



TUBE PRODUCTS OF INDIA



SET UP APPROVAL / INPROCESS INSPECTION REPORT - KOPG

Sr. No.	Parameters	Specification	Method of check	Frist Observed			Second Observed			Doc No.: TIGE/QA/PR/01 , Doc Date: 15-08-2019			
				Ⓐ	Ⓑ	Ⓒ	Ⓐ	Ⓑ	Ⓒ	Rev No.: 02 , Rev Date: 20-02-2024			
				1st 3 Pis			Last 2 Pis			1st 3 Pis			Last 2 Pis
			1	2	3	1	2	1	2	3	1	2	Shift :
1	Caulking Side OD	28.5	Snap Gauge										Date :
2	Caulking ID	26.05+0.05	Plug gauge										Machine Name :
3	Caulking Side Run Out	0.08	HG/Dial										Operator Name :
4	Caulking Bore Depth	46.10 +0.10	Plug gauge/Vernier										Operation Description :
5	Groove Width	8.6 ± 0.2	Vernier										Set Up Part Rejection :
6	Inner Dia	26.3 ± 0.1	Plug gauge										
7	Inner Dia	26.5 ± 0.1	Plug gauge										
8	Runout	0.1	HG/Dial										
9	Dimension	3.00 + 0.1	Vernier										
10	Groove Dia	28.20 -0.2	Snap Gauge										
11	Total Length	288.3±0.2	Height Gauge										
12	Drilling length	50.50 ± 0.2	Vernier										
13	Hole Dia	1.5	Pin Gauge										

INPROCESS INSPECTION

Sr. No.	Parameters	Specification	Method of check	Hourly Checking Nos	Hourly Observations											Remarks	
					08:00	09:00	10:00	11:00	12:00	01:00	02:00	03:00	04:00	05:00	06:00		07:00
1	Caulking Side OD	28.5	Snap Gauge	5 nos													
2	Caulking ID	26.05+0.05	Plug gauge	5 nos													
3	Caulking Side Run Out	0.08	HG/Dial	5 nos													
4	Caulking Bore Depth	46.10 +0.10	Plug gauge/Vernier	5 nos													
5	Groove Width	8.6 ± 0.2	Vernier	5 nos													
6	Inner Dia	26.3 ± 0.1	Plug gauge	5 nos													
7	Inner Dia	26.5 ± 0.1	Plug gauge	5 nos													
8	Runout	0.1	HG/Dial	5 nos													
9	Dimension	3.00 + 0.1	Vernier	5 nos													
10	Groove Dia	28.20 -0.2	Snap Gauge	5 nos													
11	Total Length	288.3±0.2	Height Gauge	5 nos													
12	Drilling length	50.50 ± 0.2	Vernier	5 nos													
13	Hole Dia	1.5	Pin Gauge	5 nos													

Ⓐ Shift beginning

Ⓑ Insert Change

Ⓒ New Job

Check by : Name & Signature

Verified by : Quality In-charge