

Part No.520JT00302	Current Opr: Blanking & Piercing	Date :-
Part Name: Plate CL.3W45	M/c No.	Shift :-

				SET-UP APPROVAL REPORT					Time:
Characteristics	Specifications	Spec Char. Class	Measurement Technique	1	2	3	4	5	Remarks
Outer Diameter	110.00± 0.25		DVC						
Inner Diameter	90.00+0.30		DVC & Spline Gauge						
Inner Diameter	82.00+0.20		DVC & Spline Gauge						
NO of Teeth	24		Visually Counting & Spline Gauge						
Width	6.20+0.20		DVC						
Thickness	2.00±0.05		MM						
Flatness	0.2 Max	SC	Feeler Gauge						
Heavy Burr	Not Allowed		visual						
Line Mark	Not Allowed		visual						
Undercut	Not Allowed		visual						
Tool Mark	Not Allowed		visual						
Rust	Not Allowed		visual						
Bridge Width	2.00 ± 0.2		DVC						
Air Pressure (Poka-yoke)	06 ~ 08 Kg/ Cm2		Visual						

Quality Insp. Sign**Production Sup. sign:**

INPROCESS INSPECTION REPORT																
Characteristics	Product Specifications	Spec Char. Class	Measurement Technique	Observations										Remarks		
				1		2		1		2		1			2	
Outer Diameter	110.00±0.25		DVC													
Inner Diameter	90.00+0.30		Spline Gauge													
Inner Diameter	82.00+0.20		Spline Gauge													
NO of Teeth	24		Visually Counting & Spline Gauge													
Width	6.20+0.20		Spline Gauge													
Thickness	2.00±0.05		MM													
Flatness	0.2 Max	SC	Feeler Gauge													
Heavy Burr	Not Allowed		visual													
Line Mark	Not Allowed		visual													
Undercut	Not Allowed		visual													
Tool Mark	Not Allowed		visual													
Rust	Not Allowed		visual													

LAST FIVE PIECE REPORT														Time:	
Characteristics	Product Specifications	Spec Char. Class	Measurement Technique	Observations										Remarks	
				1		2		3		4		5			
Outer Diameter	110.00±0.25		DVC												
Inner Diameter	90.00+0.30		Spline Gauge												
Inner Diameter	82.00+0.20		Spline Gauge												
Width	6.20+0.20		Spline Gauge												
NO of Teeth	24		Visually Counting & Spline Gauge												
Thickness	2.00±0.05		MM												
Flatness	0.2 Max	SC	Feeler Gauge												
Heavy Burr	Not Allowed		visual												
Line Mark	Not Allowed		visual												
Undercut	Not Allowed		visual												
Tool Mark	Not Allowed		visual												
Rust	Not Allowed		visual												

Previous opr.: R/M Receiving**Next Opr.: Deburring**

Approved By:-