



FINAL INSPECTION STANDARD



Model HONDA

16.10.2020

Part Name : Fork pipe Macined (k86)

Date

Part No. ---

Rev. No.

XC

Cust F1FA013050

Sr. No.	Parameter	Specification	Gauge Type	Availability	Resp.	Target Date	Remark
1	Outer Diameter (mm)	30.10 (+0.08/0.0)	OD Micrometer	Yes	---	---	
2	Inner Diameter (mm)	24 (+0.0/-0.15)	Vernier	Yes	---	---	
3	Total Length	288.3± 0.2	Digital Height Gauge	Yes	---	---	
4	Drilling Distance	50.5±0.2	Vernier	Yes	---	---	
5	Caulking side Bore Dia	26.05+ 0.05	plug gauge/Bore gauge	Yes	---	---	
6	Caulking side Bore Runout	0.08	Dial	Yes	---	---	
7	Caulking side OD Plane Turning Dia	Ø28.5	Snap Gauge/ Micrometer	Yes	---	---	
8	Caulking side OD Turning Total Length	10	vernier	Yes	---	---	
9	Caulking side OD Plane Turning	4	vernier	Yes	---	---	
10	Caulking side OD Chamfer	0.2x45°	As Per Prog/ prof .proj	Yes	---	---	
11	Caulking side ID Chamfer	0.5x45°	As Per Prog/ prof .proj	Yes	---	---	
12	Cocking side Bore Depth	46.1+ 0.1	plug gauge/Vernier	Yes	---	---	
13	Caulking side ID Chamfer	0.2x45°	As Per Prog/ prof .proj	Yes	---	---	
14	OD Length-2	8	vernier	Yes	---	---	
15	Groove Dia	Ø29±0.1	Micrometer	Yes	---	---	
16	Concentricity	0.1	Dial Gauge	Yes	---	---	
17	Straightness	0.08/200	Dial Gauge	Yes	---	---	
18	Circularity	0.01	Dial Gauge	Yes	---	---	
19	Threading side ID Chamfer	0.5x45°	As Per Prog/ prof .proj	Yes	---	---	
20	Threading Minor Dia	25+0.12/+0.08	plug gauge	Yes	---	---	
21	Threading Size	M26 x 1-6H	Thread Gauge	Yes	---	---	
22	ID Chamfer	1x30°	As Per Prog/ prof .proj	Yes	---	---	
23	Threading side Total Bore Depth	24	vernier	Yes	---	---	
24	Thread Depth	20+ 1	vernier	Yes	---	---	
25	Threading side OD Chamfer	3X5°	As Per Prog/ prof .proj	Yes	---	---	
26	Threading side Bore Depth	7±0.2	Depth gauge	Yes	---	---	
27	Threading side Bore Runout	0.1 wrt B	Dial Gauge	Yes	---	---	
28	Threading side Bore Dia ©	26.3+ 0.1	plug gauge/Bore gauge	Yes	---	---	
29	Threading side ID Chamfer	1x30°	As Per Prog/ prof .proj	Yes	---	---	
30	Free From Rust, Burr, and Scratches	Visual	Visual	Yes	---	---	

Remark-

Prepared By

Approved By