



Cast 4 Aluminium Pvt Ltd

D-187/17/1 Five star Industrial area MIDC Shendra, Aurangabad-431154

Doc.No: F/PRD/15
Rev.No: 00
01.04.2018

FIRST FIVE PIECE APPROVAL & INPROCESS INSPECTION REPORT

OPERATOR NAME : *शशिकांत शिंदे*

COMPONENT NAME : **K70 WHEEL CLUTCH**

CNC Turning 1st Set Up

Doc-Available On Station: 1) Drawing 2) Control Plan

MACHINE NO. **CNC-08**

3) SOP

4) Inspection Agreement

OPERATION **ISL**

Calibrated Gauges & Instruments

SR No.	PRODUCT SPECIFICATION	ACTUAL DIMENSION	CHECKING METHOD	FFPA READING BY INSTRUMENTS					HOURLY READING										
				1	2	3	4	5	8AM	9AM	10AM	11AM	12PM	1PM	2PM	3PM	4PM	5PM	6PM
1	ID	31.0-0.15/+0.05	PLUG GAUGE/DVC	31.11	31.10	31.09	31.12	31.10	OK	OK	OK	OK	OK	OK	OK				
2	TEETH ID RUNOUT	0.15 Max	DIAL & MANDRELL	0.09	0.10	0.13	0.10	0.13	0.12	0.10	0.13	0.12	0.13	0.10					
3	ID Chamfer	0.1x45°	VISUAL	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK					
4	VISUAL	FREE FROM BURR/ RUST/ CRACK	VISUAL	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK					
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QUALITY LINE INSPECTOR SIGN : *[Signature]*

QUALITY INCHARGE SIGN : *[Signature]*