		BG FASTENING AND ENGINEERING INDUSTRIES PVT LTD															Doc No :	32/F/02			
		INPROCESS INSPECTION REPORT FOR ROLLING															Rev. No.:	02			
AEL NO :		8525	DESCRIP	ΓΙΟΝ:	M10x1.5X30 SHCS			Materi	i Batch				M/C No.		SHIFT		DATE :-				
SR. No.	Parameter /Description	Specification	Measurement method	Sample Size			Record					PERATOR						INSPECT	OR	OR SUPERVISOR	
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		M10X1.5-6g Go / Nogo	Thread Ring Gauge	- 5 No. - 5 No.	- Every Hour - Every 4 Hour	- 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	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		As Per Product master sheet	Digi meter	-	Every Setting Change	- Inspector	- Insp. Report														
10	Air Pressure	4 ~ 6 kg/cm2	Pressure gauge	-	Every Setting Change	- Inspector	- Insp. Report														
9		1. No Left Over Parts Around The Machine	Visual	-	Every Setting Change	- Inspector	- Insp. Report														
*Drawing Revision No. : TIME																					
Operator Sign																					
					ı	Inspector Sign															