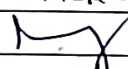


Sl No.	Process Name	Standard parameters	Date: 24/03/2023
			Fixture No: MAG/EX200/LH-01
			Fixture Description: LH panel Sealsheet welding
			Customer: on/s1 THCM
			Part Name: EX200 Cabin
			Location: THCM Fabrication
1	Condition of Clamps	Should firmly hold the workpiece, Should not create marks on the surface	Two clamps not 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 and found ok
4	Locating positions	Should be as per drawing	As per Part Inspection Report, checked and found ok
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 difference 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 spirit level and grouting of fixture in its location.	checked by Steel Rule & Filler Gauge 0.19 mm ok
9	Operator Convenience	Ergonomics, Easiness for part fitment, removal, rotation etc.	Verified and found ok
10	Fixture Identification	Fixture should have No, Description and added in the Fixture list	Fixture identified with asset number & description & added in the list. Verified and found ok
11	Part Inspection report	Part made out of the Fixture to be checked and report to be attached	parts checked & report attached.
	Fixture Status /Remarks	OK/Conditionally accepted /Rejected	See the Remarks.
Checked By Mukesh			Date: 24/03/2023
Verified By 			Date: 27-03-23.

* Remarks

- 1) Tube front clamp not ok.
- 2) Top Moving Reel clamp observed play 0.66 mm in the clamp & 1.33 mm in the part.
- 3) Tube Gap observed Bottom side 6.08 mm Gap
- 4) Centre pillar Bottom side Gap observed 9.10 mm

F/QA/03

Mag Engineering QUALITY ASSURANCE DEPARTMENT

mag
SANDHAR

INSPECTION REPORT

Part Number : TA 01852

Customer Name: m/s THCM

Sample Qty: 10

Part Name: LH Panel
EX 200 Super 4

Engg. Change Level: J/16.05.2022

Date: 24/03/2023

Reason for Submission

PILOT

PROD.

PROTO

OTHERS



Dimensional



Material



Appearance

Engineering
Specification
Testing

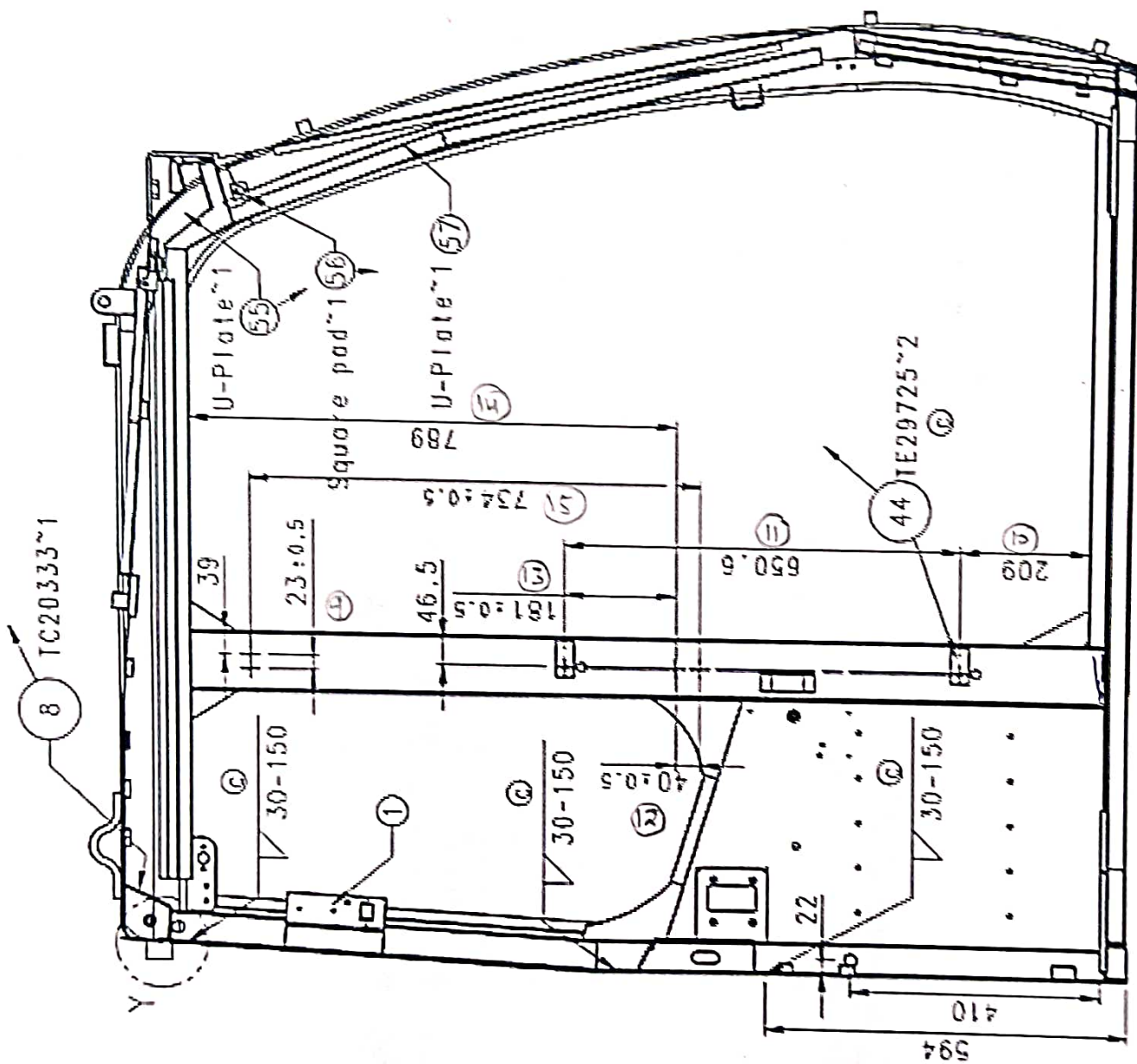
Others

Sl. No.	Characteristic	Specification	Instrument Used	Observation					Conformance		Remarks
				1	2	3	4	5	OK	Not OK	
1	Dimension	1647.9 ± 5.0	MT	1648					✓		
2	Dimension	1574 ± 5.0	MT	1575					✓		
3	Dimension	627 ± 4.0	MT	628					✓		
4	Dimension	754 ± 4.0	MT	754					✓		
5	Dimension	775 ± 4.0	MT	775					✓		
6	Dimension	1072 ± 0.5	MT	1072					✓		
7	Dimension	1509 ± 5.0	MT	1510					✓		
8	Dimension	997 ± 4.0	MT	998					✓		
9	Dimension	23 ± 0.5	DVC	22.97					✓		
10	Dimension	209 ± 2.5	DVC	189.85						✓	
11	Dimension	650.6 ± 4.0	MT	650					✓		
12	Dimension	40 ± 0.5	DVC	40.50					✓		
13	Dimension	181 ± 0.5	MT	155						✓	
14	Dimension	789 ± 4.0	MT	786							
15	Dimension	734 ± 0.5	MT	727						✓	
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Inspected By :

Mukesh

Approved By :



SECTION: S

