		BG FASTENING AND ENGINEERING INDUSTRIES PVT LTD															Doc No :	32/F/02			
		INPROCESS INSPECTION REPORT FOR ROLLING															Rev. No.:	03			
AEL NO :		8525	DESCRIPTION:		M10x1.5X30 SHCS			Materi al					M/C No.			SHIFT		DATE :-			
SR. No.	Parameter /Description	Specification	Measurement Sample method Size		Insp. Freq.	Resp Record		OPERATOR									INSPECT	OR SUPERVI		RVISOR	
1	Major Diameter	9.732 ~ 9.968	Micrometer	- 5 No. - 5 No.	- Every Hour - Every 4 Hour	- Operator - Inspector	- Insp. Report														
2	Pitch Diameter	8.862 ~ 8.994	Pitch Micrometer	- 5 No. - 5 No.	- Every Hour - Every 4 Hour	- Operator - Inspector	- Insp. Report														
3	0	M10X1.5-6g Go / Nogo	Thread Ring Gauge	50 No.	- During setup Hour (No record) - Every 4 Hour	Operator - Operator - Inspector	- Insp. Report														
4	Thread run-out	3.0 max.	Vernier Caliper	- 5 No. - 5 No.	- Every Hour - Every 4 Hour	- Operator - Inspector	- Insp. Report														
5	Thread Length	29.70 ~ 30.30	Vernier Caliper	- 5 No. - 5 No.	- Every Hour - Every 4 Hour	- Operator - Inspector	- Insp. Report														
6	Pointing Angle	1.5X45°	Profile Projector	1 No.	Every Setting Change	Inspector	- Insp. Report														
7	^	No thread lap	Magnifying glass	- 5 No. - 5 No.	- Every Hour - Every 4 Hour	- Operator - Inspector	- Insp. Report														
8	Visual Defect	Free from Crack, Burr, Pitting, Extra Material,	Visual	- 5 No. - 5 No.	- Every Hour - Every 4 Hour	- Operator - Inspector	- Insp. Report														
9	Speed	As Per Product master sheet	Digi meter	-	Every Setting Change	- Inspector	- Insp. Report														
10		4 ~ 6 kg/cm2	Pressure gauge	-	Every Setting Change	- Inspector	- Insp. Report														
9	1. Visual Machine Condition	1. No Left Over Parts Around The Machine	Visual	-	Every Setting Change	- Inspector	- Insp. Report														
*Drawing Revision No. :						TIME															
Operator Sign																					
					Inspector Sign																