













Pre-Dispatch Inspection (PDI) Summary Report

Part Name:RING - BRG ADJ. FIN.		Part No:2214G1125 - K / 02.01.2019		Customer Name:Meritor		Shift: I / II / III / G			Date:		
S.No	Product characteristics	Spl. Char.	Specification	Gauge Type	Freq.	Gauge ID	Calib. Status	No of Qty			Remarks
								U/S	O/S	Not Ok	
PROCESS DEFECTS:											
1	Thread		M154.6 x 2 - 7g6g (Go)	Parts should pass in Auto Thread Ring Go Gauge	100%						
2	Thread		M154.6 x 2 - 7g6g (NoGo)	Should Not Pass One Thread	100%						
3	Thread - Pitch Diameter		Ø 153.052 / 153.240	Lever type auto thread ring gauge	5 / Every Hour						Check & Update PDI Check Sheet
4	Thread - Major Diameter		Ø 154.311 / 154.535	Special Gauge + Dial (Min / Max)	100%						
5	Thread true Position wrt XY		1.80 Max	Vernier	2 No's / Per Skid						Check & Update PDI Check Sheet
6	Runout wrt A		0.16 Max	Special Gauge + Dial	2 No's / Per Skid						Check & Update PDI Check Sheet
7	Flatness		0.10 Max	Special Gauge + Dial	2 No's / Per Skid						Check & Update PDI Check Sheet
8	Thickness	-	25.60 / 26.40	Snap Gauge	100%						
9	Presence of Induction Hardening		Brownish Color on machined face, No hardening allowed beyond first thread	Visual	100%						
10	Part oiling & drying	-	Oil Should be apply and dried before packing	Visual	100%						
11	Chamfer Over Size & Chamfer Offset	-	Not Allowed	Visual	100%						




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								U/S	O/S	Not Ok	
12	Burr & Tool Mark	-	Not Allowed	Visual	100%						
13	Step Mark & Chattering Mark	-	Not Allowed	Visual	100%						
14	Machining Damage, Machining Rust & Entry Chamfer	-	Not Allowed	Visual	100%						
15	Fettling Damage & Extra Material	-	Not Allowed	Visual	100%						
16	Unwash & Casting Damage	-	Not Allowed	Visual	100%						
17	Casting Rust and Porosity	-	Not Allowed	Visual	100%						
18	Blow Holes & Sandrop	-	Not Allowed	Visual	100%						
19	Meritor logo	-	Should Presence	Visual	100%						
20	MEI ID	-	Should Presence	Visual	100%						
21	Date Code	-	Should Presence	Visual	100%						
Auto Thread Ring Gauge Counter Qty. :_____ Nos. (Only Adjuster Ring)				 QCC - Quality Control Characteristics				 SRC - Safety Related Characteristic			



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								 U/S	O/S	Not Ok	
Thread Go Gauge Should be clean Every shift start (Where ever Applicable)				Name Of PDI Inspector:		Inspected Qty	Accepted Qty	Defect Qty	Process Defect Qty	Supplier Defect Qty	
Remarks:				Sign Of PDI Inspectors:							
				Verified By : (PDI Supervisor)			Reviewed By : (PDI Incharge)				
F/Q/013 - Rev:00									ADR 008 / 50/PDS - Rev No:0		