
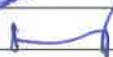
		Fixture Verification check sheet Mag/FVCS/01 REV 00	
Sl No.	Process Name	Standard parameters	Date: 22/04/2023 Fixture No: MAG/THCM/FCMDF-01 Fixture Description: FRONT DIA HO PIPE Customer: THCM Part Name: EX 200 Cabin Location: THCM Fabrication
1	Condition of Clamps	Should firmly hold the workpiece, Should not create marks on the surface	found ok
2	Condition of Locating Blocks	Should be free from wear out, Check the flatness using steel rule	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	found ok
4	Locating positions	Should be as per drawing	
5	Part resting surface	Should be free from uneven surface, High points (Projections), sticking of foreign particles.	found ok
6	Bolt and screw Tightness	Free from loose fitment	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.	verified and found ok
9	Operator Convenience	Ergonomics, Ease for part fitment, removal, rotation etc.	verified and found ok
10	Fixture Identification	Fixture should have No, Description and added in the Fixture list	added in the list and found ok
11	Part Inspection report	Part made out of the Fixture to be checked and report to be attached	part checked and attached
	Fixture Status /Remarks	<input checked="" type="checkbox"/> OK / <input type="checkbox"/> Conditionally accepted / <input type="checkbox"/> Rejected	OK
Checked By: 		Date: 22/04/2023	
Verified By: 		Date: 25/04/2023	

Date	Mod. No	Modification	D.n.	Chd.
15.10.13	01	DRG. INTRODUCED, ECN NO 2001-2349	ARJUN	



1. TO BE PAINTED WITH PRIMER & SURFACER COLOR-ZAXIS GREY
2. PHOSPHATE BEFORE PAINTING

GEN. TOL. RANGE FOR MACHINING	GEN. TOL. RANGE FOR WELDING
LENGTH	LENGTH
DEVIATION	DEVIATION
4 < L ≤ 16	53 < L ≤ 175
16 < L ≤ 63	175 < L ≤ 250
63 < L ≤ 250	250 < L ≤ 500
250 < L ≤ 1000	500 < L ≤ 1000
1000 < L ≤ 4000	1000 < L ≤ 2000
4000 < L ≤ 125	2000 < L ≤ 3000
125 < L ≤ 1000	3000 < L ≤ 4000
1000 < L ≤ 4000	4000 < L ≤ 6300
4000 < L ≤ 16000	6300 < L ≤ 10000

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Tato Hitachi Construction Machinery Company Limited

FRONT TUBE

TD09894

F/QA/03

Mag Engineering QUALITY ASSURANCE DEPARTMENT

SANDHAR

INSPECTION REPORT

Part Number: TD09894

Customer Name: TATA HITACHI

Sample Qty.: 5

Part Name: Front Tube

Engg. Change Level:

Date: 10/04/2023

Reason for Submission

PILOT

PROD.

PROTO

OTHERS

☒ Dimensional☐ Material☐ Appearance☐ Engineering
Specification
Testing☐ Others

Sl. No.	Characteristic	Specification	Instrument Used	Observation					Conformance		Remark
				1	2	3	4	5	OK	Not OK	
1	Dia	12	DVC	12.4	12.5	12.3	12.4	12.5	✓		
2	Dim	50 ± 1.6	MT	48	49	48	48	49	✓		
3	Thick	4 ± 1.6	DVC	3.5	3.6	3.0	3	3.2	✓		
4	Dim	50 ± 1.6	MT	48	49	49	48	49	✓		
5	Dim	817.6 ± 4.0	MT	825	826	825	826	825		✓	
6	RA Dim	20 ± 1.6	DVC	19.5	19.2	18.9	19.0	19.5	✓		
7	LH Dim	20 ± 1.6	DVC	21.00	20.00	20.5	20.8	21	✓		
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Inspected By: Approved By: 