

**BINEET AUTO INDUSTRIES****QUALITY PLAN FOR INPROCESS INSPECTION**

Product Name : LEAF SPRINGS

S. No.	Operation	Characteristics to be checked	Acceptance Criteria	Inspection Method	Inspection Frequency
1.	SHEARING	1. Length 2. Perpendicularity 3. Burr	1. As specified 2. Perpendicular 3. No Burr	1. By measuring tape 2. By Right angle 3. Visual	1.5 Pcs / hour 2.5 Pcs / hour 3.5 Pcs / hour
2.	SIDE CUTTING	1. Cutting Length 2. Cutting Width 3. Burr	1. As per data sheet 2. As per data sheet 3. No Burr	1. By measuring tape 2. By measuring tape 3. Visual	1.5 Pcs / hour 2.5 Pcs / hour 3.5 Pcs / hour
3.	EYE ROLLING	1. Eye Dia 2. Eye Parallelism 3. Burning spot 4. Dent Marks 5. Eye Gap	1. As per data sheet 2. Parallel 3. No burning spot 4. No dent marks 5. As specified	1. By Vernier Callipers 2. Visual 3. Visual 4. Visual 5. By Filler Gauge	1.5 Pcs / hour 2.5 Pcs / hour 3.5 Pcs / hour 4.5 Pcs / hour 5.5 Pcs / hour
4.	DRILLING	1. Hole Size 2. Perpendicularity 3. C/C distance	1. As per data sheet 2. Perpendicular 3. As per data sheet	1. By Vernier Calipers 2. By Vernier Calipers 3. By Measuring Tape	1.5 Pcs / hour 2.5 Pcs / hour 3.5 Pcs / hour
5.	NIBBING	1. Nibbing Size 2. Nibbing distance	1. As per data sheet 2. As per data sheet	1. By Gauge 2. By Measuring Tape	1.5 Pcs / hour 2.5 Pcs / hour
6.	TAPER ROLLING	1. Taper Length 2. Taper Width 3. Die Marks 4. Burning Spot	1. As per data sheet 2. As per data sheet 3. No die marks 4. No burning spots	1. By Measuring Tape 2. By Vernier Calipers 3. Visual 4. Visual	1.5 Pcs / hour 2.5 Pcs / hour 3.5 Pcs / hour 4.5 Pcs / hour
7..	HARDENING	1. Furnace Temperature 2. Quenching Oil Temperature 3. ASQ Hardness 4. Burning Spot	1. 920°C ± 10°C 2. 70°C ± 10°C 3. 555 BHN min. 4. No Burning Spot	1. By temperature Indicator 2. By temperature Indicator 3. Hardness Tester 4. Visual	1.5 Pcs / hour 2.5 Pcs / hour 3.5 Pcs / hour 4.5 Pcs / hour

8.	TEMPERING	1. furnace Temperature 2. Tempered Hardness	1. 460°C ± 10°C 2. 362 BHN – 444 BHN	1. By temperature Indicator 2. By Hardness Tester	1.5 Pcs / hour 2.5 Pcs / hour
9.	HARDNESS TESTING	1. Removal of Decarburised surface 2. Impression Ovality	1. 0.1 mm 2. Nil	1. Visual 2. Microscope	1.5 Pcs / hour 2.5 Pcs / hour
10.	CAMBERING	1. Camber	1. As per data sheet	1. Scale	1.5 Pcs / hour
11.	BUSH FITTING	1. Bush Dia after fitting	1. As Original dia of Bush	1. By Gauge	1.5 Pcs / hour
12.	EYE GRINDING	1. Eye Length 2. Grinding Coverage	1. As specified 2. Proper	1. By Vernier Calipers 2. Visual	1.5 Pcs / hour 2.5 Pcs / hour
13.	CLAMPING	1. Riveting 2. Perpendicularity	1. Properly 2. perpendicular	1. Visual 2. Visual	1.5 Pcs / hour 2.5 Pcs / hour
14.	ASSEMBLY	1. Inter Leaf Gap 2. No. of leaf 3. Camber 4. Position of Clamp	1. No inter leaf gap 2. As per data sheet 3. As per data sheet 4. As per datasheet	1. Visual / By Filler gauge 2. Visual 3. By Scale 4. Visual.	1.5 Pcs / hour 2.5 Pcs / hour 3.5 Pcs / hour 4.5 Pcs / hour
15..	SCRAGGING	1. Deflection 2. Camber	1. As per data sheet 2. As per data sheet	1. By Scale 2. By Scale	1.2 Pcs / hour 2.5 Pcs / hour
16.	PAINTING	1. Colour 2. Coverage	1. As per data sheet As per data sheet 2. 100 %	1. Visual 2. Visual	1.5 Pcs / hour 2.5 Pcs / hour
17.	PRINTING	1. Matter 2. Clarity	1. As specified 2. 100%	1. Visual 2. Visual	1.5 Pcs / hour 2.5 Pcs / hour