECTION OF DISCREPANCIES & DIE / PUNCH CHANGE & LOT RE- INSPECTION																
Quality Insp. Sing Production Sup. sign: INPROCESS INPECTION REPORT																
				INI	PROCES	SS INPECT	TION RE	Observations								
Characterstics	Product Specifications	Spec Char. Class	Measurement Technique	10.0	00	12	2.00 14.3		i0 16.		5.30 1		.30	Remarks		
				1	2	1	2	1	2	1	2	1	2	1		
Bend	Not allowed		Visual													
Outer plate fitment	Should qualify freely		Visual													
Dent & Damage	Not allowed		Visual													
Outer Diameter	104.25~104.35		DVC													
Outer Diameter	104.80 ~ 104.96	CC/I	DVC													
										•						
					LAST F	IVE PIEC	E REPOI	RT								
Characterstics	Product Specifications	Spec Char. Class	Measurement Technique	Observations									Remarks			
				1		2	2	3	3		4		5	rteinants		
Bend	Not allowed		Visual													
Outer plate fitment	Should qualify freely		Visual													
Dent & Damage	Not allowed		Visual													
Outer Diameter	104.25~104.35		DVC													
Outer Diameter	104.80 ~ 104.96	CC/I	DVC													
Previous opr.: Induction Hardening Propaged By:							Next Opr:- Final Inspection Approved By:									
Prepared By:-							Approved	ву:								

Doc. No. : Q86-F01/ Rev.00 / 01.08.2017