







<b>Part Name:</b> GAS CAP				<b>Part No :</b> S2FF00802B					<b>Operation Name:</b> Injection Moulding			<b>Operation Number:</b> 60		<b>M/C No:</b>	
<b>Operator Name:</b>				<b>Date:</b>					<b>Shift:</b>			<b>Material - Nylon6 + GF 30%</b>			
				<b>First Setting Approval for 5 Short</b>					<b>Machine Parameter (At the time of Setup)</b>					<b>Remarks</b>	
<b>S.NO</b>	<b>Parameter</b>	<b>Specification</b>	<b>Inspection Method</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>Parameter</b>	<b>Specification</b>	<b>Insp. Method</b>	<b>Observation</b>			
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	15.5 ± 0.1 mm	D.V.C.												
11	Colour	Natural White	Visual												
12	Appearance	No Shrinkage, Short Mould, Moulding defect, Burr & Sharpe Edge.	Visual												

<b>JaiRaaj Global</b>				<b>In-process Observation</b>					<b>Machine Parameter (Periodic Checking)</b>					DOC. NO: F/QA/04	
														Rev No. 00	
														Rev Date 01.01.2018	

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	15.5 ± 0.1 mm	D.V.C.														
11	Colour	Natural White	Visual														
12	Appearance	No Shrinkage, Short Mould, Moulding defect, Burr & Sharpe Edge.	Visual														

**PREPARED BY:**

**APPROVED BY:**