

In-Process Quality Inspection Report

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Precision Components LLC

C/D 145, TX Industrial Complex,



Report No : IQIR/12/147

Date : 17/05/2012

Shift : A

Customer Ref. : PS/145/05/2012

Customer : XYZ Motors Ltd.

Part Name : Gear Shaft

Part No. & Rev : GS-124/ Rev-2

Drawing No. : DR-4521

Material : EN-8D Steel

Inspection Stage : (First Piece / Patrol / Last Piece)

Lot No. / Batch No. : 1712/5/1

Machine No. : PRO/HT/01

Set Up & First Five Piece Approval Report

M/C No.	Oper'n Name	Product/Process Specification	Tolerance	Measurement Technique	Obs-1	Obs-2	Obs-3	Obs-4	Obs-5	Remarks	Judgment
M01	Turning	Shaft Dia Ø25.00 mm	±0.05 mm	Vernier Caliper	25.01	25.02	25	24.99	25.01	Within spec	OK
M01	Facing	Face Length 80.00 mm	±0.10 mm	Vernier Caliper	80.02	79.98	80.01	80.03	79.99	Within spec	OK

In-process Inspection Report

M/C No.	Oper'n Name	Specification	Tolerance	Measurement Technique	9:00	11:00	13:00	15:00	17:00	Remarks	Judgment
M01	Turning	Shaft Dia Ø25.00 mm	±0.05 mm	Vernier Caliper	25.01	25.02	24.99	25	25.01	Stable	OK
M01	Facing	Face Length 80.00 mm	±0.10 mm	Vernier Caliper	80.01	80	79.98	80.02	80.01	Stable	OK

Last Five Piece Inspection Report

M/C No.	Oper'n Name	Specification	Tolerance	Measurement Technique	Obs-1	Obs-2	Obs-3	Obs-4	Obs-5	Remarks	Judgment
M01	Turning	Shaft Dia Ø25.00 mm	±0.05 mm	Vernier Caliper	25	25.01	25.01	25	24.99	Final check ok	OK
M01	Facing	Face Length 80.00 mm	±0.10 mm	Vernier Caliper	80.02	80	80.01	79.99	80.01	Final check ok	OK

Operator Name : Robert S. Graham

Inspector Name : Bred Polard

Checked By : Richardson .T.