Cust	omer							ROU	LE C	RD (C	DF)				T/C	No.: -				
P.O. No./Line Item:				Date:		JCC No.:						Order Qty:				Initials	& Signatur	o after		
Die #:					Net Wt.: #REF!		REF!	Cut Wt:		#REF!		Sr. No.					Dept	comp	oletion of pro	ocess
Product Name:			Material Grade:	#		#REF!		Cust Forgng Drg		#REF!		Rev. No. #REF!								
Part. No.:					Rev. No.			Process		-										
Quality Plan:		#REF!		Rev. No.:	#	REF!	_	MS No.:				Rev. No.:-	#REF!							
Generic Spec	c.		#REF!		Rev. No.:	#REF!		-	PSL:		REF! Ex-works		-			-				
Cust Finish I	Org		#REF!		Rev. No.: #REF!		TP		I REQD :		•	#F	REF!			MQC / PPC				
MPS No :		Rev. No.:			.: FSL Level :				Materi	ial Group:		-								
									Test	Mechanical		Dime								
Inspection Point as per qualifier Customer requirer			H - Hold W - Witness M - Monitor		Stages	Raw material	Forging	Heat treatment	piece stamping	Mechanical Testing	Hardness	NDE	Dimn. Checks	Certification						
		N- None of th		the above Inspection Points																
						ATERIAL	CHEMIS	TRY	l	l		Į	l							
Elem	nents	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-				
Actual	values																Spectro			
M	in																Lab			
	ax																			
						R/M	ALLOTM	 FNT												
Bar No.: -			H.No.: -			Section :			Mill Red	luction rat	io:-		No. of E	Bars used	>		MQC			
			Heat Cod	e:-		Work Instruction for RM Inspection, HC and RM :-30-WI-MQC-04														
						R/M CUTTING														
Bar No.: -		2 / 2	Cut Wt:-		40 DE DD 00	Section:-											PRODU CTION			
Ref Cutting Schedule :-40-DF-PR-20 Production Date:								RGING		cnines, B	and saw	s.:-30-W	I-PR-02							
						•	#REF!	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		ieces fora	ed: –									
Production Unit:																				
	·			•						on Ratio of					•					
Specified Tri			MIN		Actual Te	emp:			Reducti	on Ratio of	f Part : -						PRODU CTION			
TP Size: Sacrificial TP (QTC) Qty.:- Reduction Ratio of Part: - Reduction Ratio of Part: - Pls. refer Forging method sheet 40-DF-TD-06-									6-											
Cooling method: Die No.																				
					or equal to Fo PR-15/30-WI-F								0-WI-PI	R-07/30-V	VI-PR-08/3	0-WI-				
		WI-FR-13/3	#REF!	REV.NO.	0	K-10/30-	WI-FR-17/5	O-WI-FK												
														QC						
				Wor	k Instruction F	or Hot ins	pection & L	ay Out Ins	spection	-30-WI-QA	-04		<u> </u>							
Pls refer HT	Process Shee	t		40-DF-H	Γ-05					HEAT	TREATI	MENT								
Cooling Med	ia after Anne	aling / Norm	alizing (T	ick As App	licable): -	Air / Water														
Cooling Media after Annealing / Normalizing (Tick As Applicable): – Quench Media after Hardening (Tick As Applicable): –					Water / Oil / Polymer				As Queno	h Hardne	ss (1 / Ch	arge): –	нвм			нт				
Cooling Media after Tempering (Tick As Applicable): –					Air / Water															
Reference-30-WS-HT-01work Standard for Heat-Treatment Guideline latest					revision				Loadin	g Patte	rn:									
Used Fu	rnace No																			
		SA / IA / ANN / NORM			RM	HARDENING				1ST TEMPERING			IG 2ND TEMP			RING / SF	₹	Quenching BATH TEMP.		
Customer		МІ	MIN N		MAX	MIN		MAX		MIN		MAX		MIN		MAX		START	MAXIMUM	FINISH
Specification																				
.,		SPECIFIED (WHF)		ACTUAL		SPECIFIED (WHF)		ACTUAL		SPECIFIED (WHF)		ACTUAL		SPECIFIED (WHF)		ACTUAL			ACTUAL	
Batch No. / Date	Qty.							-	1				l			-	1			
		TEMP	TIME	TEMP	TIME	TEMP	TIME	TEMP	TIME	TEMP	TIME	TEMP	TIME	TEMP	TIME	TEMP	TIME	(°C)	(°C)	(°C)
															Ann	rovec	l Bv· I	HOD N	IOC	l
Date		HT Lot No. Split Route		a Card Dataile	Quantity Sent		Sant To S		ubcontractor		Quantity. Received		Approve				& Signature	after comp	letion of	
Date		Spiit Rou			o Jaiu Details.	equality Selft			sent 10 St		IDCUITE ACTOR		«uamity. Réceived		Date of Receipt Dept			pro	cess	
													PPC							
Customer Spe	cific Requireme	nt - Yes/ No if	Yes please	specified.										<u> </u>	<u> </u>					

	HARDNESS TEST RESULT														Department		Initials & Signature after completion of process	
Hardı	ness Procedu	re	Rev	v. No.	Locatio	on	Refer 30-WI-HT-05 WI for Hardness location/Part Drawing											
#REF!			#R	REF!			Hardness Range : -				#REF!			HBW				
Refer Latest Revision of 30-WI-HT-13 WI / 30-WI-HT-14 V					/I / 30-WI-HT-	-03 WI												
Qty Checked: –				Q	ty. ok :-		Qty. Hard:-					Qty for R	ework: –					
Qty Released:-															нт			
					ME	ECHANICA	AL TEST RES	BULTS										
Name Hardness UTS Y.S.					Elg.	R.A.		CVN				TP LO	CATIO	N				
Uni	it	0	0	0	0	0		0										
Min	n	0 0 0 0 0					0									М	QC	
Max	Max 0 0 0				0	0												
Lab Repo	ort No.																	
Disposi	ition	←					01	K / NOT OK	-	J					→			
VOLUMETRIC	NDE (UT)	WI	for 30-WI	-UT-01 Ultr	asonic Examina	ation	Responsibility NDE				actor for S chining/Li			of	APPLICABI APPLICA		Respon	
							Inspec		Vendo	or Name	Qty			Received Qty Reje			sibility	
APP	PLICABLE / NOT	APPLICABLE					Initial & Signature After Completion of Process											
	OK Ot. 6				Auth. By MQC													
	OK Qty Sent		OK Qy		Qty Rejected													
																	PPC	
Proced	dure	#REF!			Rev. No.	#REF!			Refe	erence	Refer Prod Drawing no				REV NO			
						#IXEI .			Dime	nsional								
QP			#REF!		Rev. No.	#REF!		40-DF-Q			Refer Ligh Drawing no	t Cut D.	REV N		REV NO			
FINISH MACHI		APPLICABLE / NOT APPLICABLE																
OK Qty Sent	OK Qty R	Received Qty Rejected					achining a					PPC						
Cust.MC Drg.No.			#REF!		REV NO.	*	below will be done at plaincluding those which a other vendor.											
SURFACE NDE BY WET FLOUROSCENT MPI APPLICABLE / NOT APPLICABLE											Auth. By	PPC						
				#DEE!	Oty Check	kad:-							Pai ·	Auth By I	MQC	NDE Inspector		
-												NDE IN	spector					
QP: – #	REF!				Rev No	.:-	#REF!		WIF	or Magne	tic Particle	Inspection	on. 30-W	/I-MPI-01				
SURFACE NDE								AF		LE / NOT A	APPLICAB			Auth. Bv	мос			
_	#REF!		Rev:-	#REF!	Qty. Check		Qty. OK: Qty. Rej. WI For Liquid penetrant examination 30-WI-LP-01									NDE In	spector	
QP : -	#REF!				REV NO :	#REF!	DECTION & V				rant exami	nation 30	-WI-LP-)1				
FINAL DIMENSIONAL INSPECTION & VISUAL INSPECTION Reference- 30-WI-QA-03 WI for Visual & final Inspection latest Revision For Dimensions refer Pre Dispatch Inspection report (40-DF-QA-15)																		
	REF!	i ioi visuai		#REF!	NO -				REV NO	REV DT			QA					
Qty Checked:	-		Rev:-									Dienatch In		report for I	Dotaile			
<u> </u>				Q11 OK	PM	I TEST/Sr	ark &Spectra				itoloi pie i	oloputoli ili	ороссіон	торол тог .				
			R	eference -4					cation la	test Revisi	ion							
Reference -40-DF-MQC-10 WI for Positive Material Indentification latest Revision Procedure: Procedure:													MQC					
Qty Checked: -				- 	:					Qty Rej								
					SrNo :													
Qty. OK: SrNo: PUNCHING (Refer Punching slip) 40-DF-MQC-07																		
Punch: - as p	er Punching	Slip.:-																
																FINAL INS	SPECTION	
Actual Punching Verification as per Punching Slip: -																		
PAC	CKING DETA	ILS Refere	ence 30-W	I-DIS-01 ,3	0-WI-DIS-03,30-	-WI-DIS-05	WI for pack	ing										
Poy Identification Office				Packir	ng Box Size				_	tol 05: 21 -	10, 0, -					DECT:		
Box Identification Slip		lip	Spe	Actual		"	Qty / Box			tal Qty Of B	al Qty Of Box		Total Qty Packed			SPECTION PATCH		
REMARKS						QUA	LITY AUDIT											
=	N-	Quality Do	cument Ver	rification C No.	_			e for Dispa	tch		OF NO		PATCH DETAILS			MQC		
		Date	ıc	Date					INVOI	JE NU	DA	TE Shipping Mode		mac.				