CRITICAL CHARACTERISTICS CONTROL CHART

PART NAME :	Bearing housing FR2-200-160			Flowserve
DRAWING .NO :	H106/125	REV: D	INSTRUMENT	BORE DIAL (L/C -0.001)
OPERATION	Turning VTL 1st opn		FREQUENCY 100%	
PREPARED BY: Mr. K. Mathan			APPROVED BY: N. Gajendhran	DATE: 12/03/20

ID 222+0.05 (In mm)															
222.045															
222.040															
222.035		⊙	⊙												
222.030	⊙			⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙	⊙
222.025															
222.020															
222.015															
222.010															
222.005															

PART NO:	I1	I2	I3	I4	I5	I6	I7	I8	I9	I10	I11	I12	I13	I14	I15
P.O.NO:															
DATE/SHIFT			12/03/20												
OPR./ INS	Thm	Thm	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	Thm	Thm	Thm

ID 222+0.05 (In mm)															
222.045															
222.040	⊙	⊙	⊙	⊙											
222.035															
222.030															
222.025															
222.020															
222.015															
222.010															
222.005															

PART NO:	I16	I17	I18	I19	I20										
P.O.NO:															
DATE/SHIFT															
OPR./ INS	Thm	Thm	Thm	Thm	Thm										

ID 222+0.05 (In mm)															
222.045															
222.040															
222.035															
222.030															
222.025															
222.020															
222.015															
222.010															
222.005															

PART NO:															
P.O.NO:															
DATE/SHIFT															
OPR./ INS															

CRITICAL CHARACTERISTICS CONTROL CHART

PART NAME :	Bearing housing FR2 200-160		Flowserve
DRAWING .NO :	H106/125 REV: D	INSTRUMENT	BORE DIAL (L/C -0.001)
OPERATION	Turning VTL 2nd	FREQUENCY 100%	
PREPARED BY: Mr. K. Mathan		APPROVED BY: N. Gajendhran	DATE: 14/9/20

ID- 146.01 + 0.02 MM

In mm																
146.030																
146.025																
146.020																
146.015																
146.010																

PART NO:																
P.O.NO:																
DATE/SHIFT																
OPR./ INS																

ID- 100.0 + 0.02 MM

In mm																
100.020																
100.015																
100.010																
100.005																
100.000																

PART NO:																
P.O.NO:																
DATE/SHIFT																
OPR./ INS																

ID 68(0/+0.04)

In mm																
68.050																
68.045																
68.040																
62.035																
68.030																
68.025																
68.020																
68.015																
68.010																
68.005																

PART NO:	I7	8M	I5	82	5M	5.5	80	87	86	85	87	83	82	I1	I8	
P.O.NO:																
DATE/SHIFT	14.9.20													14/9/20		
OPR./ INS														M.N	M.N	

CRITICAL CHARACTERISTICS CONTROL CHART

PART NAME :	Bearing housing FR2 200-160		Flowserve
DRAWING .NO :	H106/125 REV: D	INSTRUMENT	BORE DIAL (L/C -0.001)
OPERATION	Turning VTL 2nd	FREQUENCY 100%	
PREPARED BY: Mr. K. Mathan		APPROVED BY: N. Gajendhran	DATE: 14/9/20

ID- 146.01 + 0.02 MM																	
In mm																	
146.030																	
146.025																	
146.020	✓	✓	✓	✓	✓												
146.015																	
146.010																	

PART NO:																	
P.O.NO:																	
DATE/SHIFT																	
OPR./ INS																	

ID- 100.0 + 0.02 MM																	
In mm																	
100.020																	
100.015																	
100.010	✓	✓	✓	✓	✓												
100.005																	
100.000																	

PART NO:																	
P.O.NO:																	
DATE/SHIFT																	
OPR./ INS																	

ID 68(0/+0.04)																	
In mm																	
68.050																	
68.045																	
68.040																	
62.035																	
68.030																	
68.025	✓		✓	✓	✓												
68.020		✓															
68.015																	
68.010																	
68.005																	

PART NO:	I4	I18	I17	I19	I20												
P.O.NO:																	
DATE/SHIFT	14/9/20 I																
OPR./ INS	M.M	M.M	M.M	M.M	M.M												