

SANDHAR ^{mag}		Fixture Verification check sheet		Mag/FVCS/01 REV 00
SI No.	Process Name	Standard parameters	Date: 25/03/2023 Fixture No: MAG/EX200/RI1/01 Fixture Description: RI1 panel settings & location 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, Two clamp not ok & not in use	
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	Clearance between Handle mounting Bracket (6.89-5.14) 1.75mm measured (6.89-6.00)=0.89mm measured not ok	
4	Locating positions	Should be as per drawing	As per part Inspection Drawing 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	Handle mounting Bracket locating blocks observed loose	
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 and grouting of fixture in its location.	checked by Steel Ruler & Filler Gauge measured upto 0.20 mm.	
9	Operator Convenience	Ergonomics, Easiness for part fitment, removal, rotation etc.	Verified and found ok	
10	Fixture Identification	Fixture should have No, Description and added in the Fixture list	Fixture identified with Asset number, Description & added in the list verified & found ok	
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 below Remarks	
Checked By Mukesh			Date: 25/03/2023	
Verified By			Date: 29/03/23	

* Remarks

- 1) ~~Two~~ clamp not ok and not using.
- 2) Clearance between Hole dia and pin dia of Handle mounting Bracket is 1.75mm not ok.
- 3) Handle mounting Bracket locating Block observed loose.

F/QA/03

Mag Engineering QUALITY ASSURANCE DEPARTMENT




INSPECTION REPORT

Part Number: TA01852	Customer Name: m/s THCM	Sample Qty: 01
Part Name: RH Panel EX200 Super +	Engg. Change Level: J/16.05.2022	Date: 20/03/2023
Reason for Submission <input type="checkbox"/> PILOT <input type="checkbox"/> PROD. <input type="checkbox"/> PROTO <input type="checkbox"/> OTHERS		

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

Sl. No.	Characteristic	Specification	Instrument Used	Observation					Conformance		Remarks
				1	2	3	4	5	OK	Not OK	
1	Dimension	1139 ± 5.0	MT	1139					✓		
2	Dimension	1214 ± 5.0	MT	1214					✓		
3	Dimension	200 ± 2.5	DVC	200.75					✓		
4	Dimension	304 ± 3.15	DVC	304.12					✓		
5	Dimension	657 ± 4.0	MT	657					✓		
6	Dimension	1022 ± 5.0	MT	1022					✓		
7	Dimension	950 ± 4.0	MT	964						✓	
8	Dimension	12 ± 1.0	DVC	11.91					✓		
9	Dimension	15 ± 1.0	DVC	15.34					✓		
10	Dimension	516 ± 4.0	MT	517					✓		
11	Dimension	171 ± 2.5	DVC	170.84					✓		
12	Dimension	171 ± 2.5	DVC	170.74					✓		
13	Dimension	20 ± 2.5	DVC	19.93					✓		
14	Dimension	40 ± 2.5	DVC	39.99					✓		
15	Dimension	50 ± 1.0	DVC	49.92					✓		
16	Dimension	160 ± 2.5	DVC	164.53						✓	
17	Dimension	225 ± 2.5	DVC	201.14						✓	
18	Dimension	40 ± 1.0	DVC	39.96					✓		
19	Dimension	350 ± 3.15	MT	350					✓		
20	Dimension	512 ± 4.0	MT	511					✓		
21	Dimension	437 ± 3.15	MT	437					✓		
22	Dimension	49 ± 0.5	DVC	50.21					✓		
23	Dimension	6.5 ± 1.0	DVC	6.45					✓		
24	Dimension	122 ± 2.0	DVC	116.70						✓	
25	Dimension	259 ± 3.15	MT	260					✓		
26	Dimension	183 ± 0.5	DVC	182.97					✓		
27	Dimension	64 ± 2.0	DVC	68.3						✓	
28	Dimension	141 ± 0.5	DVC	141.22					✓		
29	Dimension	303 ± 3.15	DVC	303.15					✓		
30	Dimension	10 ± 1.0	DVC	11.03					✓		
31	Dimension	127 ± 2.5	DVC	127.23					✓		
32	Dimension	38 ± 1.0	DVC	38.11					✓		
33	Dimension	279 ± 3.15	MT	279					✓		
34	Dimension	164 ± 2.5	DVC	164.19					✓		
35	Dimension	18 ± 1.0	DVC	13.18						✓	

Inspected By: Mukesh

Approved By: 

F/QA/03

Mag Engineering QUALITY ASSURANCE DEPARTMENT

SANDHAR

INSPECTION REPORT

Part Number: 7AD1852

Customer Name: mlg TNCM

Sample Qty: 01

Part Name: 211 Rev A
EX200 Support

Engg. Change Level: J16-05-2022

Date: 25/03/2023

Reason for Submission

PILOT

PROD.

PROTO

OTHERS

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

Sl. No.	Characteristic	Specification	Instrument Used	Observation					Conformance		Remarks
				1	2	3	4	5	OK	Not OK	
36	4	Dimension	520	520					✓		
37	2	Dimension	22	23					✓		
38	3	Dimension	314	315					✓		
39	4	Dimension	410	410					✓		
40	5	Dimension	φ 20	20.98					✓		
41	6	Dimension	55±0.5	54.98					✓		
42	7	Dimension	49±0.5	50.50						✓	
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Inspected By: Mubesh

Approved By: [Signature]

