



INPROCESS INSPECTION REPORT

Dept./ 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
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								
APPROVED BY:-				(Q.A) Sign.								

Legends:- HG-Height gauge,DVC-Digital vernier calliper,PPG-Plain Plug gauge,TPG-Thread plug gauge,APG-Air plug gauge
 PNDC2/FQA/001 A REV0.0

Date : 1/12/2022