



DURING PRODUCTION INSPECTION REPORT

CSE ORDER NUMBER: **DPI202501280035**

PRODUCTS NAME: **Cylinder Parts**

PO NUMBER: *********

QUANTITY: **500 pcs**

CLIENT NAME: ******* Inc**

FACTORY NAME: **Hefei ** **** Co., Ltd.**

SUPPLIER NAME: **Shanghai ***** Limited**

REPORT DONE BY: **Kim Wong**

DATE OF INSPECTION: **Jan 30th 2025**

DATE OF REPORT: **Feb 1st 2025**



REPORT DATE	CLIENT NAME	INSPECTOR
Feb 01 2025	***** INC.	KIM WONG

RESULTS

NO	CRITICAL CHECK LIST
1	Material Certificate
2	Important Dimensions on the drawing
3	Shape of hydraulic hole, checked by Go/No Go Gauge
4	Deburring of hydraulic hole
5	Thread holes, checked by Thread Go/No Go Gauge
6	Mechanical property, Tensile strength Test
7	
8	
9	
10	
11	



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INSPECTION STANDARDS

Inspection Type		During Production Inspection		
Sampling Standard		ANSI/ASQ Z1.4		
Sampling Level		II		
AQL Tolerances	CRITICAL defaults	0		
	IMPORTANT defaults	2.5		
	MINOR defaults	4.0		
Quantity of inspection items		50pcs		
Total quantity		500pcs		
SIZE OF THE SAMPLE / Number of inspected PIECES	AQL II SAMPLE SIZE	50pcs	ACCEPT CRITICAL	0
			ACCEPT IMPORTANT	0
			ACCEPT MINOR	5
Factory cooperation during the inspection		Good		
Factory quality organization		Good		
Inspector's general opinion on the factory		The factory provided excellent cooperation and follow-up for the project.		



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	ITEM NUMBER	DESCRIPTION	QTY PRODUCED	QTY. INSPECTED	QTY. CONFORM	QTY. NONCONF.	PENDING *
1	310-0011	Cylinder Cap	10pcs	10pcs	10pcs		
	ITEM COMMENTS :	1. I did random sampling inspections during the production process. Both the dimensions and finish meet the requirements.					
2	310-0012	Cylinder Cap	10pcs	10pcs	10pcs		
	ITEM COMMENTS :	1. I did random sampling inspections during the production process. Both the dimensions and finish meet the requirements.					
3	310-0013	Cylinder Cap	10pcs	10pcs	9pcs	1pcs	
	ITEM COMMENTS :	1. I did random sampling inspections during the production process. Both the dimensions and finish meet the requirements on 9pcs. 2. 1pc was rejected because a important dimension is out of tolerance.					
4	310-0018	Cylinder Cap	10pcs	10pcs	10pcs		
	ITEM COMMENTS :	1. I did random sampling inspections during the production process. Both the dimensions and finish meet the requirements.					
5	310-0020	Cylinder Cap	10pcs	10pcs	10pcs	pcs	
	ITEM COMMENTS :	1. I did random sampling inspections during the production process. Both the dimensions and finish meet the requirements.					



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DRAWING SPEC	MEASUREMENT RECORD of 310-0020										TOOL	
	1	2	3	4	5	6	7	8	9	10		
(inch)												
φ4.25	4.249	4.251	4.25	4.25	4.251	4.251	4.251	4.251	4.25	4.25	Outside micrometer	
φ3.500	3.498	3.498	3.497	3.499	3.499	3.498	3.498	3.498	3.496	3.497	outside micrometer	
◎φ0.020	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	CMM	
φ3.125/3.135	3.132	3.132	3.132	3.131	3.13	3.13	3.131	3.131	3.13	3.13	outside micrometer	
φ2.997/2.999	2.998	2.998	2.999	2.998	2.998	2.998	2.998	2.998	2.998	2.998	CMM	
φ2.312	2.312	2.313	2.313	2.311	2.311	2.312	2.313	2.312	2.312	2.311	callipers	
◎φ0.005	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	CMM	
0.688	0.687	0.687	0.687	0.688	0.687	0.688	0.688	0.687	0.687	0.688	callipers	
0.375±0.005	0.375	0.375	0.375	0.376	0.376	0.374	0.375	0.376	0.374	0.375	depthometer	
φ2.000/2.002	2.001	2.001	2.001	2.001	2.001	2.001	2.001	2.001	2.001	2.001	internal micrometer	
◎φ0.001	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	CMM	
⊥0.001	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	CMM	
Ra63	22	34	38	24	36	31	27	33	42	29	Fingers and eyes	
φ3/16	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	Pin	
1/8 NPT	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	Thread gauge	
2.000	1.997	1.997	1.997	1.998	1.993	1.995	1.996	1.993	1.997	1.996	callipers	
ORB 06 thread 9/16-18	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	Thread gauge	
ORB 06 roughness	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	Fingers and eyes	
ORB 06 thread 9/16-18	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	Thread gauge	
ORB 06 roughness	ok	ok	ok	ok	ok	ok	ok	ok	ok	ok	Fingers and eyes	



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Product Appearance



Product details different view(310-0011)



Product details different view(310-0012)



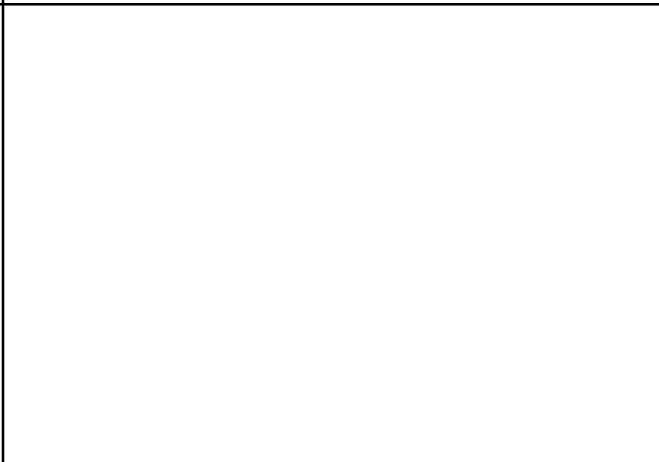
Product details different view(310-0013)



Product details different view(310-0018)



Product details different view(310-0020)



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310-0011 Inspection Pictures



Measuring: $\phi 0.2.997-2.999''$



Measuring: 3/4-16UNF-2B(go & no go)



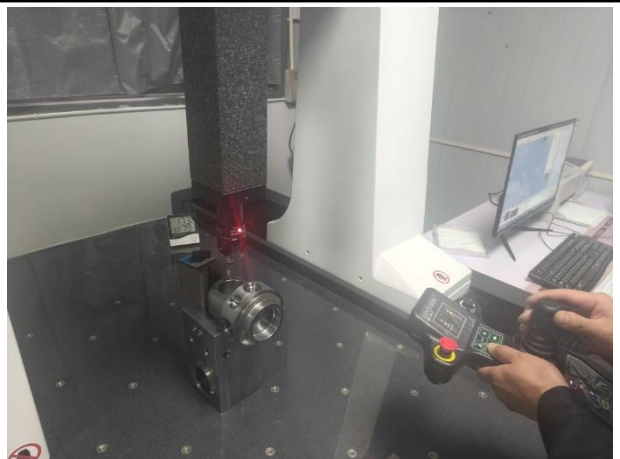
Measuring: $\phi 0.875-0.877''$



Measuring: 2.000-2.002"



Measuring: Ra 63 testing



Measuring: CMM report

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310-0012 Inspection Pictures



Measuring: $\phi 0.812-0.814''$



Measuring: $\phi 0.687-0.689''$



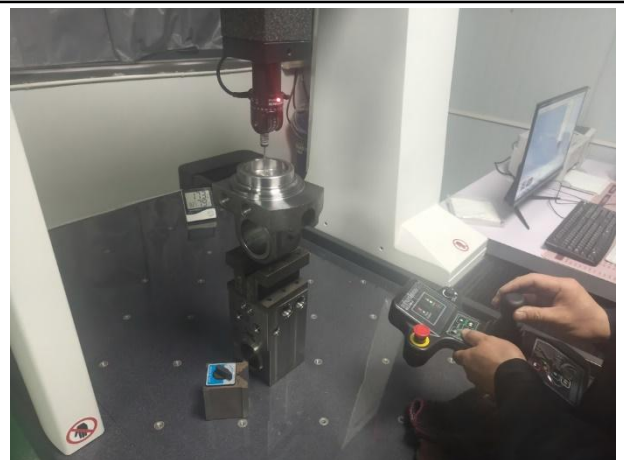
Measuring: $\phi 1.000-1.002''$



Measuring: $\phi 2.500-2.502''$



Measuring: Ra 63 testing

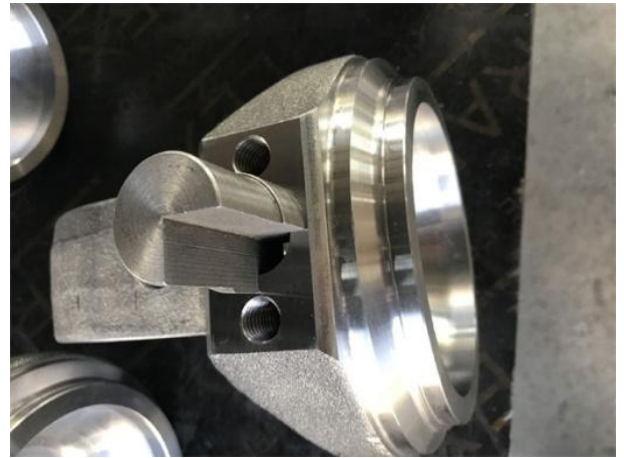


Measuring: CMM testing

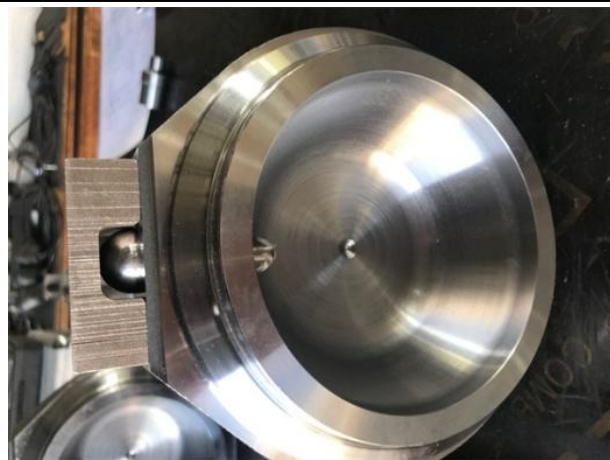
310-0013 Inspection Pictures



Measuring: $\phi 4.997-4.999''$



Measuring: Gauge (08 ORB)



Measuring: 0.467Max (Gauge)



Measuring: $\phi 2.500-2.502''$



Measuring: $\phi 0.668-0.674''$



Measuring: CMM testing

310-0018 Inspection Pictures



Measuring: 3.750"



Measuring: $\phi 0.375$ "



Measuring: $\phi 1.520/1.525$ "



Measuring: 5/16-18UNC-2B (go & no go)



Measuring: Ra63 testing



Measuring: CMM testing

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310-0020 Inspection Pictures



Measuring: $\phi 1.000/1.002''$



Measuring: $\phi 3.497-3.499''$



Measuring: Ra 63 Testing



Measuring: 3/4-16UNF-2B (go & no go)



Measuring: Ra 63 Testing



Measuring: CMM testing