




**ASM CASTINGS P.LTD.**Doc. No. :- ASM/F/QC/86
Rev. No. :- 02**PDC QUALITY INSPECTION STANDARD**

PART NAME:- Core Plate LML RED. (612)

PART NO.:- 520AE00400

Drawing Rev.& Date :- 00/ 27-05-2006

S.NO.	PARAMETERS	SPECIFICATION	INSP. METHOD	SIZE	FREQ.
1	Apperance	Component must be free from casting defects	Visual	100% by Operator	
2	Thickness	2.8-0.15	Micrometer	Each cavity 01 pcs.	Die Loading & Every 3 hrs
3	Thickness	2.0 -0.15	Micrometer	Each cavity 01 pcs.	
4	Claw I.D	112±0.2	DVC	Each cavity 01 pcs.	Die Loading & Every 3 hrs 
5	Ring variation	Within 0.1mm	Micrometer	Each cavity 01 pcs.	Die Loading
6	Month Calender	Current Month	Visual	Each cavity 01 pcs.	Die Loading
7	Hardness	35 HRB (80 BHN) min	Hardness Tester	Each cavity 01 pcs.	Die Loading
8	Chemical Composition of Molten Material / Runner 	As Per ALSI-132	Spectro Meter	01 Sample	Die Loading
9	Biscuit Thickness 	20 ~ 25 MM	DVC	01 Shot at once	Die Loading & Every 3 hrs
2	04/07/2023	Claw I.D Checking Freq. Revised from Die Loading to Every 3 Hrs.	Ateev Sharma	L.M. Sharma	
1	10/06/2021	Check Point added for Hardness , Chemical Composition, & Biscuit Thickness	Nakul Kotru	L.M. Sharma	
0	05/10/2014	Initial Release	R.Dagar	L.M. Sharma	
Rev. No	Rev. Date	Ammendments	Prep. By	Appd. By	