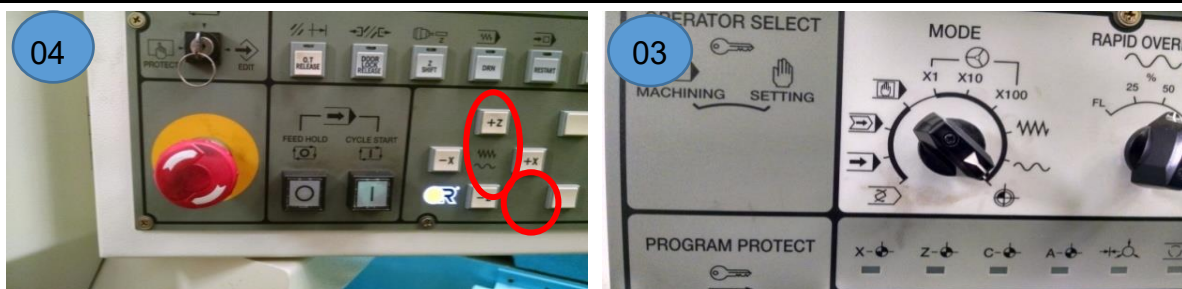
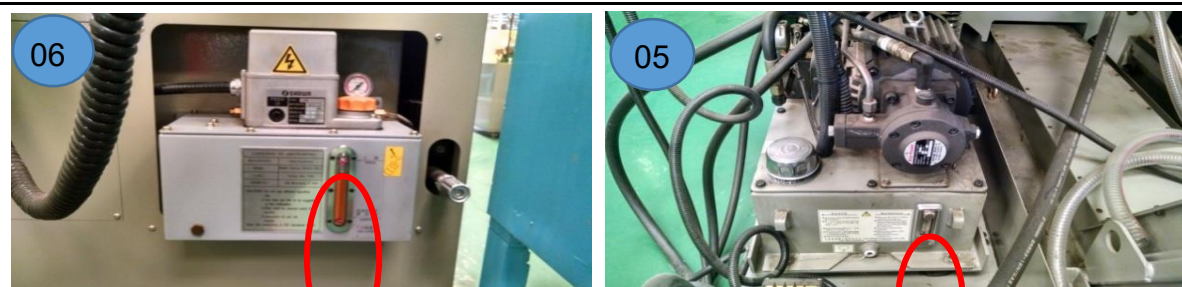
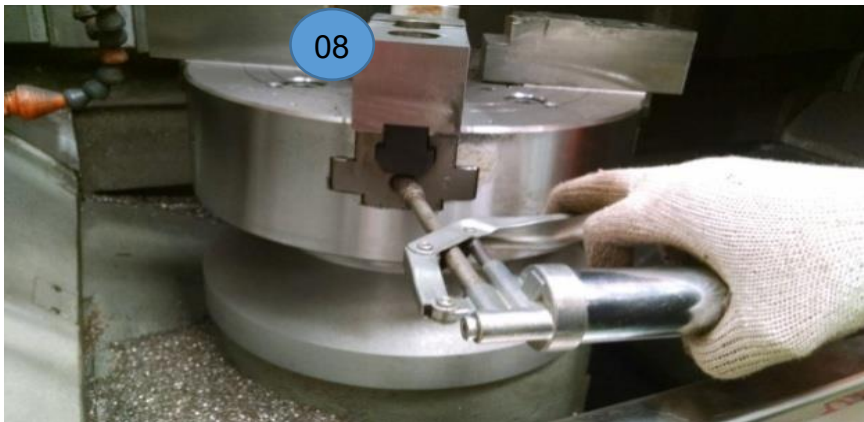
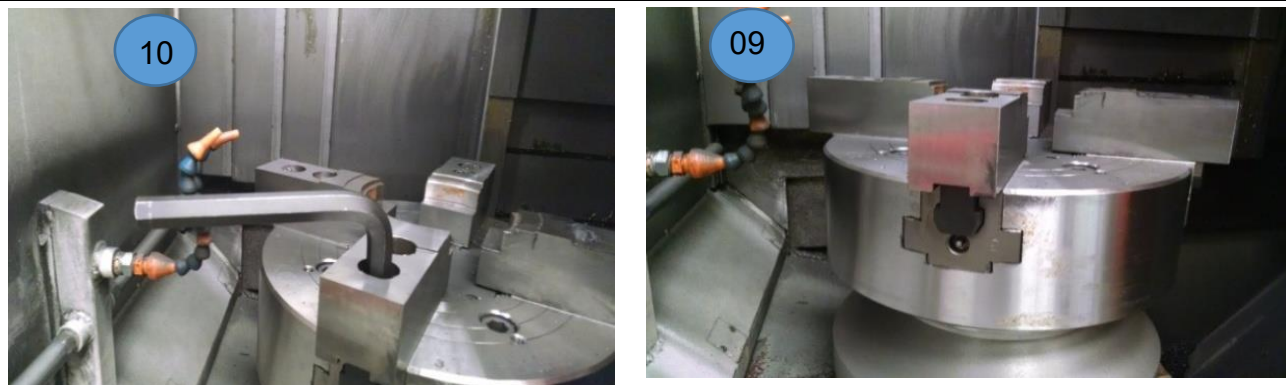
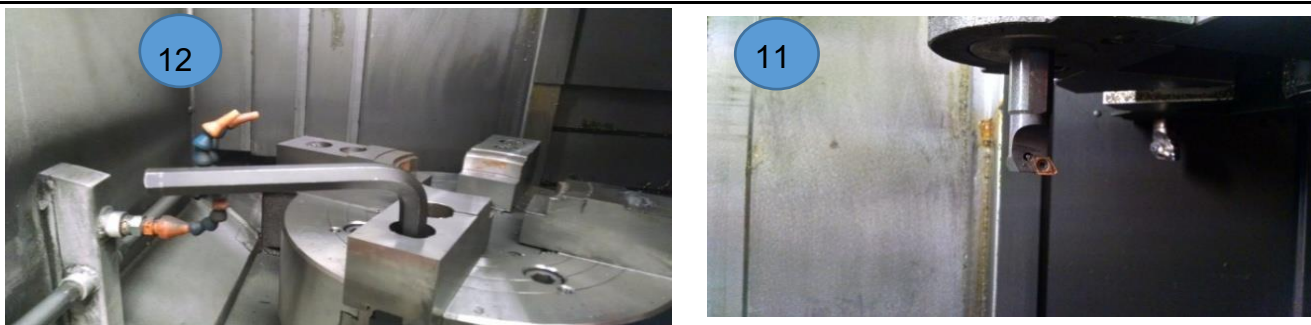
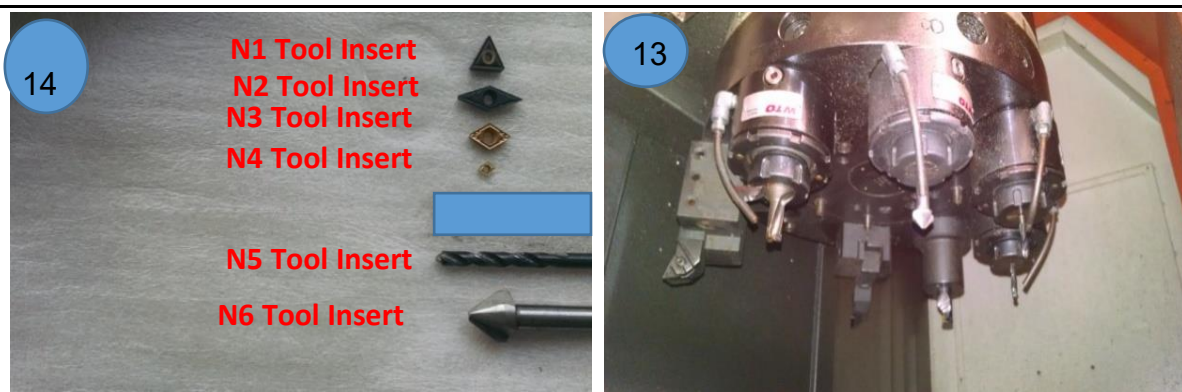
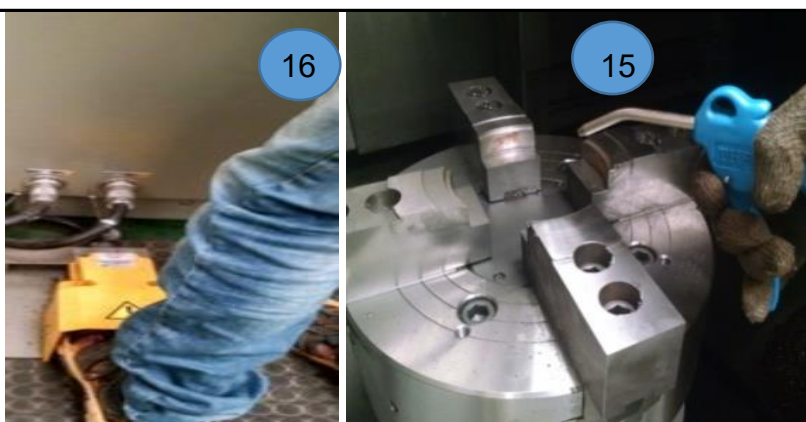
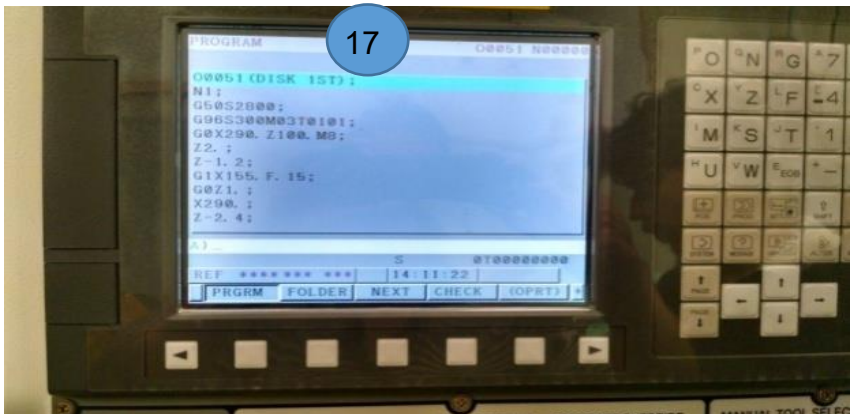
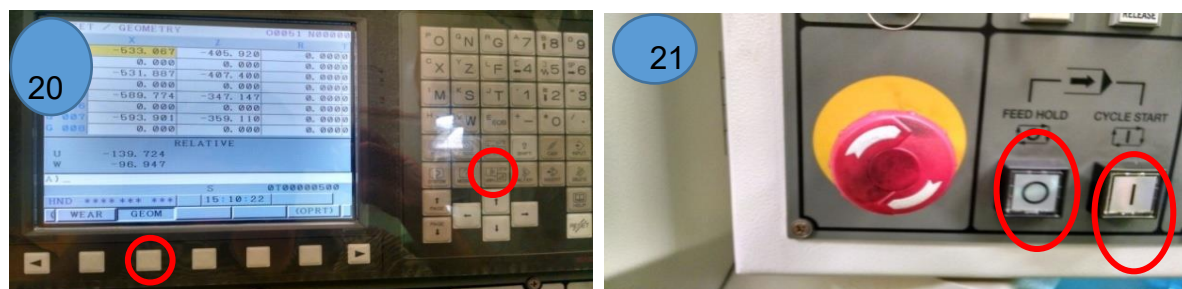
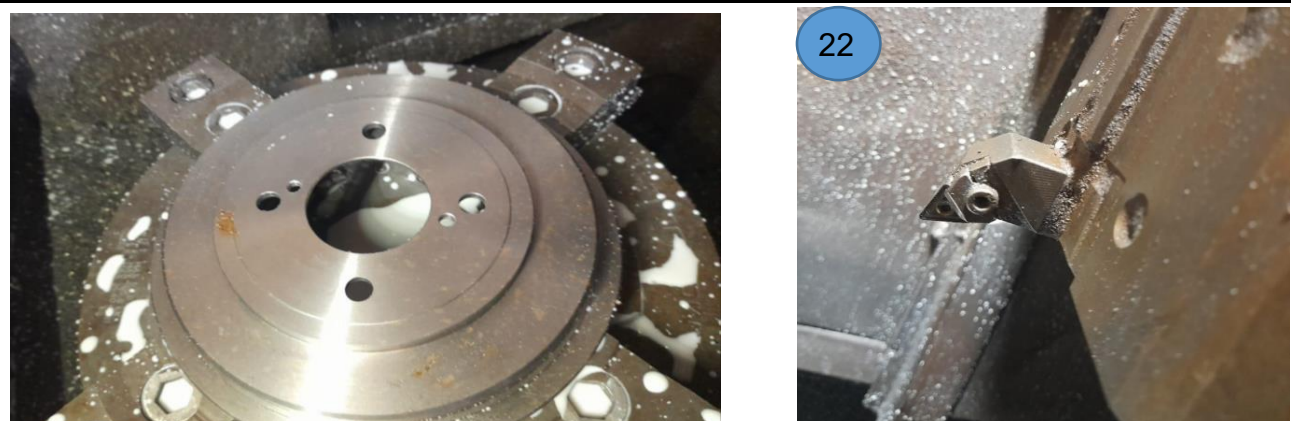
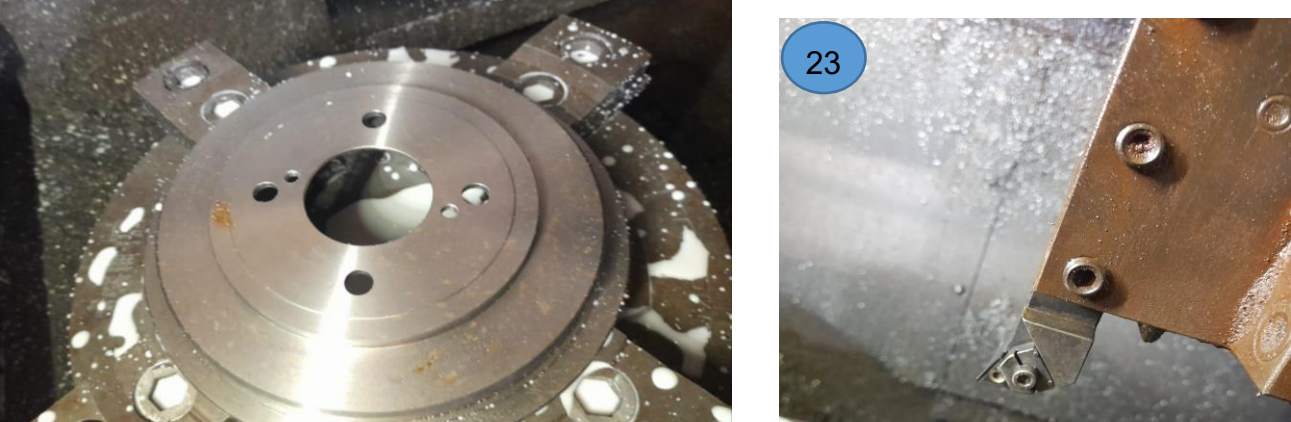


Manufacturing Operation Standard

Manufacturing Operation Standard				Preparing Department			Control No.	
Model		3AM		Confirmed by		Checked by	Prepared by	PP\FM\025 ISSUE 01 PAGE 5 of 17
PROCESS NAME		2nd Side CNC Machining with Drilling						
Job Setting								
		No.	OPERATION	QUALITY STANDARD	WORKING POINT	TOOL & MATERIAL	COMMENTS	SAFETY POINTS
		1	Main breaker ON & machine power on.	-	1- Rotate selector Red mark to Green mark. 2- Press Switch ON Button.	Selector & Button	If operator doesn't press button or move selector to its position then machine will no start.	Shoes, Gloves
		2	Machine Reference	Before starting machine make sure your axis in reference point.	Press Both X & Z axis button	X & Z Axis button & Selector	If operator starts machine without sending reference point then it can cause accidents of machine.	Shoes, Gloves
		3	Checking of Oil levels.	Check level gauge every day before starting machine.	Check oil level on level gauge.	Level Gauge.	If level gauge is below than its standard level then machine will be alarming & it can effect on your production.	Shoes, Gloves
		4	Set clamping Pressure.	Clamping pressure should be 10~14 Kg/cm2	Clamping Jaws.	Pressure gauge	Always set pressure gauge reading in between 10~14 kg/cm2, Lose clamping can cause rejection & accident on machine.	Shoes, Gloves
		5	Greasing	-	Grease with the help of greasing Gun	Greasing Gun	-	Shoes, Gloves
		6	Setting of Jaws	T slot seating area should be clean and free from Bur.	Tight all 4 jaws with the help of LN-key	LN-key	If bur found on T-slot area then jaws will not properly tight.	Shoes, Gloves
		7	Jaws cutting	When ever setup change make cut on jaws touching profile .	Cut jaws with the help of boring bar.	Boring Bar	If operator didn't make cut on jaws teeth's then Run out found on part.	Shoes, Gloves
		8	Checking of Tools & Inserts	Make sure all tools mount on Turret & don't damaged.	Mount all tools in turret with respect to 1st side machining.	Tools & Inserts.	-	Shoes, Gloves
		9	Drum clamping & its appearance.	Make sure Rib should be insert before start machining. Make sure jaws should be free from Bur & also Drum should be free from Bur, Dust or blow hole & CNC 1st Side operation should be done .	Before starting operation insert slot key with the help of slot Jig. Before clamping Drum on jaws clean jaws with the help of Air gun then place Drum and press right pedal. Visually check the appearance of Drum.	Air Gun Right Pedal	If bur found on Jaws then piece will not properly clamp & Run out found in Drum. If CNC 1st side operation didn't done on Drum then return it to back CNC 1st Side Operator	Shoes, Gloves
		10	Call program	Before start machining make sure Programed # (O0012) Drum 2nd Side' call on screen	Type program # & press Program search Button on screen.	Button	If operator call wrong program # then it can cause accidents in machine	Shoes, Gloves
		11	Mode Setting	Make sure mode set on X1 & Single block and optional block ON	set selector position on X1 & optional block & Single block ON then On cycle start button when tool is near to part then press free hold button to hold process & then press reset button & after pressing reset button manually touch tool with part with the help of Handle then go to offset & select geometry option, in geometry option select whose tool which is working in process then give '0' offset value in X & Z axis.	Selector & Button	If this process will not proper follow then it can cause accident in machine.	Shoes, Gloves
								
		12	N1 Rough Turning & Facing	After completing N1 process Inspect the part. make sure dimension should be 0.2~0.3mm up for final dimension.	Cycle start Button Press & Inspect the part with the help of Vernier Caliper & micrometer	Tool (WTXNL) Insert (TNMG 1.2) Instrument (Vernier Caliper & Micro Meter)	If sizes don't according to tolerance then repeat N1 process & give offset value & check again .	Shoes, Gloves
		13	N2 Finish Turning & Facing	After completing N2 process Inspect the part with reference to OPS document. Process & make sure dimension should be according to document. PP\FM\024 ISSUE 01 PAGE 5 of 15	Cycle start Button Press & Inspect the part with the help of Vernier Caliper Micro Meter.	Tool (WTXNR) Insert (TNMG 0.8) Instrument (Vernier Caliper & Micro Meter)	If sizes don't according to tolerance then repeat N2 process & give offset value & check again .	Shoes, Gloves

