



INPROCESS INSPECTION REPORT

Deptt./ Sec. - Quality

P.N DIE CASTINGS PVT,LTD

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Stage/ Op. No.		M/c Name/ No.	Date		Part Name	Part No	Customer					Next Operation	
CASTING					CCLH PULSER		ETL					FETTLING	
Sr. No.	Parameters	Specification	Method	Frequency	Shift wise Inspector Observations								Remarks
					8:00 AM	11:00 AM	2:00 PM	5:00 PM	8:00 PM	11:00 PM	2:00 AM	5:00 AM	
1	Resting pad thickness	1±0.1	HG/ DVC	1nos/3hrs									
2	Dowel hole (4 place)	7±0.25	DVC	1nos/3hrs									
3	Counter depth (7 place)	2±0.25	DVC	1nos/3hrs									
4	Counter depth at ring area (3 place)	1.5±0.25	DVC	1nos/3hrs									
5	Warpage	0.5 max	HG	1nos/3hrs									
6	Dimension	29.45±0.25	HG	1nos/3hrs									
7	Dimension	51.50±0.25	HG	1nos/3hrs									
8	Dimension	54.9±0.25	HG	1nos/3hrs									
9	U Slot width	6.0±0.25	DVC	1nos/3hrs									
10	U Slot depth	13.30±0.25	DVC	1nos/3hrs									
11	Oil gallery dia	6.5±0.1	DVC	1nos/3hrs									
12	Slid Area	VISUAL CHECKED SLIDE AREA SUCH AS MISMATCH	Visual	1nos/3hrs									
13	Appearance	free from burr dent damage e/m	Visual	1nos/3hrs									
		Pill off	After shotblast	1nos/3hrs									
		Free from non filling soldering ,crack	Visual	1nos/3hrs									
		Free from cold shot and catching	Visual	1nos/3hrs									
		Mounting hole pin bend	Pin gauge	1nos/3hrs									
APPROVED BY-				(Q.A) Sign.									
Legends:- HG-Height gauge,DVC-Digital vernier caliper,PPG-Plain Plug gauge,TPG-Thread plug gauge,APG-Air plug gauge													