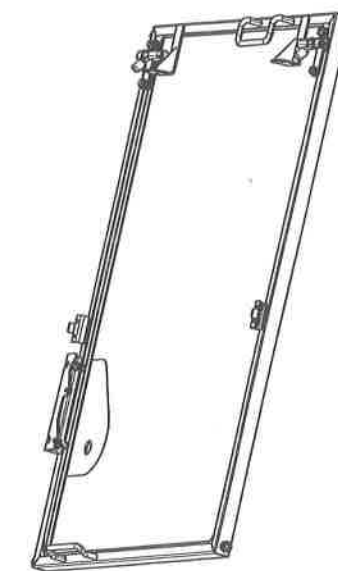
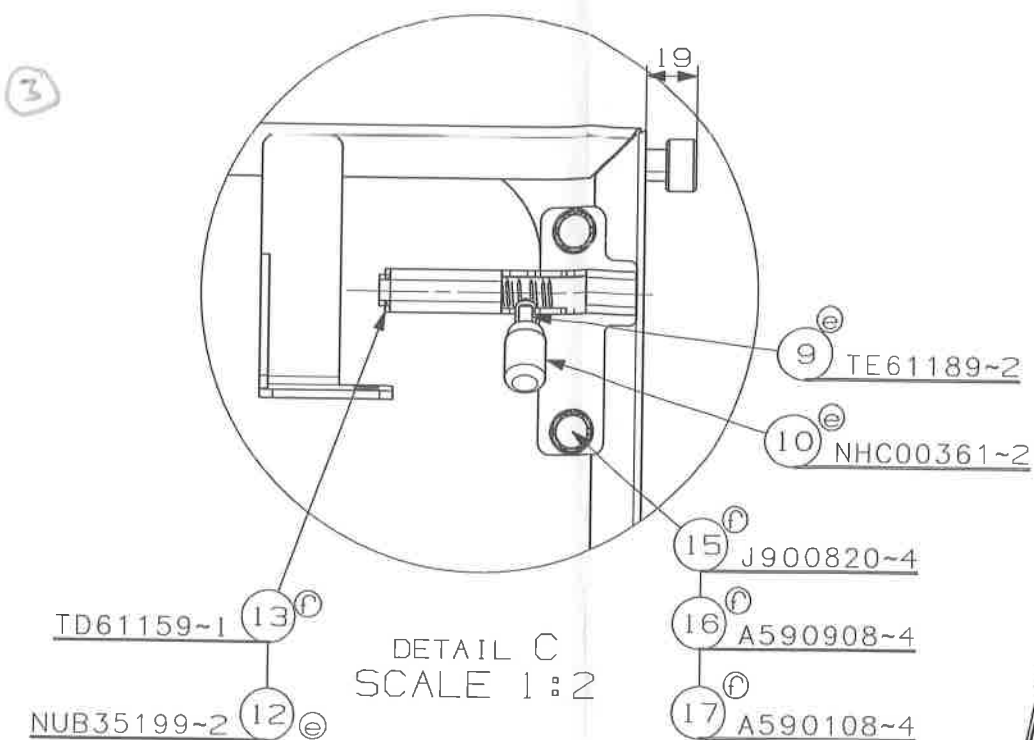
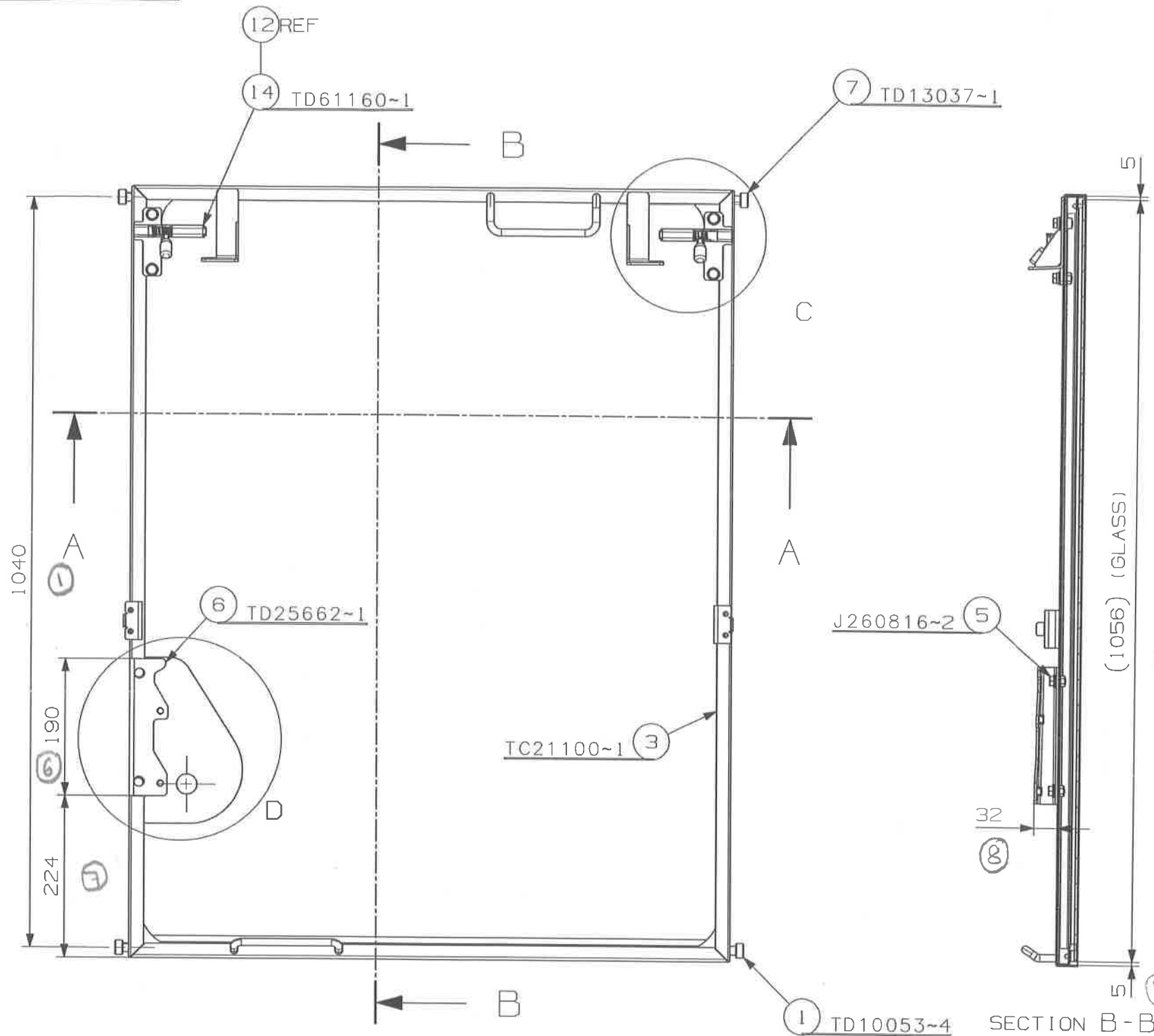
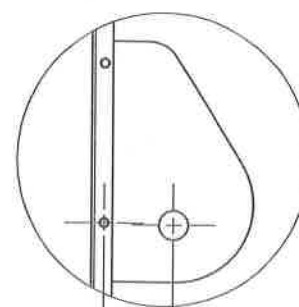
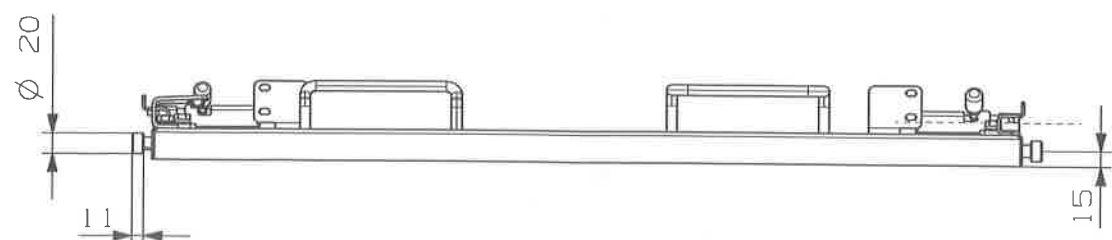
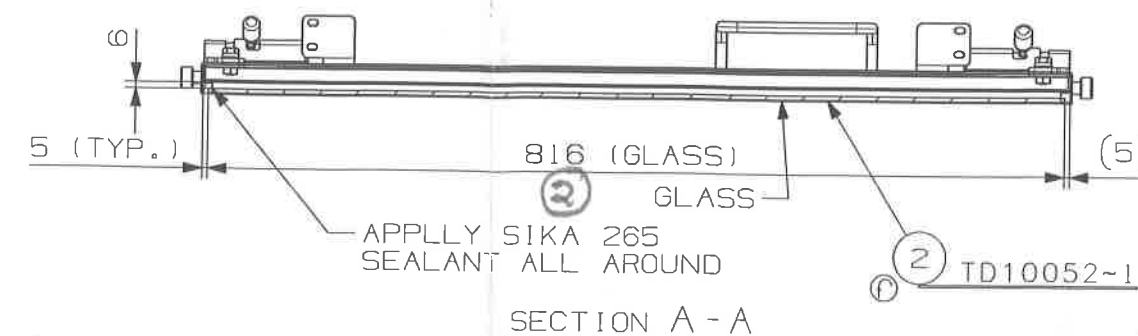
		Fixture Verification check sheet <span style="float: right;">Mag/FVCS/01 REV 00</span>	
Sl No.	Process Name	Standard parameters	Date : 24/04/2023
			Fixture No: MAG/EX200/MF/01
			Fixture Description: moving fixture sections & rollers
			Customer : M/S THEM
			Part Name : EX200 Cabin
			Location: THEM 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 0.32
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 & 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 & spirit level found ok
9	Operator Convenience	Ergonomics, Easiness 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 with agreed numbers Description & added in the master list verified & 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	ok
Checked By: <u>Mulsh</u>			Date: 24/04/2023
Verified By: <u>[Signature]</u>			Date: 25/04/2023

Date	Mod.No	Zone	Modification	Drn.	Chd.
10.10.13	(A)		DRG. INTRODUCED, ECN NO 2001-2349	ARUN	
20.1.14	(B)		ITEM 5&6 ADDED, ECN NO 2001-2441	ARUN	
09.01.16	(C)		DIMS 178 & 145 WAS 198 & 100 RESPECTIVELY. ECN S200-0787	MOHIT	ARUN
21.03.17	(C)	A7	ITEM- 7 INTRODUCED. QTY 2NOS ITEM-1 QTY REVISED TO 2NOS. ECN S200-0822	MOHIT	ARUN
13.01.21	(E)		IT-8(725662) WAS TD10210, IT-8,9,10,11,12 ADDED, ECN S200-1874	SHRUTI	ARUN
30.11.22	(F)		IT-8 & 11 REMOVED, IT-13,14,15,16,17 ADDED, DEATIL D ADDED, ECN NO S200-2101	VIGNESH	SHRUTI



ISOMETRIC VIEW





DETAIL D<sup>Ⓢ</sup>  
SCALE 1:5  
IT-6 IS HIDDEN

GEN. TOL. FOR MACHINING		GEN. TOLERANCE FOR WELDING	
LENGTH	DEVIATION	LENGTH	DEVIATION
$L \leq 4$	$\pm 0.1$	$L < 63$	$\pm 1.6$
$4 < L \leq 16$	$\pm 0.2$	$63 \leq L < 125$	$\pm 2.0$
$16 < L \leq 63$	$\pm 0.3$	$125 \leq L < 250$	$\pm 2.5$
$63 < L \leq 250$	$\pm 0.5$	$250 \leq L < 500$	$\pm 3.15$
$250 < L \leq 1000$	$\pm 0.8$	$500 \leq L < 1000$	$\pm 4.0$
$1000 < L \leq 4000$	$\pm 1.25$	$1000 \leq L < 2000$	$\pm 5.0$
COMPLY WITH STD. TES 900-025		$2000 \leq L < 4000$	$\pm 6.3$
DON'T USE PROHIBITED CHEMICAL		$4000 \leq L < 8000$	$\pm 8.0$
(REF. DRG. NO. 9964633) IN SUPPLIES		$8000 \leq L < 16000$	$\pm 10.0$

This drg. is the sole property of Tata Hitachi. It should not be copied or communicated to any person without the written approval of Tata Hitachi.



Tata Hitachi Construction  
Machinery Company Limited  
Jamshedpur

2013	Sign	Date	Weld Quality	Gen. Roughness	Material Description, Size, Spec., Std. No.
Dwn.	MOHIT	10.10			
Chd.	ARUN	10.10	Project Name <b>EX200SUPER</b>		Fin. Wt. (Kg.): 20.1
Appd.	ARUN	10.10	Projection 	DIMS. ARE IN mm TOL. AS PER STD. ISO 286-2	Replaces Drg.:
Scale:- 1:10					Reference Drg. No.:
Drg./ Part Designation					Drg./ Part No.
FRONT MOVABLE WINDOW ASSLY					TB20416
					Sheet No. 1 of 1 Sheets

**F/QA/03**

**MAG ENGINEERING  
QUALITY ASSURANCE DEPARTMENT**

**SANDHAR** mag

## INSPECTION REPORT

Part No: T820416	Customer Name: m/c JHGM	Sample Qty: 01
Part Name: EX200, 1000mm x 1000mm window	Engg change level: ① / 30.11.22	Date: 24/04/2023
Reason for submission	<input type="checkbox"/> PILOT <input type="checkbox"/> PROTO <input checked="" type="checkbox"/> PRODUCE <input type="checkbox"/> OTHERS	

☒ Dimensional ☐ Material ☐ Appearance ☐ Engg Spec Test ☐ Others[illegible]

Inspected By:

**Approved By:**