A PREMIER GROUP COMPANY
PREMIER SEALS (INDIA) PVT LTD.

FIRST PIECE CUM PATROL INSPECTION REPORT

Doc No .: FMT/QA/042
Rev. No. & Date :- 03/ 02.09.2022

PREMIER SEALS(I) PVT LTD.	CUSTOMER NAME : - ENDURNCE	MACHINE NO.	
DRAWING NO. / PS NO.	PART NAME : - BELLOW	DATE:-	
F2A V00 6020 / 22022	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 º C	Temp.Indicator													
d	Pressure	2500 + 500 PSI (140 TO 210 kg/cm²)	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	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	11.30 - 3.30
	2.Identification On Part:- PS, cavity no etc.			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	3.30 - 7.30
	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													
f	Flash Thick	0.50 ± 0.10 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) Maintenace Problem			