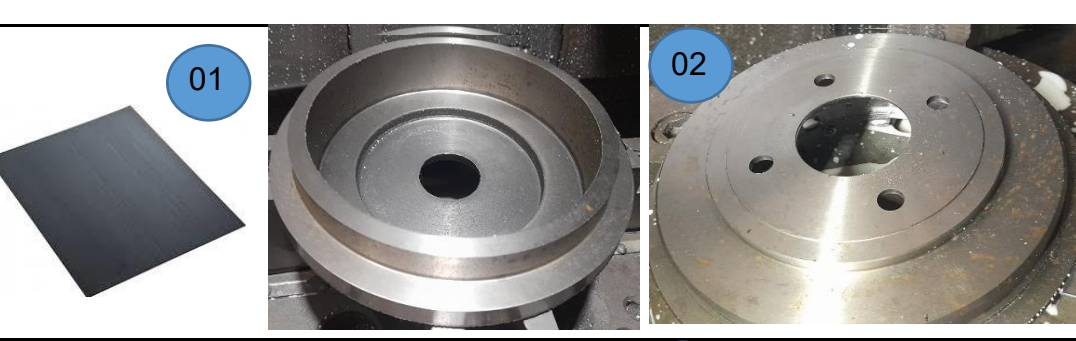
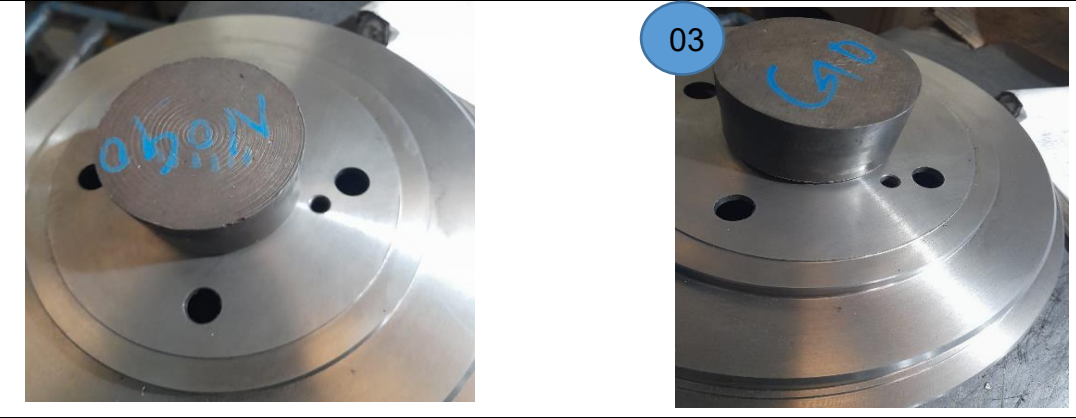
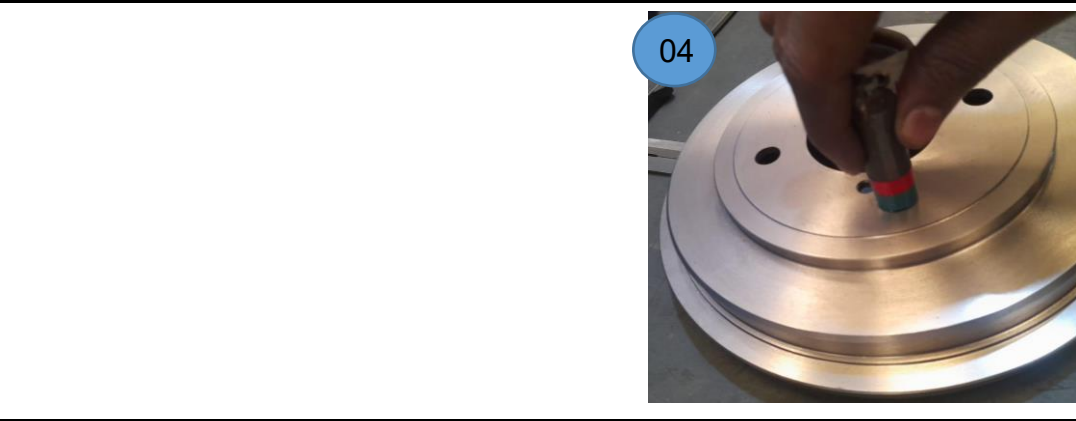
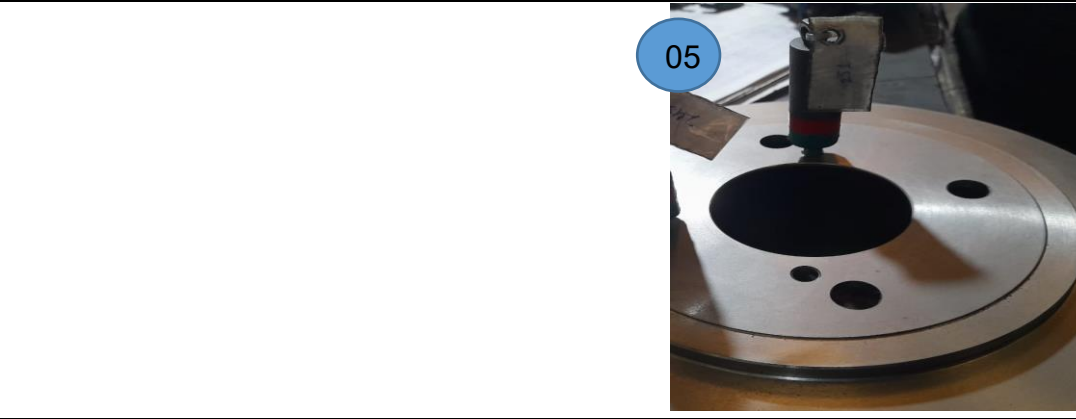
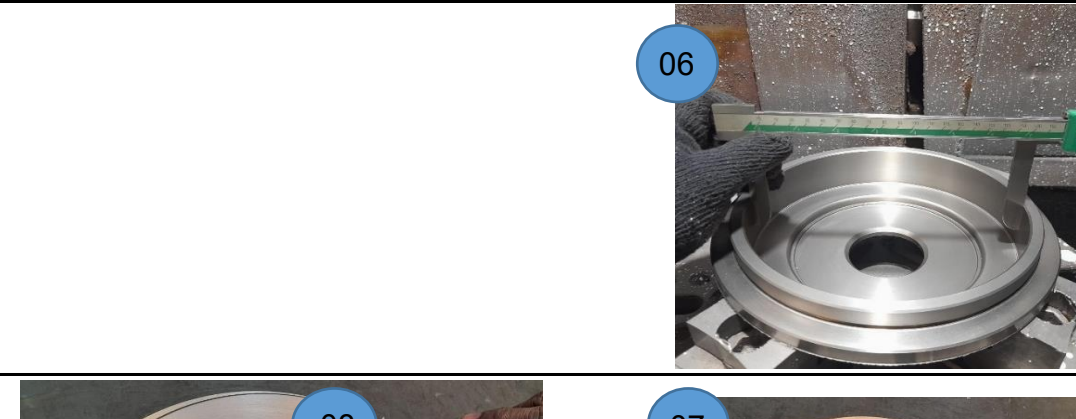
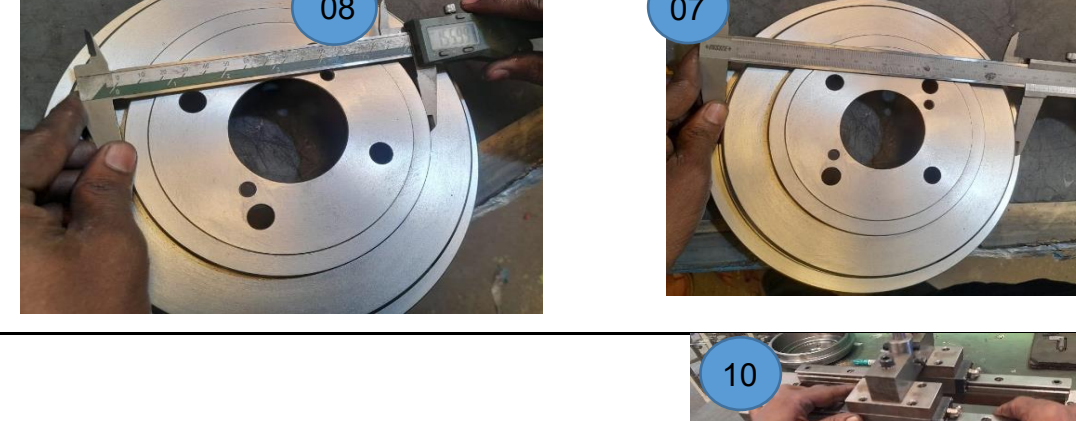
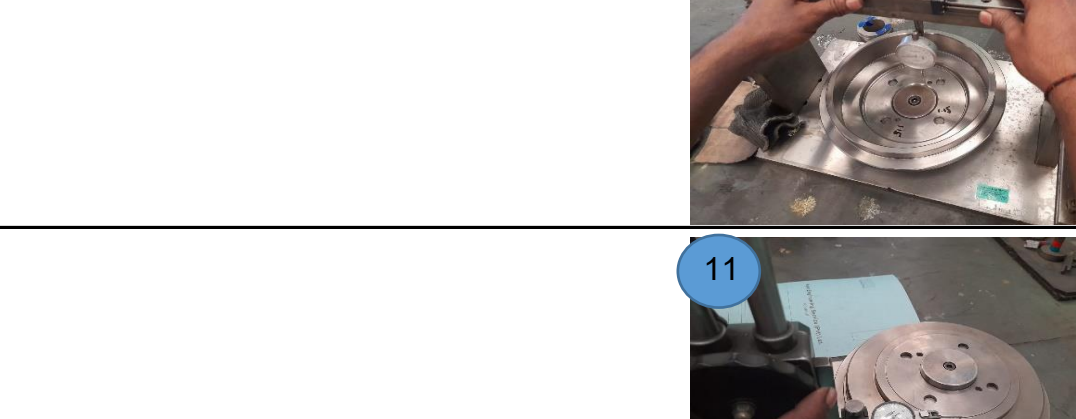
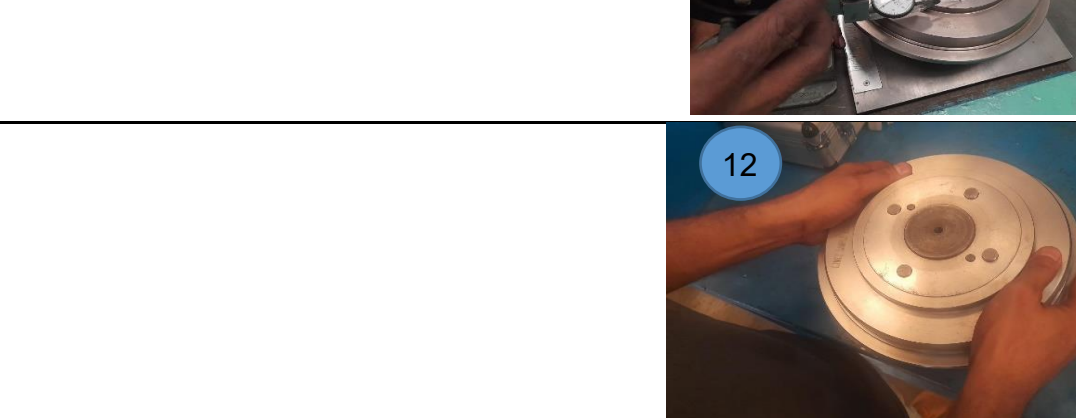
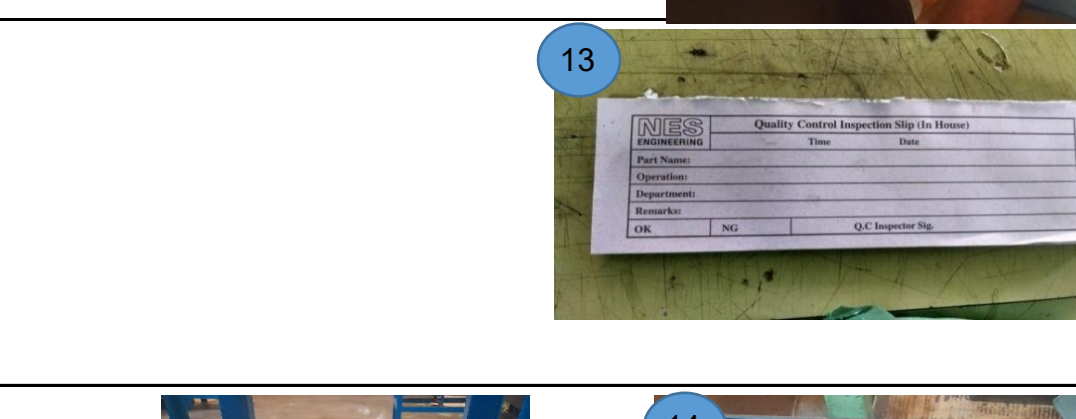


Manufacturing Operation Standard

Preparing Department		
Confirmed by	Checked by	Prepared by
		

Control No.
PP\FM\025 ISSUE 01 PAGE 09 of 17

Model	3AM	Process / Operation Name	Semi-Final Inspection
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	No.	Operation	Quality Standard	Working Point	Tool & Material	Comments	Safety Points
	1	Bur Remove & Appearance	Make sure at this stage all Previous Process must be done & also make sure Drum should be free from Bur & Dent. Empery Paper Grid (120)	Visually check Complete Drum.Bur Remove with Help of Empery Paper	Drum, Empery Paper (120)	If inspector found some missing in previous processes then give it back to its position.	Gloves, Shoes
	2	Check Ø61.0	GO & no Gauges Should be clean from Bur. Gauges Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	Inspection With Go & No-Go gauges.	Go & No-Go gauges.Ø61	If Go & No Go Gauge doesn't calibrated from QC then possibilities of rejection.	Gloves, Shoes
	3	Check 4-holes Ø12.5	GO & no Gauges Should be clean from Bur. Gauges Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	Inspection With Go & No Go gauges.	Go & No Go Gauge.Ø12.5	If Go & No Go Gauge doesn't calibrated from QC then possibilities of rejection.	Gloves, Shoes
	4	Check 2-holes Thread M8x1.25	GO & no Gauges Should be clean from Bur. Gauges Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	Inspection With Thread Go & No Go gauges.	Thread Go & No Go Gauge.M8x1.25	If Go & No Go Gauge doesn't calibrated from QC then possibilities of rejection.	Gloves, Shoes
	5	Check Diameter Ø148	Knife Vernier caliper Should be clean from Bur. Knife Vernier caliper Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	Inspection With Knife Vernier Caliper	Knife Vernier Caliper	If knife Vernier Caliper doesn't calibrated from QC then possibilities of rejection.	Gloves, Shoes
	6	Check Diameter Ø217 & Ø156	Vernier caliper Should be clean from Bur. Vernier caliper Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	Inspection With Vernier Caliper	Vernier Caliper	If Vernier Caliper doesn't calibrated from QC then possibilities of rejection.	Gloves, Shoes
	7	Check Flatness	Flatness C.F Should be clean from Bur. Flatness C.F Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	Flatness cheek now with the help C.fixture.	Flatness C.F	If fixture is NG then immediate inform to Supervisor.	Gloves, Shoes
	8	Check RUNOUT W SURF	RUNOUT W SURF Should be clean from Bur. RUNOUT W SURF Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	RUNOUT W SURF cheek now with the help C.fixture.	RUNOUT W SURF C.F	If fixture is NG then immediate inform to Supervisor.	Gloves, Shoes
	9	Check PCD	PCD C.F Should be clean from Bur. PCD C.F Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 01 PAGE 09 of 15	PCD C.F cheek now with the help C.fixture.	PCD C.F	If fixture is NG then immediate inform to Supervisor.	Gloves, Shoes
	10	QC inspection	Before starting production go to QC window and check 1st part & receive OK slip .	Go to QC Window	QC Slip	If part is NG then go and come until QC didn't give you OK slip.	Gloves, Shoes
	11	Storage & Handling Of Finish Part	Finish Drum set in Storage Location	Place the Drum properly in the Drum Trolley, so it doesn't hit or Damage ,collide with Other Drum.	Finish Drum , Storage Trolley	If Drum needs to repair then place into Repairing rack if reject then place into Rejection rack. And follow the OK ,Rej. & REPAIRING Treatment Flow as Mention Below	Gloves, Shoes

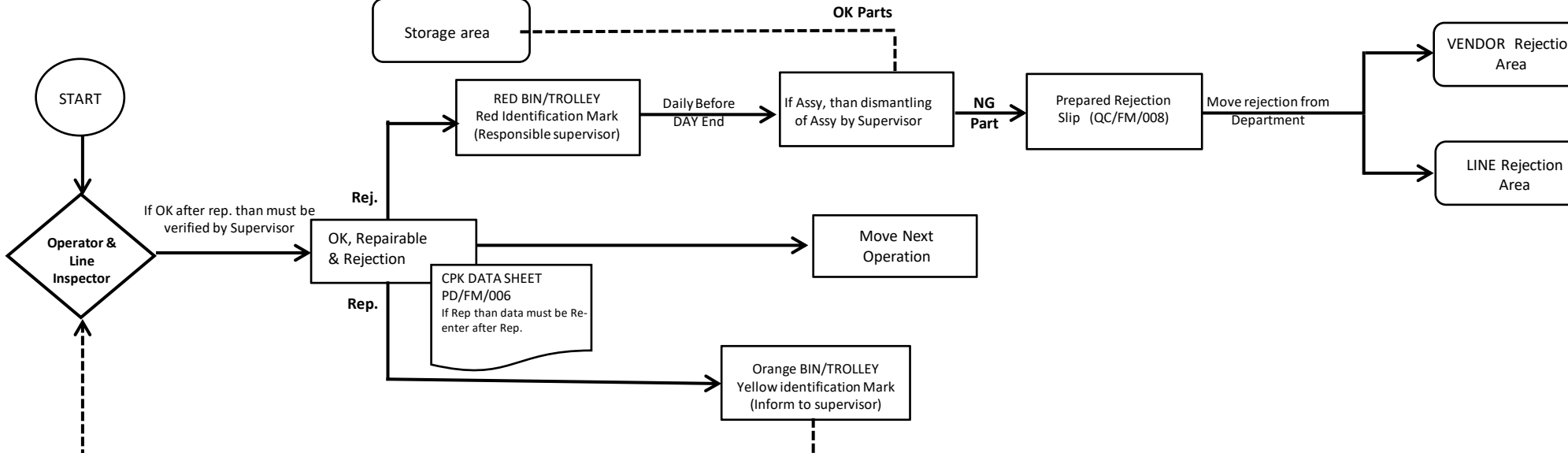
Day First Part Manufacturing

* For first part manufacturing Operator must follow these process: All process 1,2,3,4,5,6,7,8,9,10

Routine Part Manufacturing

* For Routine part manufacturing Operator must follow these process: 1,2,3,4,5,6,7,8,9

OK,REJ.& REPAIRING PART RULES & ROUTE



Designated Safety Wears					No.	Parts Number	Parts Name	QTY	Rank	Model											
					1	42610-3S6-T000	DRUM REAR BRAKE (200 mm)	1	HA	3AM											
Material					Torque Importance																
T	B	G	D	SS	R																
Torque	Bond	Grease	Oil	Scap	Anti Rust	Class A	Class B	Class C													
											Issue			20-1-2025		New Issue					
											Date		Revision Contents				Check		Confirm		

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