



Data Sheet for machined blanks.
Ref.: ISO/TS 16949-2002,7.5.1

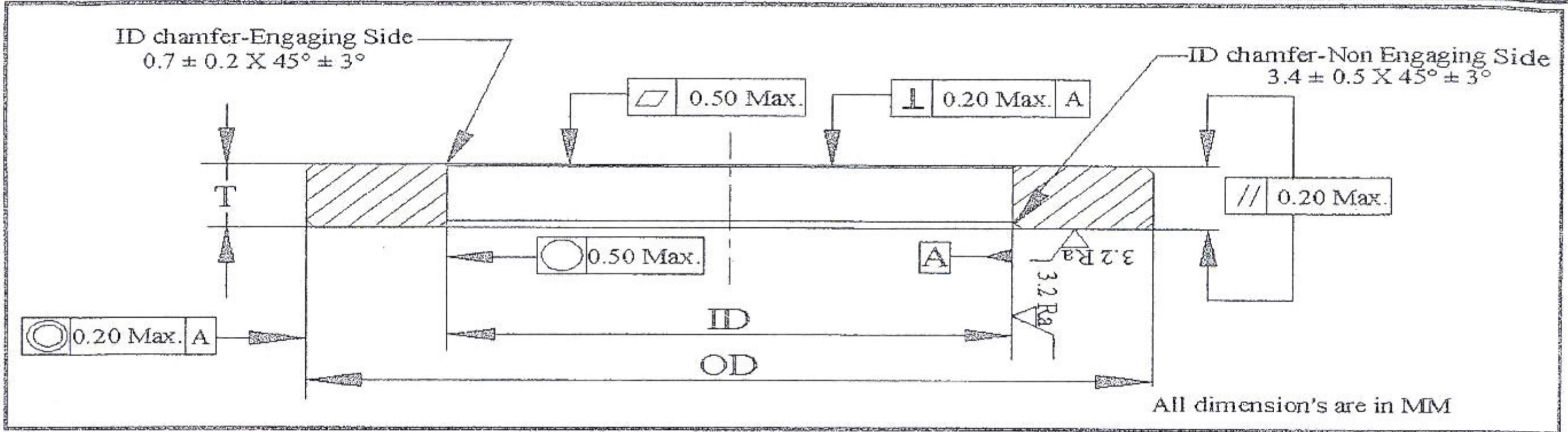
OMP REF 9725X
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PAGE 1/1

ENGG. M/C CHART : SG-ENG-F11
Origin Date :30.07.08

REVISION INDEX

REV.NO	REV. DATE	REVISION DETAILS
00	30.07.08	New Release
01	29.03.13	(CCN No.-147/2012-13)

Input : Normalised & ID Stretched blanks.



PUNCH AS PER RPAL ENGINEERING PART TRACEABILITY STANDARD NO -ANNEXURE 'A'

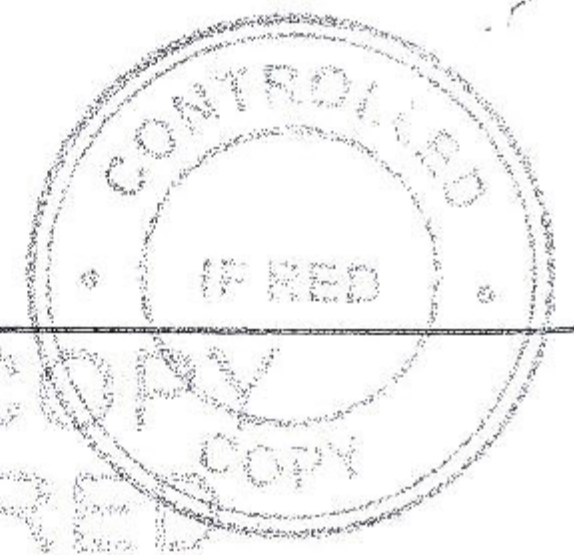
Punch	Vendor code & Batch code
Side of Punching	On Small ID Chamfer Side

All Dimensions in MM

Sr. No.	Parameters	Specifications	Instruments to be used for measurement.
1	Outer Diameter (OD)	337.25 ± 0.10	Plain Vernier
2	Inside Diameter (ID)** Special characteristics Cpk = 1.33 Min	293.05 ± 0.05	Id checking Fixture or Bore dial gauge
3	Thickness (T)	16.0 ± 0.10	Outside Micrometer
4	Radial Width (Minimum)	21.41	One end spherical micrometer
5	ID Chamfers: Engaging side	0.70 ± 0.20 x 45° ± 5°	Vernier Calliper & Bevel Protractor
6	ID Chamfers: Non-engaging side	3.40 ± 0.50 x 30° ± 5°	Vernier Calliper & Bevel Protractor
7	ID Ovality	0.50 mm max.	Id Checking Fixture
8	ID/OD Concentricity	0.20 mm max.	One end spherical micrometer
9	Flatness	0.50 mm max.	Filler Gauge
10	Perpendecularity Face to ID	0.20 mm max.	Surface Plate and Height Gauge with
11	Parallality	0.20 mm max.	Plain Outside Micrometer
12	Straightness	0.10	Surface plate, ruler & feeler gauge
13	Surface roughness on ID	3.2 Ra	Hommel roughness tester
14	Surface roughness on Face	3.2 Ra	Hommel roughness tester
15	Identification colour code	N.A.	-----

Notes :

- For machined OD, consider radial width as a reference. Maximum RW variation allowed is 0.20 mm
- For un-machined OD, maintain **minimum radial width** as a control dimension.
- Surface of machined ring blanks should be free from chatter marks, tool marks, burrs etc.
- Perform " Corner break " operation on lathe machine.
- Each supply shall carry predespatch inspection report for all the above mentioned parameters except for roughness on ID & face of blanks.
- For surface roughness on ID & face, a report is to be submitted once in a month.
- For unfaced with skin cut parts, ensure removal of equal material from both the faces.
- Instruments to be used for the measurement of geometrical tolerances.
ID Ovality: ID checking fixture OR Bore dial gauge.
Flatness: Surface plate & feeler gauge
ID to face perpendicularity: Height Gauge, Lever Dial & Surface Plate.



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ONLY F RED

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