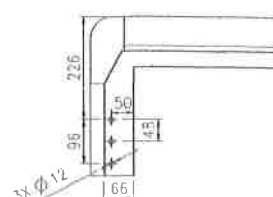
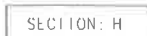


SANDHAR <sup>mag</sup>		Fixture Verification check sheet		Mag/FVCS/01 REV 00
Sl No.	Process Name	Standard parameters	Date : 26/04/2023 Fixture No: 0004151200/DR/D1 Fixture Description: Door Sub Assembly Customer : M/S THCM Part Name : EX200 Cabin Location: THCM Fabrication	
1	Condition of Clamps	Should 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	Two locating blocks Not 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 not ok	
4	Locating positions	Should be as per drawing	As per past 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 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 / Tube and Grouting / Levelling of fixture in its location.	checked by steel rule & Filler Gauge measured upto 0.18 mm found ok	
9	Operator Convenience	Ergonomics, Easiness for part fitment, removal, rotation etc.	lock mounting supporting plate & Bush not having locating pins	
10	Fixture Identification	Fixture should have No, Description and added in the Fixture list	Fixture Identification done & added in the master list	
11	Part Inspection report	Part made out of the Fixture to be checked and report to be attached	part checked and Report attached.	
	Fixture Status / Remarks	OK/Conditionally accepted / Rejected	See the Remarks	
Checked By Mulesh			Date :	
Verified By			Date :	

Remarks :

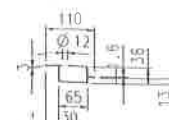
- Two locating blocks not ok. clearance between part and block measured upto 3.73 (center block) & 2.87 mm measured (top side block) respectively.
- Condition of locating pins for hinge mounting plate hole, clearance measured 1.5 mm.
  - Supporting plate hole & locating pins clearance measured upto 2.2 mm.
  - Supporting plate with M10 nut measured clearance upto 1.7 mm.
- lock mounting supporting plate & Bush not having locating pins, manually doing adjustment.



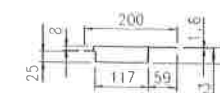
SECTION: D



SECTION: L



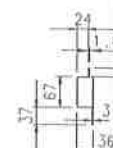
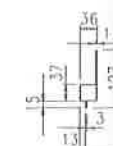
SECTION: A



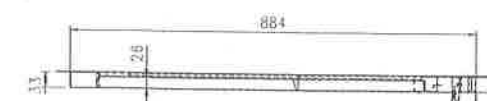
SECTION: E



SECTION: K



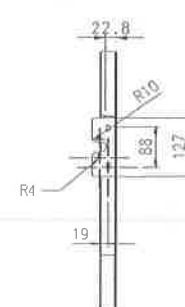
SECTION: A



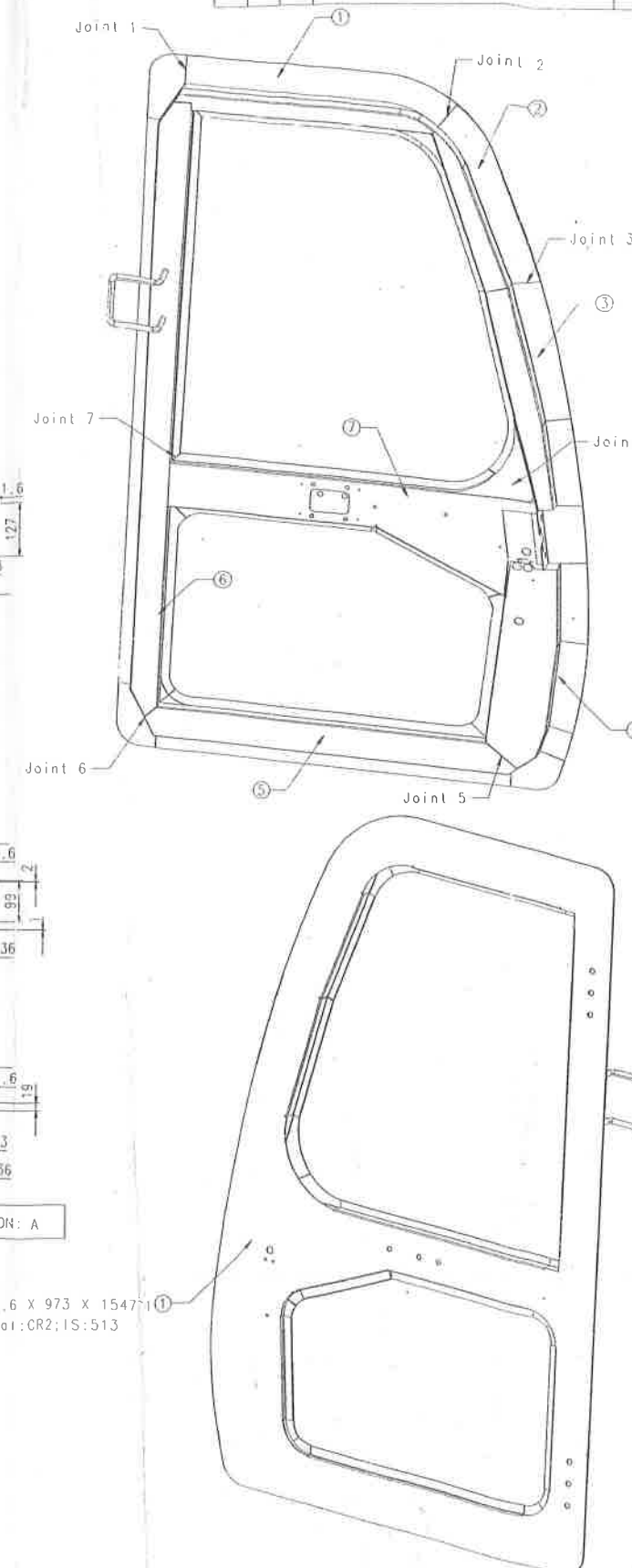
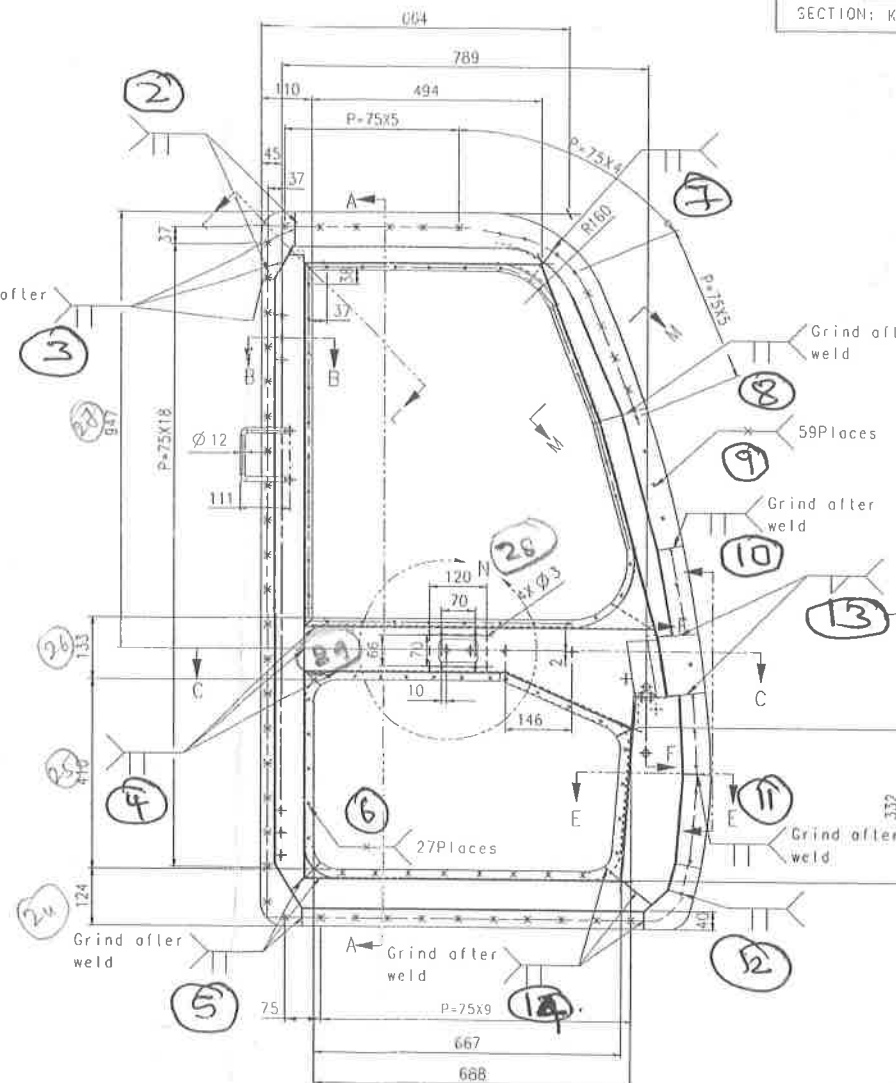
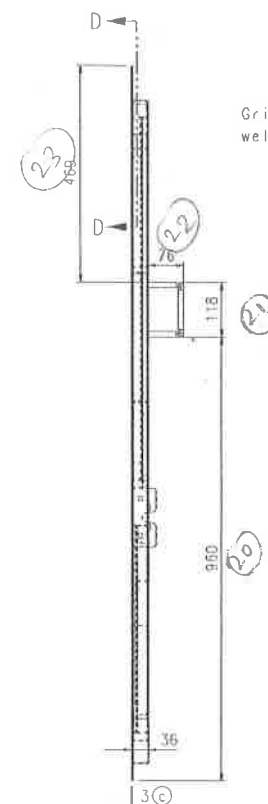
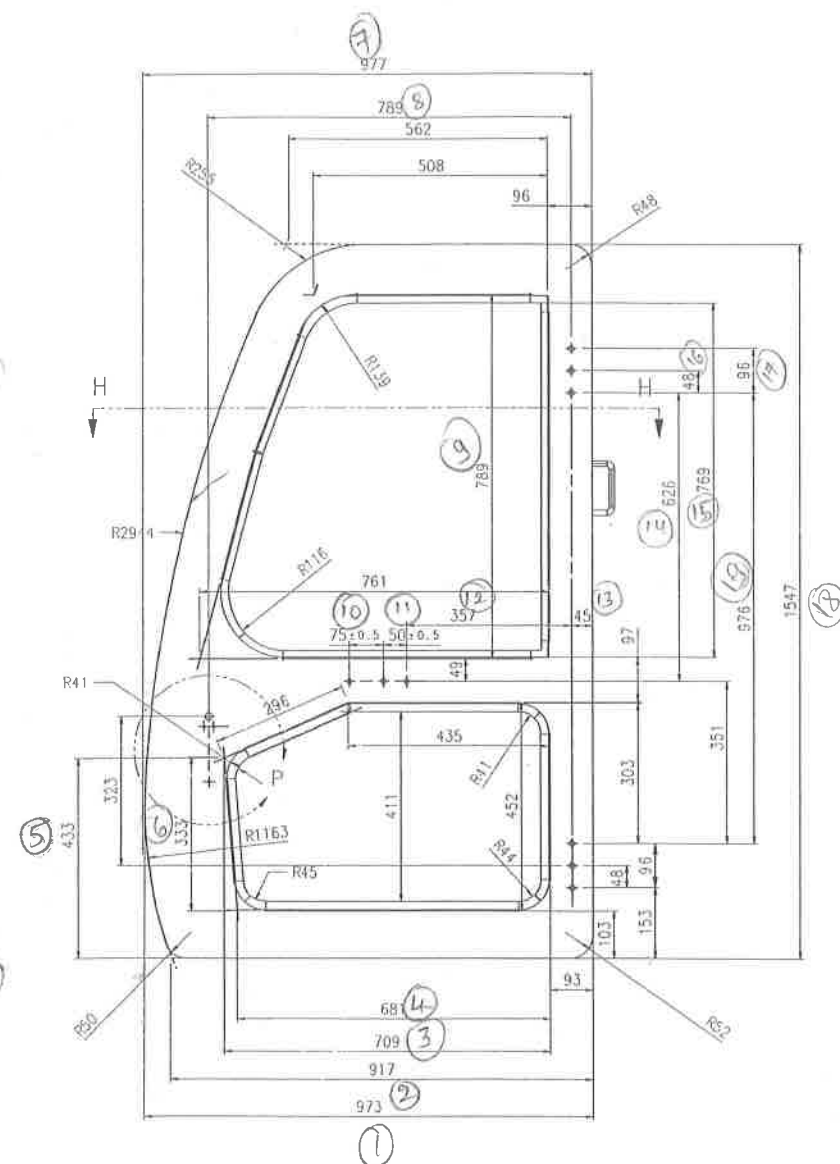
SECTION: C



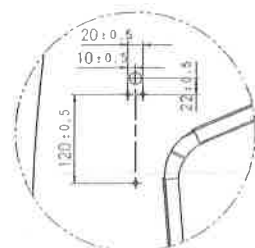
SECTION - F



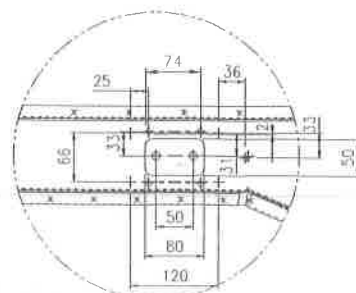
SECTION: I



Note:  
1)  $P_{xx}$  'x' indicates pitch length & no of spol.



DETAIL P  
SCALE 1:5



DETAIL N  
SCALE 1:5

DIM. TOL. FOR MACHINING			DIM. TOLERANCE FOR WELDING		
LENGTH	DEV. (VAR.)		LENGTH	DEV. (VAR.)	
1" x .1	± 0.1		1" x .1	± .1	
4" x .16	± 0.2		4" x .16	± .2	
16" x .3	± 0.3		16" x .3	± .3	
8" x .250	± 0.4		8" x .250	± .4	
250" x .1000	± 0.5		250" x .1000	± .5	
1000" x .4000	± .25		1000" x .4000	± .25	
COMPLY WITH ISO 343 500-025			2500" x .4000	± .5	
DON'T USE PROBABILISTIC CHAINING			4000" x .5000	± .5	
(REF. (DIN. NO. 90453)) IN SUPPLIES			8000" x .18000	± 1.0	

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 83
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F/QA/03

MAG ENGINEERING  
QUALITY ASSURANCE DEPARTMENT

SANDHAR

## INSPECTION REPORT

Part No: T320592	Customer Name: m/s THCM	Sample Qty: 01
Part Name: DDBR Wudamank	Engg change level: 2 a / 28.09.18	Date: 26/04/2023
Reason for submission		
<input type="checkbox"/> PILOT	<input type="checkbox"/> PROTO	<input checked="" type="checkbox"/> PROD
<input type="checkbox"/> OTHERS		

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

SL. No.	Characteristics	Specification	Instrument used	Observation					Conformance		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 ± 3.5	MT	435					✓		
6	Dim	333 ± 3.5	MT	332					✓		
7	Dim	977 ± 4	MT	975					✓		
8	Dim	789 ± 4	MT	788					✓		
9	Dim	789 ± 4	MT	785					✓		
10	Dim	75 ± 0.5	DVC	74.92					✓		
11	Dim	50 ± 0.5	DVC	50.01					✓		
12	Dim	357 ± 3.5	MT	357					✓		
13	Dim	45 ± 1.6	DVC	45.01					✓		
14	Dim	626 ± 4	MT	628					✓		
15	Dim	769 ± 4	MT	768					✓		
16	Dim	48 ± 1.6	DVC	48.06					✓		
17	Dim	96 ± 2.0	DVC	95.86					✓		
18	Dim	1547 ± 5.0	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 ± 3.5	MT	469					✓		
24	Dim	124 ± 2	DVC	123.93					✓		
25	Dim	410 ± 3.5	MT	408					✓		
26	Dim	133 ± 2.5	DVC	135.17					✓		
27	Dim	947 ± 4.0	MT	948					✓		
28	Dim	120 ± 2.0	DVC	120.01					✓		
29	Dim	66 ± 2.0	DVC	66.04					✓		
30											
31											
32											

Inspected By: mukesh

Approved By: 