

Evidences

Name of Operator :- <u>sonawane</u>		Date :- <u>26/11/23</u>		Shift :- <u>Day</u>									
Process Name & No. :- <u>50 Rough Grinding</u>		Part No :- <u>550LG06702/ XH (HMS/HMP-30 / 176.4 mm)</u>											
Mfg. Location :- <u>Plant-1 (W-14) / Plant-3 (F-66)</u>		Machine No. :- <u>133</u>		Lot No. :-									
Sr No.	Inspection Parameters	Inspection Method	Spl. Char. Class	Limits		Observations (In-process inspection is done for 5 Pcs/Hr but records only 1pc/2 hr)							
				LSL(-)	USL(+)	Set-up approval		In-process Inspection				Last piece Insp.	
1	Shank Dia	Micrometer		14.05	14.15	14.09 14.12		9.00	11.00	1.00	3.00		5.00
2	Taper	Micrometer		0.05 Max		0.03 0.02		0.02	0.02	0.02	0.03	0.02	0.02
3	Deep line mark On OD	Visual		No Deep line mark On OD allowed		OK		OK	OK	OK	OK	OK	OK
4	Burning Mark	Visual		No burning mark		OK		OK	OK	OK	OK	OK	OK
5	Shank Runout wrt Shank Dia.	Dial & stand		0.050 mm		0.03		0.02	0.02	0.03	0.03	0.02	0.02

Sr. No.	Parameters	Remark	Sr. No.	Specification	Remark
1	Grinding Wheel speed (1400-1500 RPM)	1420 RPM	5	Dressing Freq. (600 Nos)	OK
2	Grinding Wheel Grade (A-46/60)	A-46	6	Hydraulic oil Level (Must be in Green Zone)	OK
3	Regulating Wheel Grade(80/120RR)	80RR	7	Coolant level (Must be in Green Zone)	OK
4	Regulating wheel speed (10-45 Hz)	28 RPM	8	Coolant Conc. (1%-4%)	3%

Note :- Plant 1 :- HEC, W-14 Satpur MIDC, Nashik, Plant 2 :- HEC, F-125, Satpur MIDC, Nashik, Plant 3 :- HEC, F-66, Satpur MIDC, Nashik

Inspected By: [Signature] Verified By: [Signature]

In-process Check sheet

Machine Number :- <u>ADM-02</u>		Date :- <u>26/11/23</u>		Shift :- <u>Day</u>			
Part Name / No :- <u>HEX</u>		Name of Inspector :- <u>Pitendra</u>					
Operation		Run Out on Groove Dia. wrt Threading					
0.70							
0.65							
0.60							
0.55							
USL 0.50							
0.45							
0.40							
0.35							
0.30							
0.25							
0.20							
0.15							
0.10							
LSL 0.05							
Time/Freq.	7	9	11	1	3	5	7
Obs. 1	0.45	0.17	0.07	0.34	0.47	0.25	0.23
Obs. 2	0.13	0.42	0.15	0.32	0.22	0.43	0.09
Obs. 3	0.27	0.13	0.24	0.13	0.33	0.45	0.48
Obs. 4	0.34	0.27	0.12	0.45	0.27	0.40	0.32
Obs. 5	0.66	0.43	0.47	0.29	0.43	0.04	0.24

Note :- If Dimension goes above/below Specification then stop the machine & inform to Supervisor/QA Engg.

Actions :-

Inspected By - [Signature] Approved By -

Run Chart