

# SETUP APPROVAL

Doc.Ref:  
Page : 1 of 2

Date and Shift	8/2/2023 'A'		Supplier Name	C axon mobil	
Item Description	B 20 'R' cover (D-04)		Operator Name	vinay	
Part Number	128-501-00094		Inspector Name	Giri. D	
Material + Colour	ppcp + Black		Bush Batch No. +ve	3/2/c 9255	
Material Batch No.	p10790A		Bush Batch No. -ve	3.1/1A 9113	

  

S.No.	Checking Parameter	Specification	Tol.	Observation	Remarks
1.	Machine	450 K		450 K	OK
2.	Clamp tonnage	250 Ton	ref	450 Ton	OK
3.	Mold die-height	-		464.57	OK
4.	Mold as per Matrix	yes		yes	OK
5.	Shot size	170	3	170	OK
6.	Suck Back	6.0	ref	60	OK
7.	Inj. Velocity	25/22/20	3	25/22/20	OK
8.	Inj. Pressures	60/55/50	5	65/60/55	OK
9.	Inj. Position	100/60	ref	50/30	OK
10.	Inj. SW Mode	By pos	-	Ry pos	OK
11.	SW to Hold Position	20.0	3	23	OK
12.	Holding Velocity	30.	3	30	OK
13.	Holding Pressures	40/40	5	40/40	OK
14.	Holding Times	5.0/5.0	+0	5.0/5.0	OK
15.	Re-filling speed	60	10	60	OK
16.	Re-filling pressure	-	-	-	OK
17.	Back pressure	4.0	+0	4.0	OK
18.	Cooling time - Tower	45	Min	-	OK
19.	Cooling time - Chiller	40	Min	40	OK
20.	Barrel temp - Set	215, 215, 210, 205, 200	10°C	220, 215, 210, 205, 200	OK
21.	Hot runner temp - Set	-	-	-	OK
22.	Hot runner temp - Actual	-	-	-	OK
23.	Hot Air dryer temp - Set	-	-	-	OK
24.	Chiller temp - Set & Actual	19°C	+5/-2	21°C	OK
25.	SCR.Min/Cushion - Act	9.5	ref	9.8	OK
26.	Injection time/Fill time	5.6	"	5.13	OK
27.	Re-filling time	21.66	"	20.6	OK
28.	Cycle time - Avg	85	"	85	OK
29.	Injection pressure - Act	154.6	"	56.0	OK
30.	Semi auto / Fully auto	semi auto	-	Semi auto	OK
31.	Dozer RPM	32.0	ref	32.0	OK
32.	Dozer time	28.0		28.0	OK
33.	Length	192.2 to 5	h1	192-20/24	OK
34.	Width	105.0 to 5	h1	192-22/16	OK





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Doc.Ref:  
Page : 2 of 2

S.No.	Checking Parameter	Specification	Observation								Remarks
35.	Polarity check	As per drawing									
36.	Handle lock	No damage/no deformation									
37.	Lock pin dimension	Lock pin dia 8.13-8.23mm Lock dia 8.64 - 8.74mm	C	+ve		Opp. +ve		-ve		Opp. -ve	
			a	Lock pin dia	Lock dia	Lock pin dia	Lock dia	Lock pin dia	Lock dia	Lock pin dia	
			v								
			1	815	867	816	867	817	867	816	
			2	816	866	817	867	815	866	816	
			3	817	865	815	866	816	867	817	
			4	815	866	816	865	817	866	816	
38.	Vent locking position	As per drawing									
39.	Blow holes in heat seal area	No blow holes heat seal area									
40.	Half shots & dent marks	No half shots & no dent marks									
41.	Half shot in both side of vent area & flashes	No half shot in both side of vent area & flashes									
42.	Vent hole damages	No vent hole damages									
43.	Same post	No same post									
44.	Same post-Jig & vent hole jig	Used/Not used									
45.	White patches	As per approved sample									
46.	Bush damage/step in inner dia/bush height/flow marks	No bush damage/No step in inner dia/bush height/flow marks									
47.	Flashes, burn marks/STEM inner	No flashes, no burn marks/No scratch and damage									
48.	Post jig checking	Entered freely									
49.	Color difference	As per approved sample									
50.	Flow marks	As per approved sample									
51.	Waviness	As per approved sample									
52.	Black marks	No black marks									
53.	Water & Stress marks	No water marks, no stress marks									
54.	Ejection pin up & down	No ejection pin up & down									
55.	Runner point hole	No Runner point hole									
56.	Brand insert position	As per approved sample									
57.	Month & Year insert	Current Month & Year									
58.	Pin damage/deformation	No pin damage/No deformation									
59.	Silver streaks	As per approved sample									
60.	Handle fitment check	Visual check									

Material pre heating Temp:

Pre heating time:

Spec: \_\_\_\_\_ Obser: \_\_\_\_\_

Spec: \_\_\_\_\_ Obser: \_\_\_\_\_

QA Inspector-Sign: \_\_\_\_\_

PRD Supervisor-Sign: \_\_\_\_\_

Setup approval status: ☒ OK ☐ Not Ok

Operator-Sign: \_\_\_\_\_

BC(PTM)-QAD-SFR-108

+ Start of work - 10  
x pins real parts