

INPROCESS INSPECTION REPORT

Doc. Control
REV. 01

DATE: 22-2-2024

MACHINE NO.: CNC 23

SHIFT: Day

OPERATOR NAME: Babhuti Mishra

INSPECTOR NAME: Alok Kumar

DRAWING NO./ REV NO.: F2BZ038020

TARGI	440
ACTUL	
COMMULATIVE	
REJECTED PARTS	

8:30 ~ 9:30	9:30 ~ 10:30	10:30 ~ 11:30	11:30 ~ 12:30	12:30 ~ 1:30	1:30 ~ 2:30	2:30 ~ 3:30	3:30 ~ 4:30	4:30 ~ 5:30	5:30 ~ 6:30	6:30 ~ 7:30	7:30 ~ 8:30
46	46	46	46	23	46	46	46	46	46	46	46

LOSSES

- NO MATERIAL / TOOL
- NO ELECTRICITY POWER / AIR
- NO MAN POWER
- MACHINE BRAKE DOWN
- SETUP CHANGE
- MEASUREMENT & ADJUSTMENT
- LUNCH / TEA TIME
- TOOLCHANGE
- TOTAL LOSSES

8:30 TO 9:30	9:30 TO 10:30	10:30 TO 11:30	11:30 TO 12:30	12:30 TO 1:30	1:30 TO 2:30	2:30 TO 3:30	3:30 TO 4:30	4:30 TO 5:30	5:30 TO 6:30	6:30 TO 7:30	7:30 TO 8:30

CAP OIL LOCK 22

SL. NO.	DESCRIPTION	SPECIFICATION		INSTRUMENT	8:30 TO 9:30	9:30 TO 10:30	10:30 TO 11:30	11:30 TO 12:30	12:30 TO 1:30	1:30 TO 2:30	2:30 TO 3:30	3:30 TO 4:30	4:30 TO 5:30	5:30 TO 6:30	6:30 TO 7:30	7:30 TO 8:30	
		MIN.	MAX.														
1	OUTER DIA	21.95	22	DMM	21.95	21.95	21.96										
2	OUTER DIA	19.9	20.1	DVC	20.05	20.05	20.04										
3	INTERNAL DIA	10.45	10.55	DVC	10.54	10.53	10.52										
4	INTERNAL DIA	18.32	18.42	DVC/PPG	OK	OK	OK										
5	WALL THICKNESS	5.55	5.65	DHG/DVC	5.58	5.58	5.59										
6	DEPTH	32.3	32.5	DHG/DVC	3.43	3.45	3.44										
7	TOTAL LENGTH	37.9	38.1	DVC	OK	OK	OK										
VISUAL INSPECTION DEFECTS : OD LINES, OD UNCLEAR, FACE UNCLEAR, ID LINES,,					OK	OK	OK										

LEGENDS: DMM-DIGITAL MICROMETER, DVC-DIGITAL VERNIER CALIPER, DHG-DIGITAL HEIGHT GAUGE, OD-OUTER DIAMETER

CHECKED BY:

APPROVED BY:

24, 11:42