



CUSTOMER NAME :-	ENDURANCE TECHNOLOGIES K-228	FORMAT NO :	F/QA/05
MODEL NAME-	FORK PIPE MANCHINED	INVOICE DATE :	18.07.2023
CUSTOMER PART NO :-	F2FA209330	INVOICE NO :	3013010031517
MODEL:-	33 SPD ID 27	LOT SIZE :	300 nos
REV. :-	XC	SAMPLE SIZE :	40 nos

Purpose of Inspection Report									
Sr. No.	Parameters	Specification	Inspection Method	Observation					Remark
				1	2	3	4	5	
1	total Length	457 +/-0.5	Height Gauge	457.18	457.14	457.19	457.18	457.16	OK
2	Raw Tube OD	33.25+0.015	Micrometer	33.30	33.28	33.27	33.28	33.27	OK
3	Iner Diameter	27	DVC	27.04	26.98	26.95	26.96	26.99	OK
4	ID Threading	M28X1-6H	Thread Gauge	Ok	Ok	Ok	Ok	Ok	OK
5	ID Threading Depth	13 + 2	plug gauge	13.32	13.38	13.41	13.51	13.53	OK
6	ID Chamfer	1.5	DVC	1.52					OK
7	Step od Concentricity	0.05 max	Dial gauge with fixture	0.051	0.048	0.049	0.050	0.053	OK
8	OD Chamfer	5	DVC	5.08					OK
9	Drilling Distance	112.7 ± 1	vernier	112.70	112.75	112.70	112.72	112.80	OK
10	Drill chamfer	0.5X45°	prof .proj	44°55'51"					OK
11	Drill dia	3.3 ± 0.1	vernier	3.31	3.34	3.30	3.33	3.32	OK
12	OD Chamfer	1.5 ± 0.2	DVC	1.49					OK
13	ID Chamfer	0.5 ± 0.2	DVC	0.51					OK
14	Angle	45°	prof .proj	44°56'52"					OK
15	Threading total length	25.5 +1	DVC	25.8					OK
16	OD Threading	M33X1-6g	OD Threading ring gauge	Ok	Ok	Ok	Ok	Ok	OK
17	Step OD	31.00 +0.1	prof .proj	31.08	31.05	31.06	31.08	31.06	OK
18	Distance	8 +0.5	vernier	8.38	8.4	8.38	8.32	8.31	OK
19	Distance	4X 90.5°	prof .proj	4.1X 90°					OK
20	Visual	No Dent ,No Burr	Visual	OK	OK	OK	OK	OK	OK
		Apply Rust oil	Visual	OK	OK	OK	OK	OK	OK
		No Hole Shift	Visual	OK	OK	OK	OK	OK	OK

INSPECTED BY :- Mr. Sandeep Jadhav

APPROVED BY :- Mr. KS Rathod