



Parts Inspection Report

Main aim of measurement :- Final parts Measurement etc.

Part No	23111-K0N-D000- H1	DCN	M-19-E0197	LOT QTY		Approval
Part Name	GEAR PRIMARY DRIVEN	H/T LOT NO		MODEL	K1EA	<i>Ujjwal</i>
Customer	ENDURANCE	Qty	5 No.s	DATE:-	07-10-2023	
Purpose of measurement	SALES RETURN PART INSPECTION REPORT					Incharge
						<i>SP</i>

SI No.	Inspection Parameter	Inspection Method	Specification	Measurement Unit					Disposition (OK/NG)
				mm/microns					
				Actual Observation					
				1	2	3	4	5	
1	Diameter	DVC	∅ 103.0 ± 0.25	+0.178	+0.188	+0.182	+0.185	+0.180	OK
2	Diameter	APG	∅ 23.0 +0.021	+0.019	+0.015	+0.017	+0.013	+0.018	OK
3	Lead profile	GEAR TESTER	As Per Drawing Tooth specification Table	ATTACHED REPORT					OK
4	APPEARANCE	VISUAL	No,dust,burr,dent, damage,etc.	VISUAL OK	VISUAL OK	VISUAL OK	VISUAL OK	VISUAL OK	OK
5	Diameter	APG	∅ 30.5 -0.01 / -0.03	0.021	0.018	0.020	0.019	0.016	OK
6	Face Flatness Both side	SPECIAL GAUGE & DIAL	0.1	0.018	0.030	0.036	0.034	0.036	OK
7	Teeth PCD R/O	PCD TESTER	0.04 / H	0.028	0.022	0.032	0.0034	0.028	OK
8	Dimension	HG	8.8 -0.3	0.13	0.18	0.10	0.16	0.10	OK
9	Dimension	DVC	10.5 -0.3	0.08	0.06	0.03	0.07	0.06	OK
10	Dimension	HG	18.0 -0.1	0.08	0.03	0.06	0.07	0.06	OK
11	Diameter	DVC	29.0 ± 0.2	0.16	0.13	0.10	0.14	0.11	OK
12	Dia.Over Balls or pins 3.5	OBD MIC	121.818(-0.033/-0.142)	-0.092	-0.114	-0.100	-0.108	-0.111	REF
13	CD	GRT	120.07 ± 0.034	+0.032/-0.012	+0.032/-0.008	+0.028/-0.016	+0.030/-0.008	+0.032-0.018	OK
14	TCE	GRT	0.054	0.044	0.040	0.044	0.040	0.050	OK

Consideration / Remarks

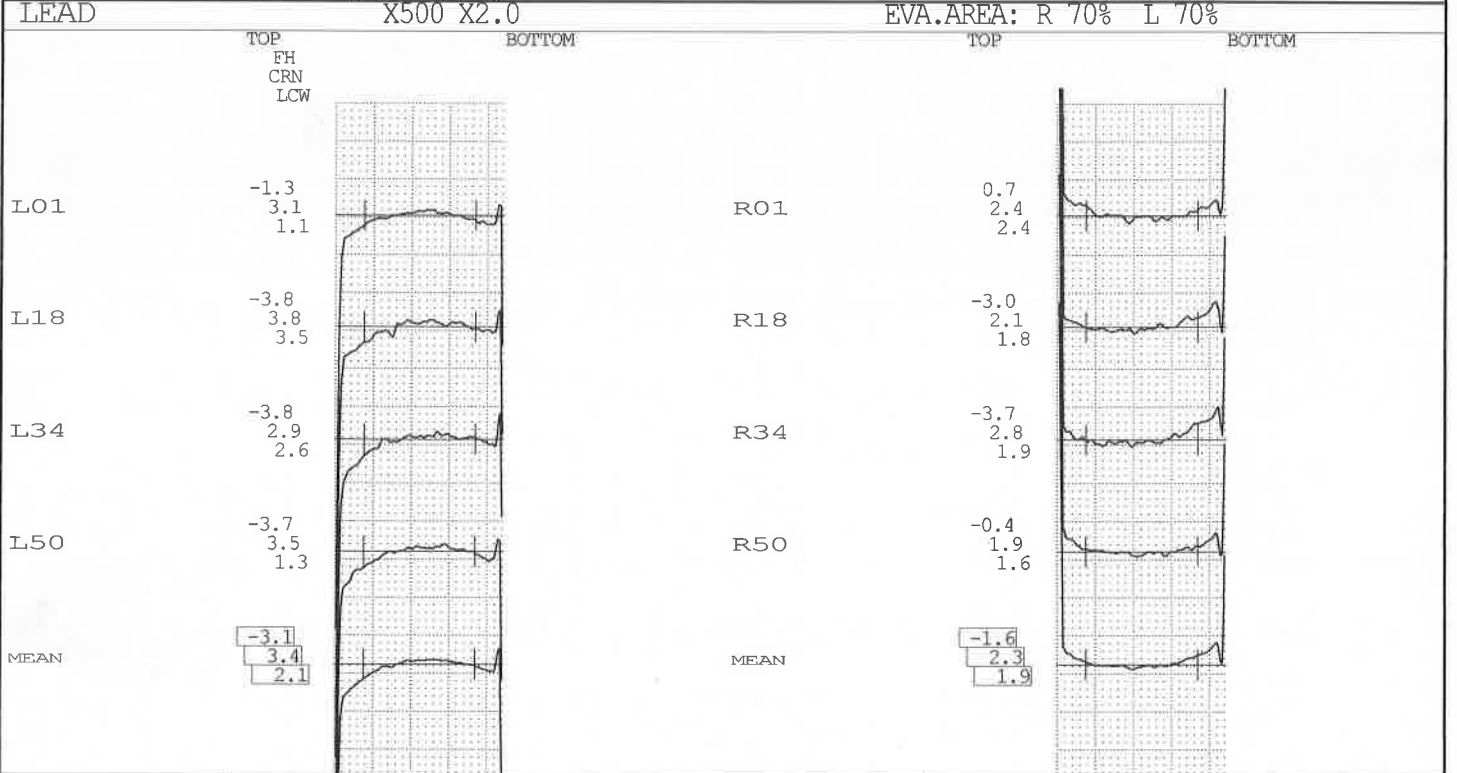
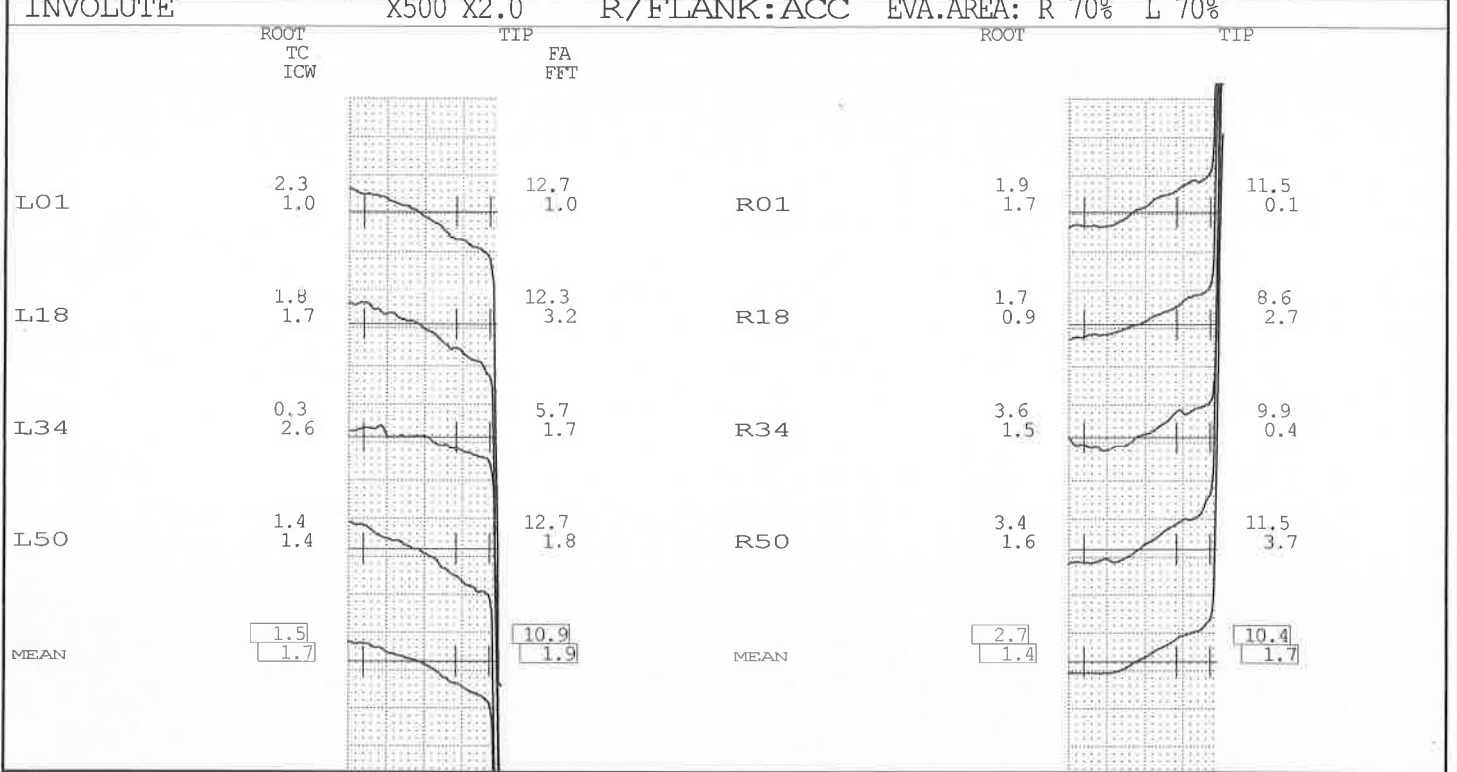
Decision
Approved
Rejected

Retention Period

Date

GEAR ACCURACY INSPECTION SHEET M.A.P.India Pvt.Ltd. (2nd Plant) (351056)

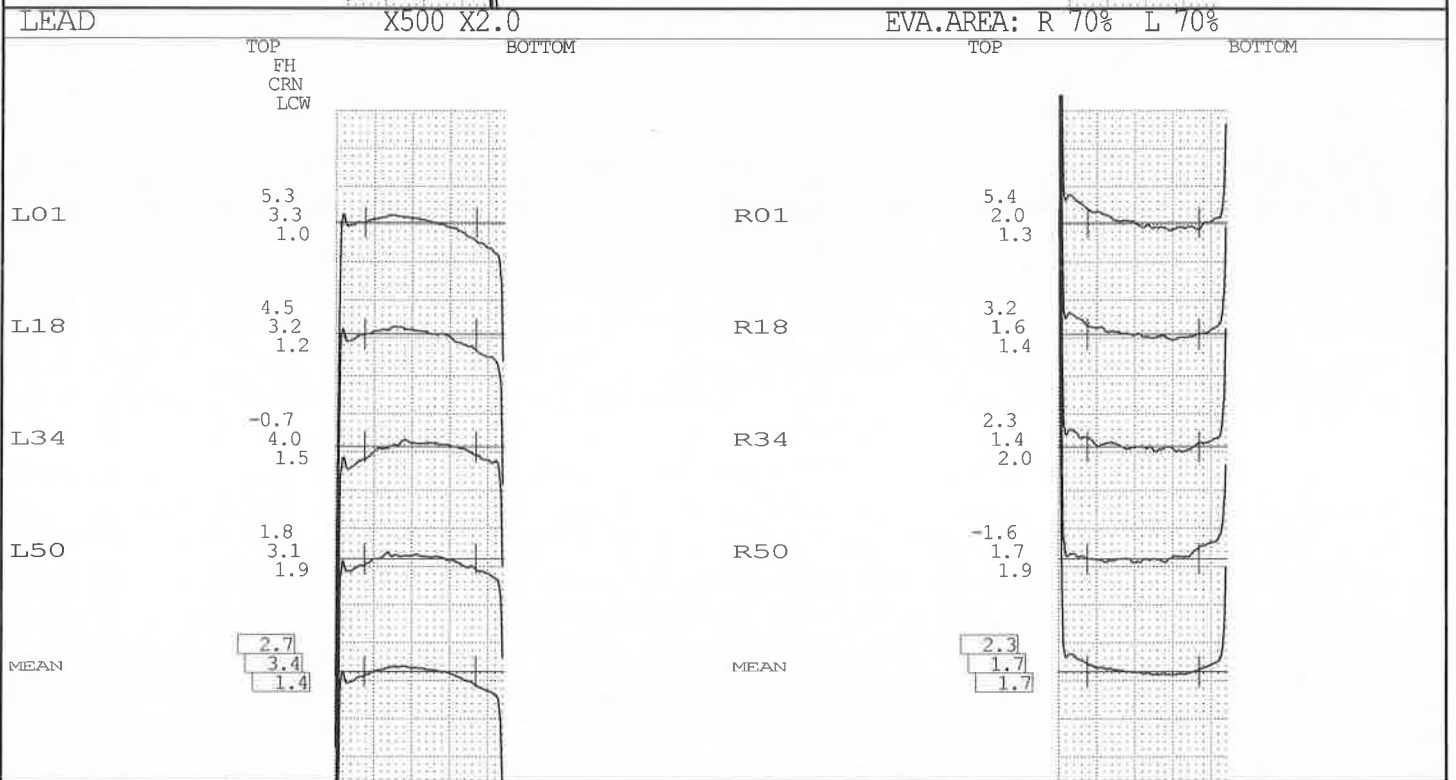
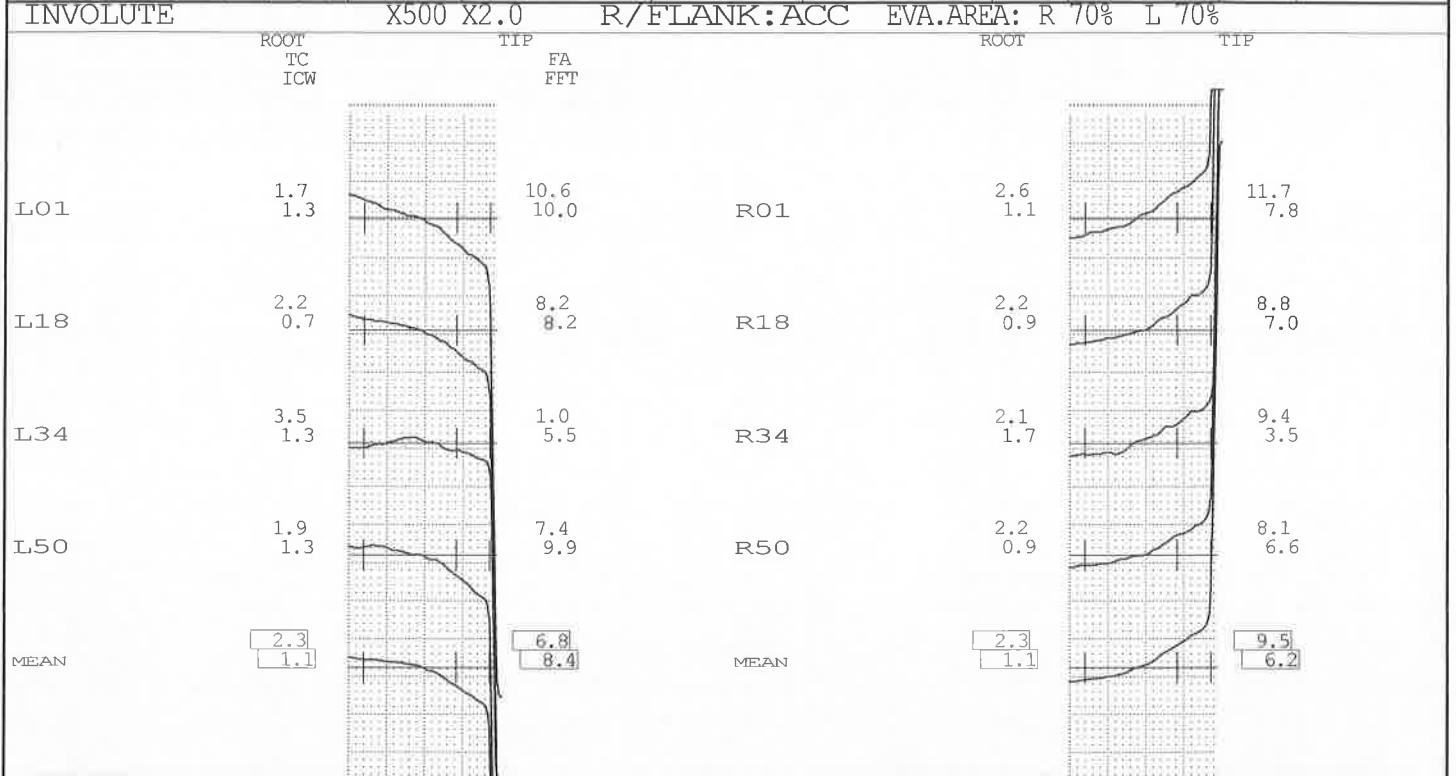
DWG.No.	23111-KON-D000-H1	KONA GEAR PRIMARY DRIVEN FINAL		DATE	2023/10/07	OPERAT	CONFIRMATION		
LOT.No.	-4388	R/O:- 0.018			06:53		(OK) / NG)		
NOTE		PROCESS	Nothing	O.P.D (B.T.L.)		Mn	1.75	Df	119.069
		Tool				Z	65	B	10.5
Smooth (50, 5, 2) (50, 5, 2)		Total		RUN OUT		FA	14.50	EL _{MIN}	8.718
						HA	00.000	I.L	1.120



	INVOLUTE				LEAD			
	FA	TC	ICW	FFT	FH	CRN	LCW	
L	TOLERANCE	2.0:12.0	0.0:4.0	0.0:4.0	0.0:10.0	-5.0:5.0	0.0:5.0	0.0:4.0
	MEAN	10.9	1.5	1.7	1.9	-3.1	3.4	2.1
	RANGE	7.1	2.0	1.6	2.2	2.6	0.9	2.3
R	TOLERANCE	2.0:12.0	0.0:4.0	0.0:4.0	0.0:10.0	-5.0:5.0	0.0:5.0	0.0:4.0
	MEAN	10.4	2.7	1.4	1.7	-1.6	2.3	1.9
	RANGE	3.0	1.9	0.7	3.6	4.4	0.8	0.8

GEAR ACCURACY INSPECTION SHEET M.A.P.India Pvt.Ltd.(2nd Plant)(351056)

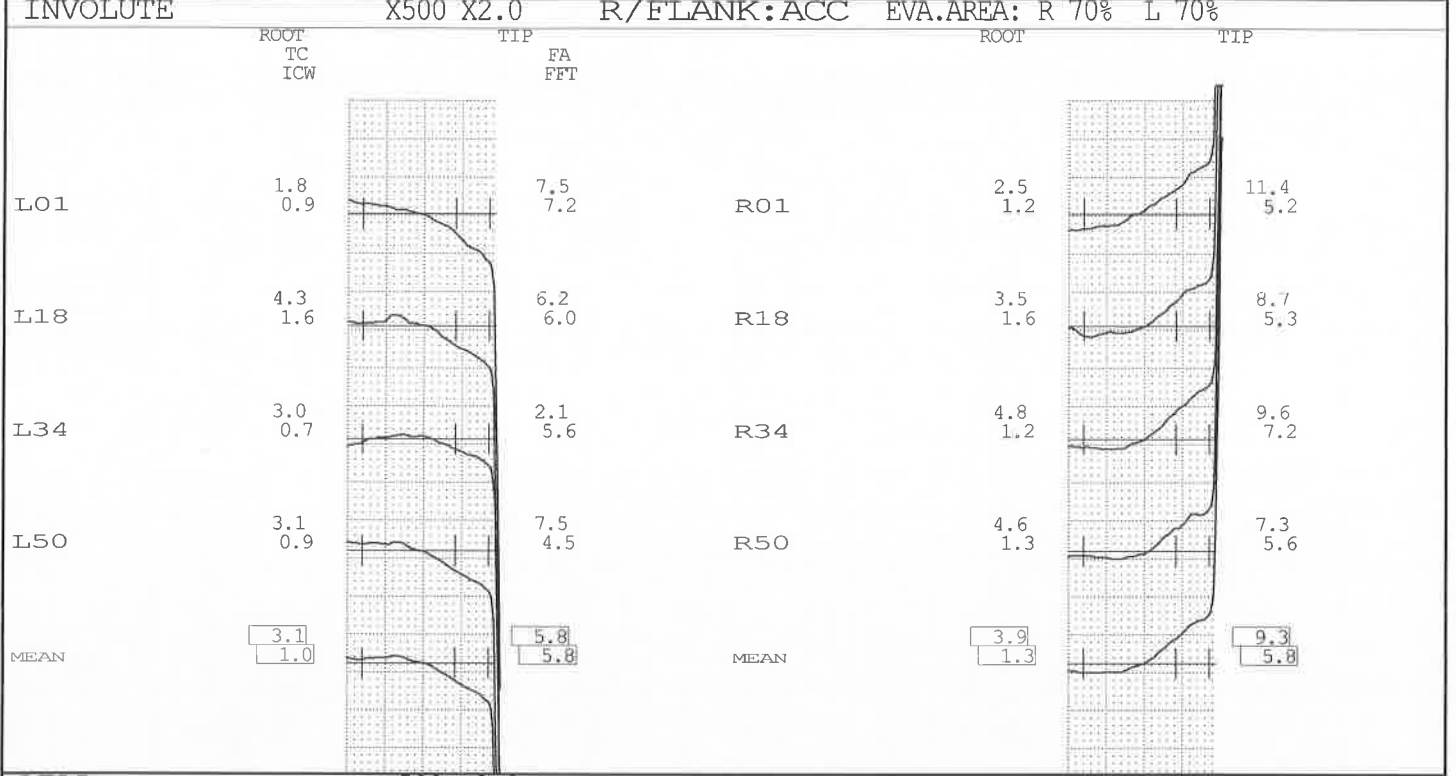
DWG.No.	23111-KON-D000-H1	KONA GEAR PRIMARY DRIVEN FINAL		DATE	2023/10/07	OPERAT	CONFIRMATION	
LOT.No.	-4401	R/O:- 0.022			18:20	<i>B</i>	(OK / NG)	
NOTE	Smooth(50, 5, 2)(50, 5, 2)	PROCESS Tool Total	Nothing	O.P.D (B.T.L.) RUN OUT	Mn Z PA HA	1.75 65 14.50 00.000	Df B EL _{MIN} I.L	119.069 10.5 8.718 1.120



	INVOLUTE				LEAD			
	FA	TC	ICW	FFT	FH	CRN	LCW	
L	TOLERANCE	2.0:12.0	0.0:4.0	0.0:4.0	0.0:10.0	-5.0:5.0	0.0:5.0	0.0:4.0
	MEAN	6.8	2.3	1.1	8.4	2.7	3.4	1.4
	RANGE	9.6	1.7	0.6	4.5	6.0	0.9	0.9
R	TOLERANCE	2.0:12.0	0.0:4.0	0.0:4.0	0.0:10.0	-5.0:5.0	0.0:5.0	0.0:4.0
	MEAN	9.5	2.3	1.1	6.2	2.3	1.7	1.7
	RANGE	3.6	0.5	0.9	4.3	7.0	0.6	0.7

GEAR ACCURACY INSPECTION SHEET M.A.P.India Pvt.Ltd. (2nd Plant) (351056)

DWG.No.	23111-KON-D000-H1	KONA GEAR PRIMARY DRIVEN FINAL			DATE	2023/10/07	OPERAT	CONFIRMATION
LOT.No.	-4402	R/O:- 0.020				12:24		(OK) / NG)
NOTE	Smooth (50, 5, 2) (50, 5, 2)	PROCESS Tool Total	Nothing	O.P.D (B.T.L.) RUN OUT	Mn Z PA HA	1.75 65 14.50 00.000	Df B EL _{mm} I.L	119.069 10.5 8.718 1.120



	INVOLUTE				LEAD			
	FA	TC	ICW	FFT	FH	CRN	LCW	
L	TOLERANCE	2.0:12.0	0.0:4.0	0.0:4.0	0.0:10.0	-5.0:5.0	0.0:5.0	0.0:4.0
	MEAN	5.8	3.1	1.0	5.8	3.8	3.8	1.4
	RANGE	5.5	2.5	1.0	2.7	4.9	1.1	1.3
R	TOLERANCE	2.0:12.0	0.0:4.0	0.0:4.0	0.0:10.0	-5.0:5.0	0.0:5.0	0.0:4.0
	MEAN	9.3	3.9	1.3	5.8	-0.1	2.5	1.9
	RANGE	4.2	2.3	0.4	2.0	4.1	0.7	1.3