



| Sl No.   | Process Name                           | Standard parameters  | Date: 19/05/2023<br>Fixture No: MAG EX200/LH/Template-02<br>Fixture Description: 400mm Block Template<br>Customer: m/s THCM<br>Part Name: EX200 Cabin-LH Side Panel<br>Location: THCM Fabrication |
|--|--|--|---|
| 1  | Condition of Clamps                    | Should firmly hold the workpiece, Should not create marks on the surface   | checked & found ok  |
| 2  | Condition of Locating Blocks           | Should be free from wear out, Check the flatness using steel rule  | checked & 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                                   | — NO —  |
| 4  | Locating positions                     | Should be as per drawing   | — NO —<br>Dim not given in the Drawing  |
| 5  | Part resting surface                   | Should be free from uneven surface, High points (Projections), sticking of foreign particles.                                | checked & found ok  |
| 6  | Bolt and screw Tightness               | Free from loose fitment  | — NO —  |
| 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. | — NO —  |
| 8  | Surface levelling                      | Fixture to be levelled, check using spirit level / Tube and Grouting / Levelling of fixture in its location.                 | checked & measured upto 0.1mm   |
| 9  | Operator Convenience                   | Ergonomics, Easiness for part fitment, removal, rotation etc.  | Difficult for tack welding  |
| 10   | Fixture Identification                 | Fixture should have No, Description and added in the Fixture list  | Template identified & added in the template list  |
| 11   | Part Inspection report                 | Part made out of the Fixture to be checked and report to be attached   | — NO —  |
|  | Fixture Status / Remarks               | OK / Conditionally accepted / Rejected   | Difficult for operator having tack weld. 400mm Block.   |
| Checked By:   |  |  | Date: 19/05/2023  |
| Verified By:  |  |  | Date: 21/05/2023  |