

JaiRaaj Global		FIRST PIECE APPROVAL AND INPROCESS INSPECTION REPORT										DOC. NO: F/ QA / 02							
												Rev No. 01							
Part Name: GAS CAP		Part No : S2FF00802B			Operation Name: Injection Moulding			Operation Number: 60			M/C No:								
Operator Name:		Date:			Shift:			Material - Nylon6 + GF 30%											
		First Setting Approval for 5 Short					Machine Parameter (At the time of Setup)												
S.NO	Parameter	Specification	Inspection Method	1	2	3	4	5	Parameter	Specification	Insp. Method	Observation	Remarks						
1	Dia	38 ± 0.1 mm	D.V.C.						Pre - Heating	100 ± 20°C	D.T.C								
2	Total Height	22.0 + 0.1 /-0 mm	D.V.C.						Temp Zone 1	260 ± 20°C	D.T.C								
3	Dia	5.15 - 0.1 /+0 mm	D.V.C.						Temp Zone 2	230 ± 20°C	D.T.C								
4	Dia	27.5 + 0.1 /-0 mm	D.V.C.						Temp Zone 3	220 ± 20°C	D.T.C								
5	Dim.	2.4 + 0.1 /-0 mm	D.V.C.						Temp Zone 4	225 ± 20°C	D.T.C								
6	Dim.	1.9 + 0.2 /+0 mm	D.V.C.						Locking Pr.	1850 ± 200 PSI	P.G.								
7	Dia	1.2 + 0.2 / -0 mm	D.V.C./PP						Injection Pr.	950 ± 200 PSI	P.G.								
8	Dim.	0.8 + 0.1 /-0 mm	D.V.C./PP						Cooling Time	17 ± 2 Sec.	Timer								
9	Dia	17.1 ± 0.1 mm	D.V.C.						Injection Time.	8 ± 2 Sec.	Timer								
10	Dia	4.8 +0.1/-0.05	D.V.C./PG																
11	Dia	15.5 ± 0.1 mm	D.V.C.																
12	Colour	Natural White	Visual																
13	Appearance	No Shrinkage, Short Mould, Moulding defect, Burr & Sharpe Edge.	Visual																
JaiRaaj Global		In-process Observation										Machine Parameter (Periodic Checking)					DOC. NO: F/QA/04		
														Rev No. 01					
														Rev Date 08.03.2024					
S.NO	Parameter	Specification	Method of Inspection	Time	Time	Time	Time	Time	Parameter	Specification	Insp. Method	Time	Time	Time	Time	Time	Remarks		
1	Dia	38 ± 0.1 mm	D.V.C.						Pre - Heating	100 ± 20°C	D.T.C								
2	Total Height	22.0 + 0.1 /-0 mm	D.V.C.						Temp Zone 1	260 ± 20°C	D.T.C								
3	Dia	5.15 - 0.1 /+0 mm	D.V.C.						Temp Zone 2	230 ± 20°C	D.T.C								
4	Dia	27.5 + 0.1 /-0 mm	D.V.C.						Temp Zone 3	220 ± 20°C	D.T.C								
5	Dim.	2.4 + 0.1 /-0 mm	D.V.C.						Temp Zone 4	225 ± 20°C	D.T.C								
6	Dim.	1.9 + 0.2 /+0 mm	D.V.C.						Locking Pr.	1850 ± 200 PSI	P.G.								
7	Dia	1.2 + 0.2 / -0 mm	D.V.C./PP						Injection Pr.	950 ± 200 PSI	P.G.								
8	Dim.	0.8 + 0.1 /-0 mm	D.V.C./PP						Cooling Time	17 ± 2 Sec.	Timer								
9	Dia	17.1 ± 0.1 mm	D.V.C.						Injection Time.	8 ± 2 Sec.	Timer								
10	Dia	4.8 +0.1/-0.05	D.V.C./PG																
11	Dia	15.5 ± 0.1 mm	D.V.C.																
12	Colour	Natural White	Visual																
13	Appearance	No Shrinkage, Short Mould, Moulding defect, Burr & Sharpe Edge.	Visual																
PREPARED BY:									APPROVED BY:										