



瑋達工業有限公司

JINTAT INDUSTRIAL CO.,LTD

進料檢驗報告 / Incoming Inspection Report

球號	標準		上限	下限	量測設備	檢驗頻率	量測數據 Measurement Data					Result		備註
No.	Spec		USL	LSL	Equipment	Test Freq.	S1	S2	S3	S4	S5	ACC	REJ	Comment
◎	★	產品外觀 Appearance Check	不可缺肉碰傷 及氧化毛邊等		Visual	AQL=1.0 / 每批	OK	OK	OK	OK	OK	✓		
			年輪章 確認產件生產日期		Visual	AQL=1.0 / 每批	N/A	N/A	N/A	N/A	N/A	✓		
					Visual	AQL=1.0 / 每批	N/A	N/A	N/A	N/A	N/A	✓		
◎	★	產品包裝 Packing Check	不可有如不完 整、破損等		Visual	100% / 每批	✓	✓	✓	✓	✓	✓		
◎	★	材質 Material	S15C		Material Certification	—	s45c	s45c	s45c	s45c	s45c	✓		
◎	★	表面處理 Finish	BLK OXIDE AMS-2485		Finish Certification	—	染黑	染黑	染黑	染黑	染黑	✓		
1-A		1/4-20 UNC -2B	GO	NOGO	Thread Gauge	5	ok	ok	ok	ok	ok	✓		
		▽ .50 ± 0.02	0.52	0.48	Thread Gauge + Caliper	5	0.5	0.501	0.5	0.51	0.5	✓		
1-B		1/4-20 UNC -2B	GO	NOGO	Thread Gauge	5	ok	ok	ok	ok	ok	✓		
		▽ .50 ± 0.02	0.52	0.48	Thread Gauge + Caliper	5	0.502	0.502	0.5	0.501	0.502	✓		
1-C		1/4-20 UNC -2B	GO	NOGO	Thread Gauge	5	ok	ok	ok	ok	ok	✓		
		▽ .50 ± 0.02	0.52	0.48	Thread Gauge + Caliper	5	0.501	0.5	0.505	0.51	0.504	✓		
1-D		1/4-20 UNC -2B	GO	NOGO	Thread Gauge	5	ok	ok	ok	ok	ok	✓		
		▽ .50 ± 0.02	0.52	0.48	Thread Gauge + Caliper	5	0.5	0.503	0.5	0.51	0.502	✓		
2-A		60° ± 1°	61	59	CMM	5	60.03	60	60.03	60.01	60.01	✓		
2-B		60° ± 1°	61	59	CMM	5	59.99	60.02	60.01	60	59.98	✓		
2-C		60° ± 1°	61	59	CMM	5	60.03	60.03	60.01	60.03	60.02	✓		
2-D		60° ± 1°	61	59	CMM	5	59.976	60.05	60.01	59.98	60	✓		
3-a		5/16-18 UNC - 2B THRU ALL	GO	NOGO	Thread Gauge	5	OK	OK	OK	OK	OK	✓		
3-b		5/16-18 UNC - 2B THRU ALL	GO	NOGO	Thread Gauge	5	OK	OK	OK	OK	OK	✓		
3-c		5/16-18 UNC - 2B THRU ALL	GO	NOGO	Thread Gauge	5	OK	OK	OK	OK	OK	✓		
3-d		5/16-18 UNC - 2B THRU ALL	GO	NOGO	Thread Gauge	5	OK	OK	OK	OK	OK	✓		
4-L		Ø .505 +.001/-0	0.506	0.505	CMM	5	0.505	0.506	0.505	0.506	0.505	✓		
		▽ .85 ± 0.02	0.87	0.83	CMM	5	0.856	0.853	0.851	0.85	0.855	✓		
4-R		Ø .505 +.001/-0	0.506	0.505	CMM	5	0.505	0.505	0.505	0.506	0.505	✓		
		▽ .85 ± 0.02	0.87	0.83	CMM	5	0.856	0.854	0.853	0.851	0.855	✓		
5-L		R2.280 ± 0.005	2.285	2.275	CMM	5	2.282	2.284	2.284	2.283	2.284	✓		
5-R		R2.280 ± 0.005	2.285	2.275	CMM	5	2.275	2.281	2.281	2.283	2.283	✓		
6		Ø 4.150 B.C.	4.155	4.145	CMM	5	4.149	4.149	4.149	4.149	4.149	✓		
7-1		Ø .323 THRU	0.328	0.318	CMM	5	0.324	0.324	0.323	0.325	0.324	✓		
		□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.53	✓		
		▽ .34 ± 0.02	0.36	0.32	CMM	5	0.339	0.34	0.34	0.338	0.34	✓		
7-2		Ø .323 THRU	0.328	0.318	CMM	5	0.323	0.324	0.324	0.324	0.323	✓		
		□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.531	✓		
		▽ .34 ± 0.02	0.36	0.32	CMM	5	0.32	0.324	0.323	0.324	0.322	✓		

球號	標準	上限	下限	量測設備	檢驗頻率	量測數據 Measurement Data					Result		備註
No.	Spec	USL	LSL	Equipment	Test Freq.	S1	S2	S3	S4	S5	ACC	REJ	Comment
7-3	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.323	0.323	0.3234	0.323	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.53	0.53	0.53	0.532	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.34	0.34	0.34	0.34	✓		
7-4	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.32	0.323	0.323	0.323	0.32	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.53	0.53	0.53	0.532	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.341	0.34	0.342	0.343	✓		
7-5	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.322	0.323	0.323	0.323	0.322	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.531	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.339	0.34	0.34	0.338	0.34	✓		
7-6	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.323	0.323	0.323	0.323	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.531	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.34	0.341	0.34	0.341	✓		
7-7	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.323	0.324	0.323	0.322	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.529	0.531	0.531	0.53	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.341	0.34	0.341	0.34	✓		
7-8	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.323	0.322	0.319	0.323	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.53	0.531	0.529	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.341	0.341	0.341	0.34	✓		
7-9	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.324	0.324	0.323	0.324	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.53	0.531	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.34	0.34	0.34	0.34	✓		
7-10	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.324	0.324	0.323	0.324	0.324	.		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.531	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.341	0.34	0.34	0.34	✓		
7-11	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.324	0.324	0.323	0.322	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.531	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.34	0.341	0.339	0.34	✓		
7-12	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.324	0.324	0.323	0.322	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.531	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.341	0.34	0.34	0.339	✓		
7-13	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.324	0.323	0.323	0.322	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.531	0.531	0.531	0.531	0.531	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.341	0.34	0.34	0.339	✓		
7-14	Ø .323 THRU ± 0.005	0.328	0.318	CMM	5	0.323	0.324	0.323	0.322	0.324	✓		
	□ Ø .531 ± 0.005	0.536	0.526	CMM	5	0.53	0.531	0.531	0.53	0.529	✓		
	▽ .34 ± 0.02	0.36	0.32	CMM	5	0.34	0.34	0.34	0.341	0.34	✓		
8	6.500 ± 0.001	6.501	6.499	CMM	5	6.5	6.5	6.5	6.499	6.5	✓		
9	3.250 ± 0.005	3.255	3.245	CMM	5	3.25	3.249	3.25	3.25	3.25	✓		
10	Ø 8.200 B.C. ± 0.005	8.205	8.195	CMM	5	8.202	8.199	8.2	8.202	8.198	✓		
11	1.125 ± 0.005	1.130	1.120	CMM	5	1.126	1.124	1.124	1.125	1.126	✓		
12-L	FULL R	PASS	FAIL	Visual	5	pass	pass	pass	pass	pass	✓		
12-R	FULL R	PASS	FAIL	Visual	5	pass	pass	pass	pass	pass	✓		
13-TL	R.500 ± 0.005	0.505	0.495	CMM	5	0.498	0.499	0.497	0.498	0.499	✓		
13-BL	R.500 ± 0.005	0.505	0.495	CMM	5	0.498	0.498	0.498	0.498	0.498	✓		
13-TR	R.500 ± 0.005	0.505	0.495	CMM	5	0.499	0.497	0.498	0.499	0.496	✓		
13-BR	R.500 ± 0.005	0.505	0.495	CMM	5	0.498	0.5	0.502	0.498	0.497	✓		

球號		標準	上限	下限	量測設備	檢驗頻率	量測數據 Measurement Data					Result		備註
No.		Spec	USL	LSL	Equipment	Test Freq.	S1	S2	S3	S4	S5	ACC	REJ	Comment
14		Ø 4.540 ± 0.005	4.545	4.535	CMM	5	4.541	4.539	4.541	4.539	4.541	✓		
15-A		30° ± 1°	31	29	CMM	5	29.96	29.98	30.01	29.98	29.97	✓		
15-B		30° ± 1°	31	29	CMM	5	29.95	30.01	30.34	29.98	30	✓		
15-C		30° ± 1°	31	29	CMM	5	29.97	29.95	29.99	29.96	29.95	✓		
15-D		30° ± 1°	31	29	CMM	5	30.02	30	30.01	29.99	30	✓		
16		(1.843)	-	-	CMM	5	1.845	1.842	1.843	1.845	1.843	✓		
17		1.089 ± 0.005	1.094	1.084	CMM	5	1.088	1.088	1.088	1.088	1.088	✓		
18		0.413 +.015/-0	0.428	0.413	CMM	5	0.42	0.42	0.42	0.42	0.42	✓		
19		0.610 ± 0.005	0.615	0.605	CMM	5	0.609	0.609	0.609	0.609	0.609	✓		
20		0.510 +.010/-0	0.520	0.510	CMM	5	0.515	0.516	0.515	0.516	0.515	✓		
21		0.025 ± 0.005	0.030	0.020	投影	5	0.028	0.028	0.027	0.028	0.028	✓		
		45° ± 1°	46	44	投影	5	45	44.9	45	45	45	✓		
		0.025 ± 0.005	0.030	0.020	投影	5	0.028	0.026	0.028	0.026	0.027	✓		
		45° ± 1°	46	44	投影	5	45	44.9	45	44.8	44.9	✓		
22		Ø 6.300 ± 0.005	6.305	6.295	CMM	5	6.299	6.3	6.3	6.298	6.3	✓		
23		Ø 4.000 ± 0.005	4.005	3.995	CMM	5	3.999	3.999	4	3.999	3.998	✓		
24		Ø 3.501 +.002/-0	3.503	3.501	CMM	5	3.502	3.502	3.503	3.501	3.502	✓		
		◎ .001 A	0.001	0.000	CMM	5	0.001	0.001	0.00058	0.0008	0.001	✓		
25-1		R.005 MAX	0.005	0.000	投影	5	0.004	0.005	0.004	0.005	0.003	✓		
25-2		R.005 MAX	0.005	0.000	投影	5	0.003	0.003	0.004	0.005	0.003	✓		
25-3		R.005 MAX	0.005	0.000	投影	5	0.005	0.005	0.004	0.003	0.002	✓		
25-4		R.005 MAX	0.005	0.000	投影	5	0.005	0.005	0.005	0.005	0.005	✓		
26-1		R.030 ± 0.005	0.035	0.025	投影	5	0.031	0.028	0.027	0.028	0.027	✓		
26-2		R.030 ± 0.005	0.035	0.025	投影	5	0.029	0.029	0.029	0.028	0.029	✓		
26-3		R.030 ± 0.005	0.035	0.025	投影	5	0.026	0.026	0.025	0.025	0.027	✓		
26-4		R.030 ± 0.005	0.035	0.025	投影	5	0.029	0.027	0.026	0.028	0.029	✓		
27		0.948 ± 0.005	0.953	0.943	CMM	5	0.946	0.948	0.948	0.947	0.948	✓		
28		0.645 ± 0.005	0.650	0.640	CMM	5	0.644	0.644	0.644	0.644	0.644	✓		
29		0.148 ± 0.005	0.153	0.143	CMM	5	0.148	0.147	0.148	0.148	0.1476	✓		
30		0.675 ± 0.005	0.680	0.670	CMM	5	0.675	0.674	0.674	0.676	0.674	✓		
31		0.895 ± 0.005	0.900	0.890	CMM	5	0.896	0.894	0.896	0.894	0.895	✓		
32-1		R.015 MAX	0.015	0.000	投影	5	0.013	0.014	0.013	0.014	0.015	✓		
32-2		R.015 MAX	0.015	0.000	投影	5	0.014	0.014	0.013	0.014	0.0145	✓		
32-3		R.015 MAX	0.015	0.000	投影	5	0.013	0.013	0.014	0.014	0.015	✓		
32-4		R.015 MAX	0.015	0.000	投影	5	0.012	0.013	0.014	0.015	0.012	✓		
33		Ø 3.267 +.002/-0	3.269	3.267	CMM	5	3.268	3.268	3.267	3.268	3.268	✓		
		◎ .001 A	0.001	0.000	CMM	5	0.001	0.001	0.001	0.001	0.001	✓		
34		Ø 3.750 +.003/-0	3.753	3.750	CMM	5	3.751	3.751	3.752	3.753	3.751	✓		
		◎ .002 A	0.002	0.000	CMM	5	0.0014	0.001	0.0012	0.0011	0.0013	✓		
35		32/√	32	0	Roughness Tester	5	16	16	16	16	16	✓		
36		63/√	63	0	Roughness Tester	5	16	16	16	16	16	✓		
37		Ø 8.860 ± 0.005	8.865	8.855	CMM	5	8.86	8.859	8.864	8.861	8.86	✓		
38		0.025 ± 0.005	0.030	0.020	投影	5	0.02	0.022	0.02	0.022	0.021	✓		
		45° ± 1°	46	44	投影	5	44.5	44.6	44.8	44.6	44.4	✓		
39		0.060 ± 0.005	0.065	0.055	投影	5	0.061	0.06	0.059	0.06	0.058	✓		
		45° ± 1°	46	44	投影	5	45	44.8	44.9	44.7	45	✓		

球號		標準	上限	下限	量測設備	檢驗頻率	量測數據 Measurement Data					Result		備註
No.		Spec	USL	LSL	Equipment	Test Freq.	S1	S2	S3	S4	S5	ACC	REJ	Comment
40-1		R.030 ± 0.005	0.035	0.025	投影	5	0.028	0.03	0.028	0.031	0.033	✓		
40-2		R.030 ± 0.005	0.035	0.025	投影	5	0.0274	0.026	0.027	0.029	0.025	✓		
40-3		R.030 ± 0.005	0.035	0.025	投影	5	0.0288	0.027	0.028	0.028	0.0276	✓		
40-4		R.030 ± 0.005	0.035	0.025	投影	5	0.027	0.026	0.025	0.028	0.033	✓		
41-1		R.005 MAX	0.005	0.000	投影	5	0.005	0.005	0.005	0.005	0.005	✓		
41-2		R.005 MAX	0.005	0.000	投影	5	0.004	0.004	0.005	0.004	0.005	✓		
42		Ø 7.499 +0/-0.002	7.499	7.497	CMM	5	7.497	7.497	7.497	7.497	7.497	✓		
43		Ø 7.048 +0/-0.004	7.048	7.044	CMM	5	7.046	7.046	7.046	7.045	7.046	✓		
		◎ .002 A	0.002	0.000	CMM	5	0.0004	0.0003	0.0004	0.0003	0.0005	✓		
44			32	0	Roughness Tester	5	16	16	16	16	16	✓		
45		0.375 +.005/-0	0.380	0.375	CMM	5	0.378	0.376	0.377	0.378	0.376	✓		
46			63	0	Roughness Tester	5	16	16	16	16	16	✓		
47			63	0	Roughness Tester	5	16	16	16	16	16	✓		
48		0.350 ± 0.005	0.355	0.345	CMM	5	0.349	0.345	0.348	0.35	0.345	✓		
49		0.180 ± 0.005	0.185	0.175	CMM	5	0.179	0.179	0.179	0.179	0.178	✓		
※			64	0	Roughness Tester	5	16	16	16	16	16	✓		
最終判定		☒	允收		處置方式		☐	①特採						
		☐	不允收				☐	②重工						
備註/說明		1.IQC在檢驗後要依據檢驗結果做最終判定 2.當最終判定是允收時，處置方式不用勾選；最終判定是不允收時，必須勾選處置方式 3.當檢驗項目的檢驗值超出標準範圍時，可由QA做最終判定(IQC要提供檢驗NG品給QA判斷) 4.★進料重點檢驗。 5.其他尺寸於特殊狀況檢驗，如：更換供應商、首件…etc.檢驗。												