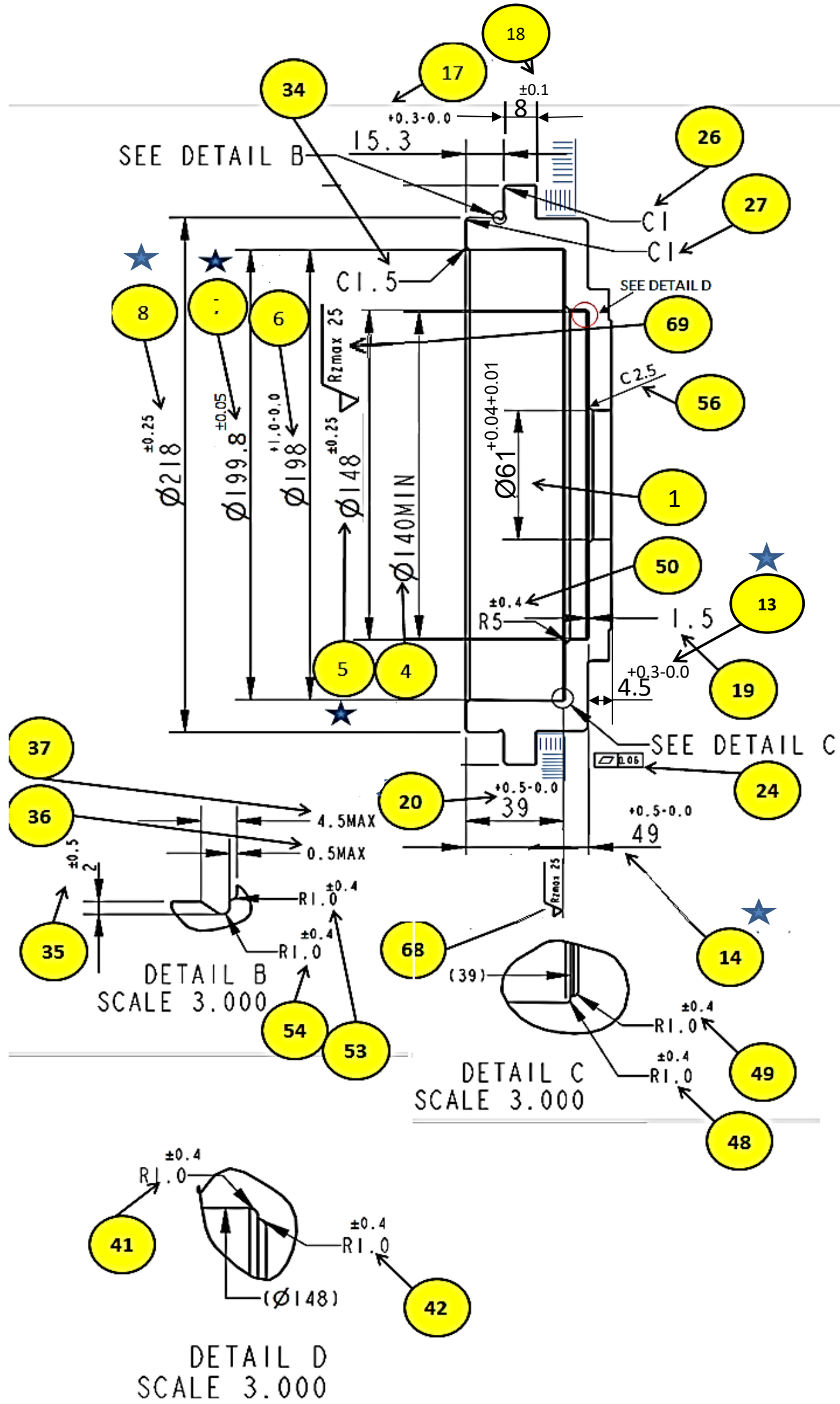


OPERATION STANDARD

PROCESS DRAWING

PPFM024
ISSUE 01
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APPEARANCE- Dent or Damage ,Bur, Rust , Blow Holes not Allowed

MACHINE NAME / No		CNC VERTICAL TURNING CENTER						
CUTTING OIL		WATER SOLUBLE Ratio (1:30)			ST		V	
No	CUTTING TOOL NAME	SPECIFICATION	ACTIVITY NAME	Qty	Insert per edge consumption	N (rpm)	(m/min)	f (mm/rev)
1	WTXNR (Rough)	(TNMG 1.2)	Outer Dia & Face	1	25 pieces/Edge	1500/350	-	0.3
2	SVVBM	(VBMT 0.8)	Final Outer Dia & Grove	1	25 pieces/Edge	1700/350	-	0.12
3	DCLNP	(CNMG 1.2)	Rough Boring & Facing	1	25 pieces/Edge	2000 G97	-	0.2
4	DCLNP	(CNMG 0.8)	Final Boring & Facing	1	15 pieces/Edge	1700 G97	-	0.12

JIGS & FIXTURES			
No	ITEM NAME	SPECIFICATION	ACTIVITY No.
1	4JAWS CHUCK	HYDRAULIC JIG	
2	Hydraulic Pressure Gauge	10-14 Bar	
3	Knife Vernier	0-250	
4	Vernier Caliper	0-300	
5	Depth Vernier Caliper	0-200	
6	Bore Gauge	200	

No	CHECK POINT	STANDARD	INSPECTION TOOL	INSPECTED BY OPERATOR	KTDMC REPORT QC-FRM- 06/00	INSPECTED BY QC INSPECTOR
-	APPEARANCE	Dent or Damage ,Bur, Rust , Blow Holes not Allowed	Visual / Pictorial Sheet (PD\FM\017)	100%	-	-
8	DIAMETER	Ø218 ^{+0.25}	Vernier Caliper/ (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
4	DIAMETER	Ø140 MIN	Knife Vernier Caliper/ (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
5	DIAMETER	Ø148 ^{+0.25}	Knife Vernier Caliper/ (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
-	DIAMETER (Before Honing)	Ø199.8 ^{+0.05}	Internal Micro Meter / (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
6	DIAMETER	Ø198.0 ^{+1.0-0.0}	Knife Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
20	DIMENSION (Height)	39 ^{+0.5-0.0}	Depth Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
17	DIMENSION (Height)	15.3 ^{+0.3-0.0}	Depth Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
14	DIMENSION (Height)	49 ^{+0.5-0.0}	Depth Vernier Caliper / (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
18	DIMENSION	8 ^{+0.1}	Micro Meter	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
36	DIMENSION (Height)	0.5 MAX	Check By Program /Height Gauge	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
37	DIMENSION (Height)	4.5 MAX	Check By Program /Height Gauge	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
35	DIMENSION (Height)	2 ^{+0.5}	Check by Program/Height Gauge	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
19	DIMENSION (Height)	1.5 ^{+0.2}	Depth Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
13	DIMENSION (THIKNESS)	4.5 ^{+0.3-0.0}	Micro Meter/(CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
1	DIMENSION (Rough Bore)	Ø61 ^{+0.04+0.01}	Inner Micro Meter/ Bore Gauge/(CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
41	RADIUS	R1.0 ^{+0.4}	Check by program/ 3DS/Master Piece	Every New Setting	Once in a Year	-
42	RADIUS	R1.0 ^{+0.4}	Check by program/ 3DS/Master Piece	Every New Setting	Once in a Year	-
48	RADIUS	R1.0 ^{+0.4}	Check by program/ 3DS/Master Piece	Every New Setting	Once in a Year	-
49	RADIUS	R1.0 ^{+0.4}	Check by program/ 3DS/Master Piece	Every New Setting	Once in a Year	-
54	RADIUS	R1.0 ^{+0.4}	Check by program/ 3DS/Master Piece	Every New Setting	Once in a Year	-
50	RADIUS	R5.0 ^{+0.4}	Check by program/ 3DS/Master Piece	Every New Setting	Once in a Year	-
53	RADIUS	R1.0 ^{+0.4}	Check by program/ 3DS/Master Piece	Every New Setting	Once in a Year	-
26	CHAMFER	C 1.0 ^{+0.2-0.0}	Bevel Protector+Height Gauge /Check By Program/ 3DS/ Master Piece	Every New Setting	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr
27	CHAMFER	C 1.0 ^{+0.2-0.0}	Bevel Protector + Height Gauge /Check By Program/ 3DS/ Master Piece	Every New Setting	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr
34	CHAMFER	C 1.5 ^{+0.2}	Bevel Protector+Height Gauge /Check By Program	Every New Setting	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr
56	CHAMFER	C 2.5 ^{+0.4-0.0}	Bevel protector+ Depth Micro Meter/ Master pieces	Every New Setting	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr
24	FLATNESS	0.06	Height Gauge + Lever Gauge/Checking Fixture	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
68	ROUGHNESS ON FACE 39 mm	RZmax 25	Check by Program /Roughness Tester	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
69	ROUGHNESS ON Ø148 FACE	RZmax 25	Check by Program/Roughness Tester	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr

	Legend Show Jaws Clamping & Part Resting		Legend Show Critical Dimension
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				PROCESS No	04	APPR by	CHKD by	CHKD by	DWG by	MATERIAL	FC220P
										PART NAME	DRUM REAR BRAKE (200 mm)
ISSUE	11-03-25	NEW WRITE	01							PART No	42610-3S6-T000
	D.M.Y	CORRECT REVISE REASON	ISSUE	PROCESS NAME	2nd SIDE CNC MACHINING					MODEL	3AM