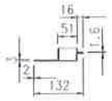
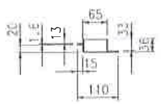
SANDHAR mag	Fixture Verification check sheet		Mag/FVCS/01 REV 00
Sl No.	Process Name	Standard parameters	Date : 22/05/2023 Fixture No: MAG/EX200/DR/03 Fixture Description: DOOR Settings Customer : M/s JHCM Part Name : EX200 Cabin Location: JHCM fabrication
1	Condition of Clamps	Should firmly hold the workpiece,Should not create marks on the surface	Checked and found ok
2	Condition of Locating Blocks	Should be free from wear out,Check the flatness using steel rule	checked and found ok
3	Condition of Locating Pins or Hole dia	Check dia and record,Clearance between Hole dia and pin dia should not be more than 0.5mm	Checked & measured upto 0.31mm
4	Locating positions	Should be as per drawing	As per part Inspection Report
5	Part resting surface	Should be free from uneven surface,High points(Projections),sticking of foreign particles.	checked and found ok
6	Bolt and screw Tightness	Free from loose fitment	checked and found ok
7	Child part resting blocks	Height should be uniform,the differnace between block should not exceed 0.2mm,Proper resting of child parts without taper.	checked and found ok
8	Surface levelling	Fixture to be levelled,check using sprit level /Tube and Grouting/Levelling of fixture in its location.	checked by Steel Rule & filler Gacer measured upto 0.13mm found ok
9	Operator Conveneint	Ergomics,Easyness for part fitment,removal,rotation etc.	Checked and found ok
10	Fixture Identification	Fixture should have No,Description and added in the Fixture list	fixture identified & Added in the fixture master list
11	Part Inspection report	Part made out of the Fixture to be checked and report to be attached	part checked & Report Attached
	Fixture Status /Remarks	OK/Contionally accepted /Rejected	OK
Checked By			Date: 22/05/2023
Verified By			Date: 25/05/2023

TB20597

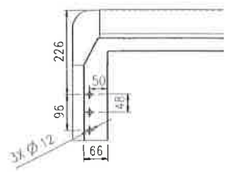
DO NOT SCALE: IF IN DOUBT, ASK

Date	Mod. No	Zone	Modification	Drn	Chd
28.09.18	02		DRG. INTRODUCED, ECN NO 5200-1284	ADITYA	ASIF



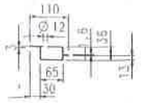


SECTION: H

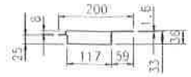


SECTION: D

SECTION: L

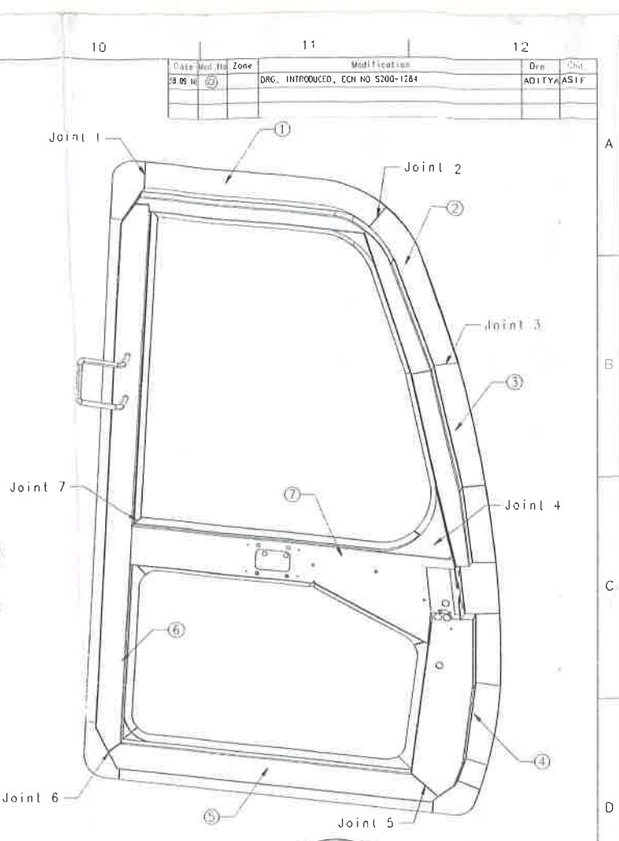


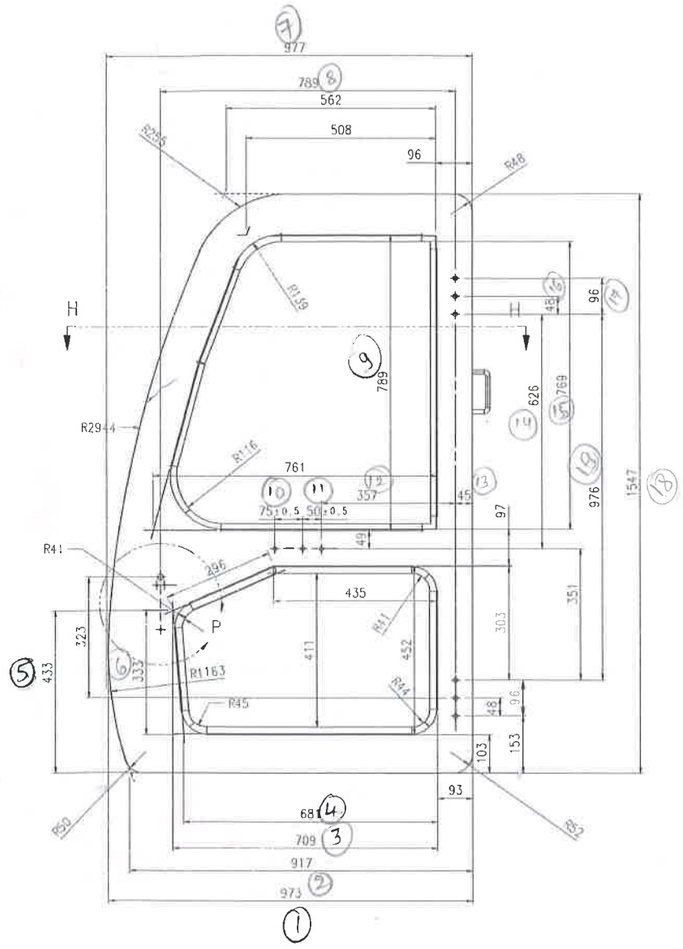
SECTION: B

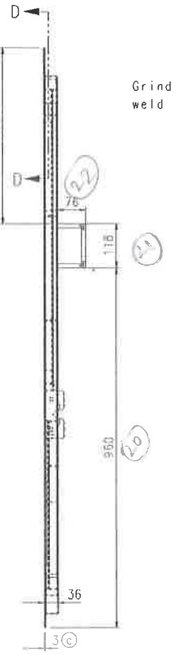


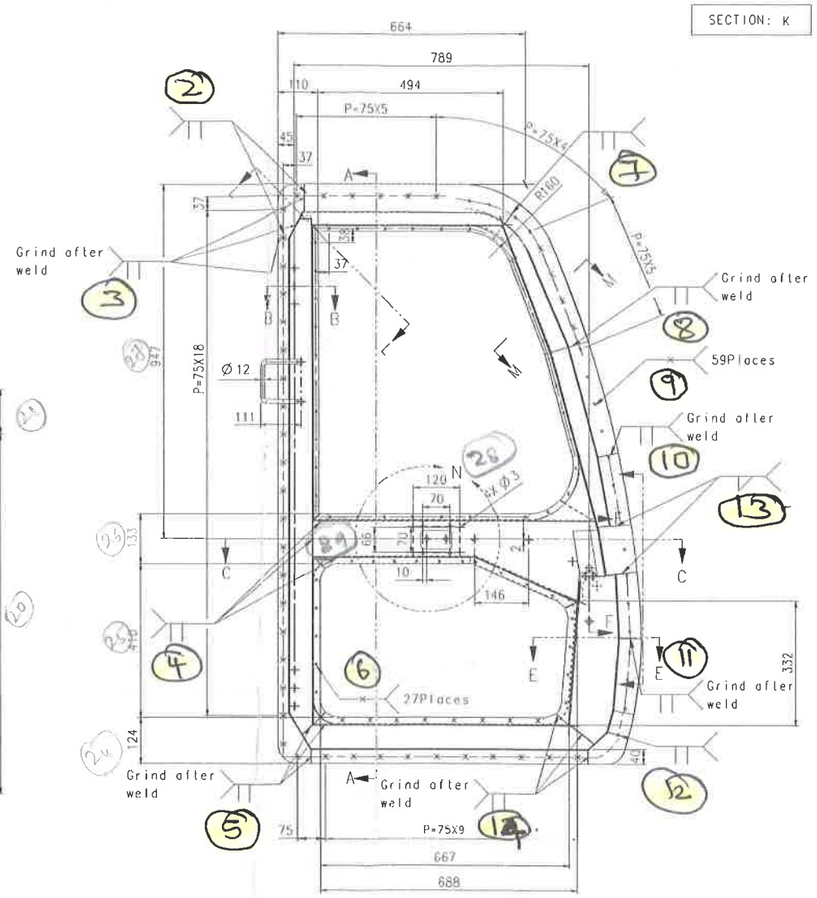
SECTION: E

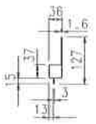
SECTION: K

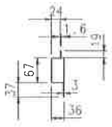




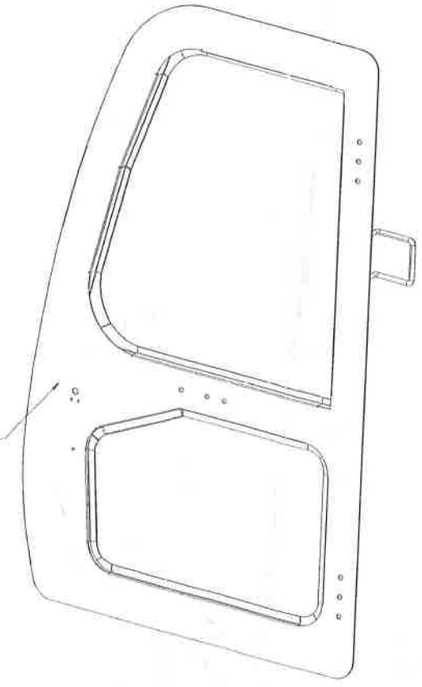






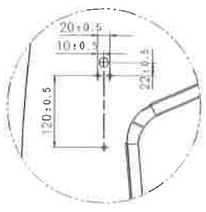


SECTION: A

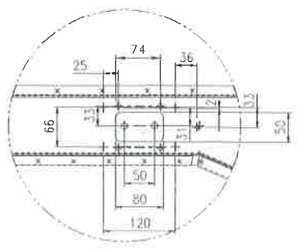


Size:1.6 X 973 X 1547 (1)
Material:CR2;IS:513

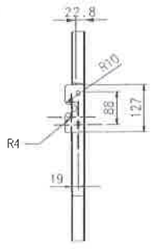
Note:
1) P-'xx' X 'x' indicates pitch length & no of spot.



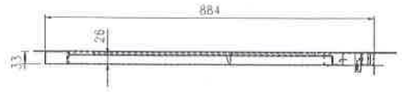
DETAIL P
SCALE 1:5



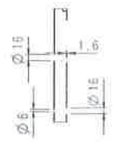
DETAIL N
SCALE 1:5



SECTION: I



SECTION: C



SECTION: F

CON. TOL. FOR MACHINING		GEN. TOLERANCE FOR WELDING	
LENGTH	DEVIATION	LENGTH	DEVIATION
0 < L ≤ 6	± 0.1	0 < L ≤ 63	± 1.6
6 < L ≤ 10	± 0.2	63 < L ≤ 125	± 2.0
10 < L ≤ 63	± 0.3	125 < L ≤ 250	± 2.5
63 < L ≤ 250	± 0.5	250 < L ≤ 500	± 3.15
250 < L ≤ 1000	± 0.8	500 < L ≤ 1000	± 4.0
1000 < L ≤ 2000	± 1.25	1000 < L ≤ 2000	± 5.0
COMPLY WITH STD. IES 606-225		2000 < L ≤ 4000	± 6.3
DON'T USE PROHIBITED CHEMICAL		4000 < L ≤ 8000	± 8.0
REF. SSG.NO.99696331 IN SUPPLIES		8000 < L ≤ 16000	± 10.0

Tata Hitachi Construction Machinery Co. Pvt. Ltd. Jamshedpur

2018	Sign	Date	Weld Quality	Gen.Roughness	Material Description, Size, Spec., Std., No.
Drn.	ADITYA	28.09			ASSEMBLY
Chd.	ASIF	28.09	Project Name		Fin. Mass (kg) 27.00
Appd.	ARUN	28.09	EX200Super-5		Replaces Drg.:
Scale:- 1:10(1:7)			Projection	UNLESS ARE IN mm TOL AS PER STD ISO 286-2	Ref. Drg. No.:
Drg. / Part Designation			Door Weldment		Drg. / Part No. TB20597
					Sheet No. 1 of 1 Sheets

F/QA/03

MAG ENGINEERING
QUALITY ASSURANCE DEPARTMENT

SANDHAR

INSPECTION REPORT

Part No: TB20597	Customer Name: M/s JHCM	Sample Qty: 01
Part Name: DOOR Widowmount	Engg change level: 01 / 28.09.18	Date: 22/05/2023

Reason for submission: PILOT ☐ PROTO ☐ PROD ☑ OTHERS ☐

☑ Dimensional ☐ Material ☐ Appearance ☐ Engg Spec Test ☐ Others

SL. No.	Characteristics	Specification	Instrument used	Observation					Conformanace		Remarks
				1	2	3	4	5	OK	Not ok	
1	Dim	973±4	MT	974					✓		
2	Dim	917 ± 4	MT	919					✓		
3	Dim	709 ± 4	MT	707					✓		
4	Dim	681 ± 4	MT	683					✓		
5	Dim	433 ± 3.15	MT	435					✓		
6	Dim	333 ± 3.15	MT	332					✓		
7	Dim	977 ± 4	MT	975					✓		
8	Dim	789 ± 4	MT	788					✓		
9	Dim	789 ± 4	MT	786					✓		
10	Dim	35 ± 0.5	DVC	34.92					✓		
11	Dim	50 ± 0.5	DVC	50.02					✓		
12	Dim	357 ± 3.15	MT	357					✓		
13	Dim	45 ± 1.6	DVC	45.03					✓		
14	Dim	626 ± 4	MT	628					✓		
15	Dim	769 ± 4	MT	768					✓		
16	Dim	48 ± 1.6	DVC	48.05					✓		
17	Dim	96 ± 2.0	DVC	95.84					✓		
18	Dim	1547 ± 50	MT	1546					✓		
19	Dim	976 ± 4	MT	974					✓		
20	Dim	960 ± 4	MT	961					✓		
21	Dim	118 ± 2	DVC	117.78					✓		
22	Dim	76 ± 2	DVC	77.27					✓		
23	Dim	469 ± 3.15	MT	469					✓		
24	Dim	124 ± 2	DVC	123.93					✓		
25	Dim	410 ± 3.15	MT	408					✓		
26	Dim	133 ± 2.5	DVC	135.17					✓		
27	Dim	947 ± 4.0	MT	948					✓		
28	Dim	120 ± 2.0	DVC	120.02					✓		
29	Dim	66 ± 2.0	DVC	66.02					✓		

Inspected By: [signature]

Approved By: [signature]