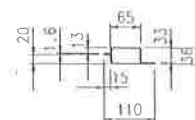
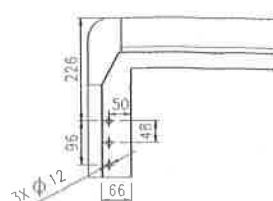


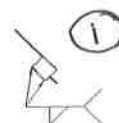
SANDHAR <small>mag</small>		Fixture Verification check sheet		Mag/FVCS/01 REV 00	
SI No.		Process Name		Date: 25/04/2023	
				Fixture No: MAG/EX200/DR102	
				Fixture Description: MMA Door Setting Welding	
				Customer: m/s JHCM	
				Part Name: EX200 Cabin	
				Location: JHCM Fabrication	
1	Condition 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 and measured upto 0.35	
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 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 0.15 mm found ok.	
9	Operator Convenience	Ergonomics, Easy access 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 / Conditionally accepted / Rejected		ok	
Checked By		mukesh		Date: 25/04/2023	
Verified By				Date: 25/04/2023	



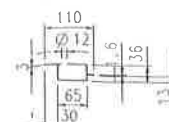
SECTION: H



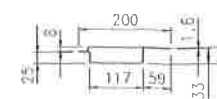
SECTION D



SECTION: L



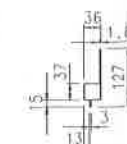
SECTION: B



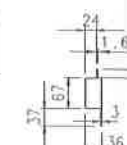
SECTION: E



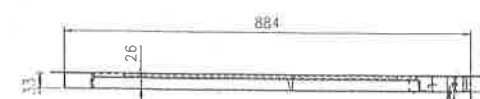
SECTION: K



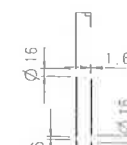
SECTION: A



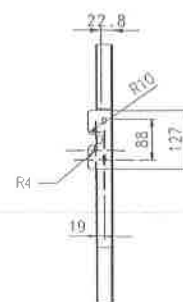
Size: 1.6 X 973 X 15
Material: CR2; IS: 513



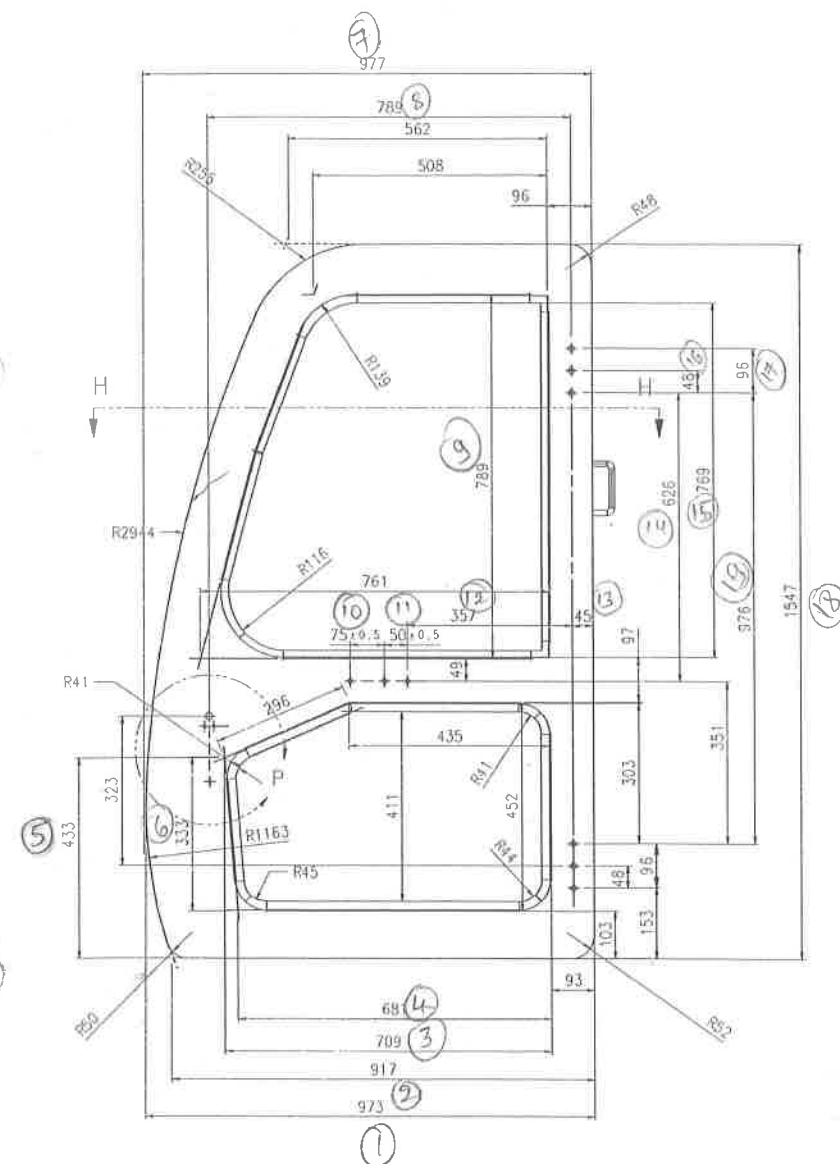
SECTION C



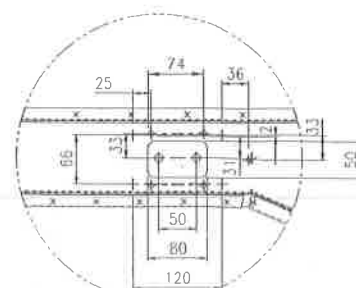
SECTION: F



SECTION: 1



DETAIL P
SCALE 1:5




DETAIL N
SCALE 1:5

GCR FOR TCR MACHINING			GCR TOLERANCE FOR WELD		
LENGTH	DEVIATION	UNIT	LENGTH	DEVIATION	UNIT
1	+ 0.1	mm	83	+ 0.1	mm
4	+ 0.2	mm	175	+ 0.2	mm
15	+ 0.3	mm	250	+ 0.3	mm
63	+ 0.5	mm	500	+ 0.5	mm
250	+ 0.8	mm	1000	+ 0.8	mm
1000	+ 1.25	mm	2500	+ 1.25	mm
2500	+ 1.5	mm	6300	+ 1.5	mm
10000	+ 2	mm	16000	+ 2	mm
25000	+ 2.5	mm	40000	+ 2.5	mm
100000	+ 3	mm	250000	+ 3	mm
250000	+ 3.5	mm	630000	+ 3.5	mm
1000000	+ 4	mm	2500000	+ 4	mm
2500000	+ 4.5	mm	6300000	+ 4.5	mm
10000000	+ 5	mm	25000000	+ 5	mm
25000000	+ 5.5	mm	63000000	+ 5.5	mm
100000000	+ 6	mm	250000000	+ 6	mm
250000000	+ 6.5	mm	630000000	+ 6.5	mm
1000000000	+ 7	mm	2500000000	+ 7	mm
2500000000	+ 7.5	mm	6300000000	+ 7.5	mm
10000000000	+ 8	mm	25000000000	+ 8	mm
25000000000	+ 8.5	mm	63000000000	+ 8.5	mm
100000000000	+ 9	mm	250000000000	+ 9	mm
250000000000	+ 9.5	mm	630000000000	+ 9.5	mm
1000000000000	+ 10	mm	2500000000000	+ 10	mm
2500000000000	+ 10.5	mm	6300000000000	+ 10.5	mm
10000000000000	+ 11	mm	25000000000000	+ 11	mm
25000000000000	+ 11.5	mm	63000000000000	+ 11.5	mm
100000000000000	+ 12	mm	250000000000000	+ 12	mm
250000000000000	+ 12.5	mm	630000000000000	+ 12.5	mm
1000000000000000	+ 13	mm	2500000000000000	+ 13	mm
2500000000000000	+ 13.5	mm	6300000000000000	+ 13.5	mm
10000000000000000	+ 14	mm	25000000000000000	+ 14	mm
25000000000000000	+ 14.5	mm	63000000000000000	+ 14.5	mm
100000000000000000	+ 15	mm	250000000000000000	+ 15	mm
250000000000000000	+ 15.5	mm	630000000000000000	+ 15.5	mm
1000000000000000000	+ 16	mm	2500000000000000000	+ 16	mm
2500000000000000000	+ 16.5	mm	6300000000000000000	+ 16.5	mm
10000000000000000000	+ 17	mm	25000000000000000000	+ 17	mm
25000000000000000000	+ 17.5	mm	63000000000000000000	+ 17.5	mm
100000000000000000000	+ 18	mm	250000000000000000000	+ 18	mm
250000000000000000000	+ 18.5	mm	630000000000000000000	+ 18.5	mm
1000000000000000000000	+ 19	mm	2500000000000000000000	+ 19	mm
2500000000000000000000	+ 19.5	mm	6300000000000000000000	+ 19.5	mm
10000000000000000000000	+ 20	mm	25000000000000000000000	+ 20	mm
25000000000000000000000	+ 20.5	mm	63000000000000000000000	+ 20.5	mm
100000000000000000000000	+ 21	mm	250000000000000000000000	+ 21	mm
250000000000000000000000	+ 21.5	mm	630000000000000000000000	+ 21.5	mm
1000000000000000000000000	+ 22	mm	2500000000000000000000000	+ 22	mm
2500000000000000000000000	+ 22.5	mm	6300000000000000000000000	+ 22.5	mm
10000000000000000000000000	+ 23	mm	25000000000000000000000000	+ 23	mm
25000000000000000000000000	+ 23.5	mm	63000000000000000000000000	+ 23.5	mm
100000000000000000000000000	+ 24	mm	250000000000000000000000000	+ 24	mm
250000000000000000000000000	+ 24.5	mm	630000000000000000000000000	+ 24.5	mm
1000000000000000000000000000	+ 25	mm	2500000000000000000000000000	+ 25	mm
2500000000000000000000000000	+ 25.5	mm	6300000000000000000000000000	+ 25.5	mm
10000000000000000000000000000	+ 26	mm	25000000000000000000000000000	+ 26	mm
25000000000000000000000000000	+ 26.5	mm	63000000000000000000000000000	+ 26.5	mm
100000000000000000000000000000	+ 27	mm	250000000000000000000000000000	+ 27	mm
250000000000000000000000000000	+ 27.5	mm	630000000000000000000000000000	+ 27.5	mm
1000000000000000000000000000000	+ 28	mm	2500000000000000000000000000000	+ 28	mm
2500000000000000000000000000000	+ 28.5	mm	6300000000000000000000000000000	+ 28.5	mm
10000000000000000000000000000000	+ 29	mm	25000000000000000000000000000000	+ 29	mm
25000000000000000000000000000000	+ 29.5	mm	63000000000000000000000000000000	+ 29.5	mm
100000000000000000000000000000000	+ 30	mm	250000000000000000000000000000000	+ 30	mm
250000000000000000000000000000000	+ 30.5	mm	630000000000000000000000000000000	+ 30.5	mm
1000000000000000000000000000000000	+ 31	mm	2500000000000000000000000000000000	+ 31	mm
2500000000000000000000000000000000	+ 31.5	mm	6300000000000000000000000000000000	+ 31.5	mm
10000000000000000000000000000000000	+ 32	mm	25000000000000000000000000000000000	+ 32	mm
25000000000000000000000000000000000	+ 32.5	mm	63000000000000000000000000000000000	+ 32.5	mm
100000000000000000000000000000000000	+ 33	mm	250000000000000000000000000000000000	+ 33	mm
250000000000000000000000000000000000	+ 33.5	mm	630000000000000000000000000000000000	+ 33.5	mm
1000000000000000000000000000000000000	+ 34	mm	2500000000000000000000000000000000000	+ 34	mm
2500000000000000000000000000000000000	+ 34.5	mm	6300000000000000000000000000000000000	+ 34.5	mm
10000000000000000000000000000000000000	+ 35	mm	25000000000000000000000000000000000000	+ 35	mm
25000000000000000000000000000000000000	+ 35.5	mm	63000000000000000000000000000000000000	+ 35.5	mm
100000000000000000000000000000000000000	+ 36	mm	250000000000000000000000000000000000000	+ 36	mm
250000000000000000000000000000000000000	+ 36.5	mm	630000000000000000000000000000000000000	+ 36.5	mm
1000000000000000000000000000000000000000	+ 37	mm	2500000000000000000000000000000000000000	+ 37	mm
2500000000000000000000000000000000000000	+ 37.5	mm	6300000000000000000000000000000000000000	+ 37.5	mm
100	+ 38	mm	25000000000000000000000000000000000000000	+ 38	mm
25000000000000000000000000000000000000000	+ 38.5	mm	63000000000000000000000000000000000000000	+ 38.5	mm
1000	+ 39	mm	2500	+ 39	mm
2500	+ 39.5	mm	6300	+ 39.5	mm
100	+ 40	mm	25000	+ 40	mm
25000	+ 40.5	mm	63000	+ 40.5	mm
1000	+ 41	mm	2500	+ 41	mm
2500	+ 41.5	mm	6300	+ 41.5	mm
100	+ 42	mm	25000	+ 42	mm
25000	+ 42.5	mm	63000	+ 42.5	mm
1000	+ 43	mm	2500	+ 43	mm
2500	+ 43.5	mm	6300	+ 43.5	mm
100	+ 44	mm	25000	+ 44	mm
25000	+ 44.5	mm	63000	+ 44.5	mm
1000	+ 45	mm	2500	+ 45	mm
2500	+ 45.5	mm	6300	+ 45.5	mm
100	+ 46	mm	25000	+ 46	mm
25000	+ 46.5	mm	63000	+ 46.5	mm
1000	+ 47	mm	2500	+ 47	mm
2500	+ 47.5	mm	6300	+ 47.5	mm
100	+ 48	mm	25000	+ 48	mm
25000	+ 48.5	mm	63000	+ 48.5	mm
1000	+ 49	mm	2500	+ 49	mm
2500	+ 49.5	mm	6300	+ 49.5	mm
100	+ 50	mm	25000	+ 50	mm
25000	+ 50.5	mm	63000	+ 50.5	mm
1000	+ 51	mm	2500	+ 51	mm
2500	+ 51.5	mm	6300	+ 51.5	mm
100	+ 52	mm	25000	+ 52	mm
25000	+ 52.5	mm	63000	+ 52.5	mm
1000	+ 53	mm	2500	+ 53	mm
2500	+ 53.5	mm	6300	+ 53.5	mm
100	+ 54	mm	25000	+ 54	mm
25000	+ 54.5	mm	63000	+ 54.5	mm
1000	+ 55	mm	2500	+ 55	mm
2500	+ 55.5	mm	6300	+ 55.5	mm
100	+ 56	mm	25000	+ 56	mm
25000	+ 56.5	mm	63000	+ 56.5	mm
1000	+ 57	mm	25000000000000000000		

This doc. is the sole
 property of Tolo Kilechi.
 It should not be copied or
 communicated to any person
 without the written approval
 of Tolo Kilechi.


Tolo Hitachi Construction
Machinery Co. Pvt. Ltd.
Jamshedpur

2018	Sign	Date	Weld Quality	Gen. Roughness	Material Description, Size, Spec., S.C.
Drn.	ADIFA	26.09			ASSEMBLY
Chd.	ASIF	28.09	Project Name Ex200Super-I		F.n. Mass (kg) 27_00
Appd.	ARUH	28.09	Projection  DIMS. ARE 116 mm TOL. AS PER STD. 192 266-2		Exp. Date Drg.
		1:10 (1:7)			Rev. Drg. No.
					Drg / Part No
					TB20597
					Sheet No. 1 of 1 Sheets

F/QA/03

MAG ENGINEERING
QUALITY ASSURANCE DEPARTMENT

SANDHAR

INSPECTION REPORT

Part No: T320592	Customer Name: m/s T/HCM	Sample Qty: 01
Part Name: DDDR Wheelment	Engg change level: R 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: R