

PP\FM\024
ISSUE 01
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Technical drawing of a mechanical part, showing front and top views with dimensions and callouts.

Front View Dimensions:

- Overall width: ± 0.05 $\varnothing 199.8$
- Inner diameter: ± 0.25 $\varnothing 148$
- Inner diameter: $\pm 0.04 \pm 0.01$ $\varnothing 61.67$
- Inner diameter: ± 0.25 $\varnothing 156$
- Outer diameter: ± 0.25 $\varnothing 217$
- Top flange width: $\pm 0.5 \pm 0.6$ 39.5
- Bottom flange width: 49.5

Top View Dimensions:

- Outer diameter: $\pm 0.17^\circ$ 90°
- Inner diameter: ± 0.1 $4 - \varnothing 12.5$
- Inner diameter: $\pm 0.4 \pm 0.0$ 15°
- Inner diameter: ± 0.25 $2 - M8 \times 1.25$
- Inner diameter: ± 0.25 $P.D. 79$
- Inner diameter: ± 0.1 $P.D. 100$

Callouts:

- 1: Top flange
- 5: Inner diameter
- 12: Inner diameter
- 11: Inner diameter
- 20: Bottom flange
- 57: Outer diameter
- 55: Inner diameter
- 58: Inner diameter
- 65: Inner diameter
- 66: Inner diameter
- 67: Outer diameter
- 68: Note
- 24: Note

NOTE:

- RUNOUT W SURF $\nearrow 0.1$ A-C
- FLATNESS $\square 0.06$

APPEARANCE- Dent or Damage ,Bur, Rust ,Blow Hole not Allowed

MACHINE NAME / No		-					
CUTTING OIL		-			ST		
No	CUTTING TOOL NAME	SPECIFICATION	ACTIVITY NAME	Qty	N (rpm)	V (m/min)	f (mm/rev)
JIGS & FIXTURES							
No	ITEM NAME	SPECIFICATION				ACTIVITY No.	
1	Runout Fixture						
2	PCD CHK. Fixture						
3	Height Gauge						
4	M8x1.25 Go&No Go Gauge						
5	Ø12.5 Go No-go Gauge						
6	Internal Micro Meter						
7	Vernier Caliper						
8	Knife Vernier Caliper						
9	Ø61 Go No-go Gauge						
10	Flatness Fixture						
No	CHECK POINT	STANDARD	INSPECTION TOOL	INSPECTED BY LINE INSPECTOR	KTDMC REPORT QC-FRM- 06/00	INSPECTED BY QC INSPECTOR	
-	APPEARANCE	Dent or Damage ,Burr, Rust ,Blow Hole not Allowed	Visual / Pictorial Sheet (PD\FM\017)	100%	-	-	
55	4-HOLES DRILLING	Ø12.5 ^{+0.4-0.0}	Vernier Caliper/Go/No-go Gauge	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
67	4-HOLES P.D. Ø12.5	Ø100 ^{±0.1}	Checking Fixture / Master piece	100%	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr	
11	DIAMETER	Ø156.0 ^{±0.25}	Vernier Caliper	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
66	P.D. M8	79 ^{±0.25}	Checking Fixture / Master piece	100%	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr	
12	DIAMETER	Ø217.0 ^{±0.25}	Vernier Caliper	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
5	DIAMETER	Ø148 ^{±0.25}	Knife Vernier Caliper	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
1	BORING DIA	Ø61G7 ^{+0.04+0.01}	Internal Micro Meter/Go&No-Go Gauge	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
24	★ FLATNESS	▭ 0.06	Dial gauge With Stand +C.F/(CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
68	★ RUNOUT W SURF	↗ 0.1 A-C	Checking Fixture /(CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
65	★ Thread	2-M8 X 1.25	Thread Plug Go/NO-Go Gauge /(CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
58	ANGLE	15° ±2°	Checking Fixture / Master piece	100%	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr	
57	ANGLE	90° ± 0.17°	Checking Fixture / Master piece	100%	Once in a Year	5 Pcs/Shift 1 Pcs / 1.5 Hr	
13	★ DIMENSION (Height)	49.5 ^{+0.5-0.0}	Height Gauge /(CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
20	DIMENSION (Height)	39 ^{+0.5-0.0}	Height Gauge	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
-	DIAMETER (Before Honing)	Ø199.8 ^{±0.05}	Go & No Go Gauge	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
 Legend Show Jaws Clamping & Part Resting  Legend Show Critical Dimension							

Legend Show Jaws Clamping & Part Resting

 **Legend Show Critical Dimension**

MATERIAL	FC220P
PART NAME	DRUM REAR BRAKE (200 mm)
PART No	42610-3S6-T000
MODEL	3AM