

FIRST PIECE CUM PATROL INSPECTION REPORT

PREMIER SEALS (I) PVT LTD.		CUSTOMER NAME : -ENDURANCE				MACHINE NO.									
DRAWING NO. F2A V00 6020		PS NO. 22022		PART NAME : BELLOW				DATE:-							
				REV: XC 30.09.2015				SHIFT:-							
Sr.No.	PARAMETERS TO BE CHECKED	SEPCIFICATION	METHOD OF INSPECTION	FIRST PIECE INSPECTION OBSERVATIONS (Should Be carried out Daily)											
				DATE / SHIFT											
1	Process Parameters														
a	Loading weight	134 ± 3 Gms.	Weighing Balance												
b	Curing Time	3 ± 1 MIN.	Digital Watch												
c	Curing temperature	180 ± 5 ° C	Temp.Indicator												
d	Pressure	2500 + 500 PSI ( 140 TO 210 kg/cm <sup>2</sup> )	Pressure Gauge												
e	Compound	EB 70	Route Card												
			batch No.												
2	Product Parameters Visual			PATROL INSPECTION (Should Be carried out Four hourly)											
a	1.FREE FROM- CRACK, RUBER LESS, OVER CURE, UNDER CURE, AIR LOCK, CUT MARK, DAMAGE, Foreign Particles, Carbon Deposition, etc.		Visually	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30	7.30 - 11.30
				11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30	11.30 - 3.30
	2.Part Should be tear trim			3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30	3.30 - 7.30
	3.Identification On Part:- PS, cavity no etc.														
	Checked By:														
	Approved By:														
3	Product Parameters Dimensional		Cavity No.	13	14	15	16	17	18	19	20	21	22	23	24
a	INNER DIAMETER	φ 33.0 - 0.5 MM	Vernier Caliper												
b	INNER DIAMETER	φ 49 ± 0.50 MM	Vernier Caliper												
d	HEIGHT	223.0 ± 0.50 MM	Height gauge / Vernier Caliper												
e	THICK	1.50 ± 0.20 MM	Vernier Caliper												
4	Performance Test														
a	HARDNESS	70 ± 5 SA	DURO METER (ON BUTTON)												
b	JUDGEMENT	OVER ALL	OK / Not OK												
c															
D															
	Checked By:														
	Approved By:														
NOTE	1) During first pc approval check all cavities record observation in this report, If NC, show it to QA Head for suitable decision. If first PC OK Run Production 2)Last pc inspection for all cavities to be done before unloading If NC QA Head will take suitable decision for further action 3) In situation of Nc during first Pc of next shift, then hold material, of previous shift and segregate										Abnormal Situation Status				
											Abnormal Situation	Time In Minutes	Status	Action	
											1) Power Fail				
											2) Tool Damage				
											3) Maintenance Problem				