

Government of India Society
Ministry of Micro, Small & Medium Enterprises
DIMENSIONAL METROLOGY LABORATORY

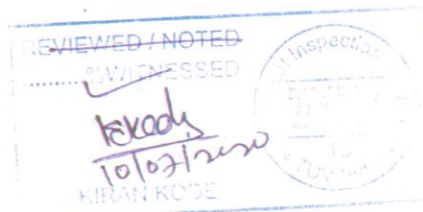
Inspection Report

Work order		18M36074		Date	06-07-2020		Document ID : DML: FF: 02
Report No. :		IR/DML/121/20-21		Drg. No. :	713690A3 PROJECT:UFM -PC		Effective Date: 01/12/2016
				Part Nam	04 FLOW STRAIGHTNER TUBE		Revision Status : 00
Customer :		M/S BARC				Page : 1	
Sr. no.	Specified Dimension						Remark
* 1	78	0/-0.3	78.34	78.47			- Not Acceptable
* 2	140	25.5	140.10				
* 3	5.5	±0.05	5.50	5.50			
* 4	15°	±0.06			Not done		Tolerance should be in deg.
* 5	2.0	Internal	0.60	NOT DONE			
* 6	75.0	±0.15	75.0				
* 7	25.5	±0.1	25.50				
* 8	7x23.0		23.15	7 nos			
* 9	R 0.5		PRESENT				
* 10	30.0	ANGLE	30				Serial No to be as per drawings.
* 11	3.0	+0.02	3.01				
* 12	3.0	+0.02	3.01				
* 13	15.7 (min)		15.7				
* 14	4 (TYP) RIBS		4.15	4.37	4.23		
	WALL Thick	1.25	1.7				

TICK MARKS RELEVANT STATEMENT

Visually check for operation completion as per process sheet, drawing / 3D Model			
Dent Mark	PRESENT <input type="checkbox"/>	NOT PRESENT <input type="checkbox"/>	
Scratch Mark	PRESENT <input type="checkbox"/>	NOT PRESENT <input type="checkbox"/>	
Remarks :- Checked on 2D UMM&M6-6H THREAD NOT DONE		Quantity accepted	
		Qty rework /	
		Quantity rejected	
Inspected By : <i>M. Chh</i>		Approved By :	

Vendor shall obtain clearance of ~~obtained~~ observed dimensions from client.



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Work order No.: 18M36074		Date : 03-06-2020	Document ID : DML: FF: 02
Report No. : IR/DML/120/19-20		Drg. No. : A0	Effective Date: 01/12/2016
Customer : M/s.BARC		Part Name: Sensor housing	Revision Status : 00
		Enclosure	
			Page : 1

Sr. no.	Specified Dimension sample n	1			
1	Ø294 ±0.2	293.95	293.80	293.86	
2	Ø270 -0/+0.081	Ø270.03	Ø272.92		
3	268	268.7	269.94		Not Acceptable
4	295.4 0/-0.1	295.36	295.5		
5	299	299.7			
6	Ø267	266.7	267.30		
7	Ø277.6	335	277.9		
8	Ø294.0	294.03	293.93		
9	Ø271.6	271.78	271.5		
10					
11,12	13	CFR PROVIDED			
14	8XM5 -13 DEEP	8*M5-15 DEEP Provided			It is surface finish needs to check with comparator
	PCD Ø286	286	285.83		
15	4XM5 -13 DEEP	4*M5-15 DEEP Provided			
	PCD Ø286	286			
16	DEEP 13.0	15			
17	25	25.25			
18	30	30.3	30.92		
19	30°	30°40'	31°38'		
20	15°	2 PLACES PROVIDED			
21	18°	16.5°			
22	3 mm	3 mm	TICK MARKS RELEVANT STATEMENT		

Visually check for operation completion as per process sheet, drawing / 3D Model

Dent Mark	PRESENT	<input type="checkbox"/>	NOT PRESENT	<input type="checkbox"/>
Scratch Mark	PRESENT	<input type="checkbox"/>	NOT PRESENT	<input type="checkbox"/>

Remarks :- Checked on 2D UMM

Quantity accept	
Qty rework /	
Quantity reject	

Inspected By : m. ghu

Approved By :

- Vendor shall obtain clearance of observed dimension from client
- * General tolerance shall be mentioned against the dimensions
 - * Over writing needs to be signed by inspector performing the dimensional inspection.

22/7/2020

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Report No. : IR/DML/121/19-20		Drg. No. : A0	Effective Date: 01/12/2016
Customer : M/s.BARC		Part Name: enclosure END PLATE A&B	Revision Status : 00
			Page : 1

Sr. no.	Specified Dimension	ENTRY 7A	EXIT 07 B	
✓ 1	Ø270-0.056/-0.108	270.7	270.55	
✓ 2	Ø261.3 -0/+0.081	262.4	262.46	262.4 262.27 Not Acceptable ?? why 4 dimensions
✓ 3	Ø251.0	251.1	250.82/251	
✓ 4	Ø241.0	240.55	240.5/240.4	241.0
✓ 5	Ø115.1+0.1	115.1	115.21	
✓ 6	27	27	27.16	
✓ 7	21	21.1	20.96/21.2	
✓ 8	16	16.06	15.88	15.96
9	4xM3-4 DEEP	OK not done		Over writing to be signed by person performing dimensional inspection
10	21.5	21.21 not done		
11	30°	OK not done		
12	84	84.31 not done		Needs to check with connector
13	4xM3-4 DEEP	4*M3		
14	31.8	31.5	31.84	
15	31.8	31.5	31.84	
16	Ø32.5	✓ 32.5		
17	103	✓ 102.9		
18	R1.0	not done		
19	5°	✓ 1.5°	2.0°	
20	27+0.1	✓ 26.95	27.14	
21	24.2 0/+0.1 (tip)	24.25	24.19	

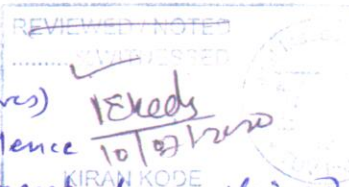
TICK MARKS RELEVANT STATEMENT

Visually check for operation completion as per process sheet, drawing / 3D Model			
Dent Mark	PRESENT <input type="checkbox"/>	NOT PRESENT <input type="checkbox"/>	
Scratch Mark	PRESENT <input type="checkbox"/>	NOT PRESENT <input type="checkbox"/>	
Remarks :- Checked on 2D UMM		Quantity accept	
		Qty rework /	
		Quantity reject	

Inspected By : <i>M.gh</i>	Approved By :
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Vendor shall obtain clearance of observed dimensions from client

- * It is recommended to keep higher margin to achieve the final dimensions (for grooves) after completion of welding. Hence it is suggested that new component be machined.



P. Gowd
22/7/2020

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Customer : M/s.BARC		Part Name: enclosure END PLATE A&B	Revision Status : 00
			Page : 2

Sr. no.	Specified Dimension	ENTRY 7A	EXIT 07 B
22	17.1 0/-0.1 (tip)	16.76 17.13 ✓	17.26 ??
23	14.1 0/+0.1 (tip)	14.4 14.15 ✓	14.25 ??
24	7 0/-0.1 (tip)	6.66 7.2 ✓	7.2
25	R0.3	Not done.	
26	▼ B	Ra 0.4 1.6 Visual	Not done
27	▼ A	Ra 1.6 1.6 Visual	Not done
28	1.6	2.05 ✓	2.15, 2.21 ✓
29	37.5° ±2.0°	43° ✓	41° ✓
Detail X		EXIT 07 B	
11	5.0	1.5° ✓	2.0° ✓
12	R1.0	R0.5 ✓	R0.5 ✓
13	▼ B	Ra 0.4 not done	1.6 Visual - Not done
15	▼ A	Ra 1.6 not done	1.6 Visual - Not done
to be check with comparators			
18	15.1 +0/-0.1		17.13 17.29
19	22.2 +0.1/0		24.43
15	15.1 +0/-0.1		14.26
16	5.0 +0/-0.1		7.2
Dimensions are out of specified limits.			

TICK MARKS RELEVANT STATEMENT			
Visually check for operation completion as per process sheet, drawing / 3D Model			
Dent Mark	PRESENT <input type="checkbox"/>	NOT PRESENT <input type="checkbox"/>	
Scratch Mark	PRESENT <input type="checkbox"/>	NOT PRESENT <input type="checkbox"/>	
Remarks :- Checked on 2D UMM		Quantity accept	
		Qty rework /	
		Quantity reject	
Inspected By : M. G. Jha		Approved By :	

Vendor shall obtain clearance of observed dimensions from client



Inspection Report

Vendor shall obtain clearance of observed dimensions from client.

RECEIVED / NOTED
WITNESSED
10/02/2000
10/02/2000