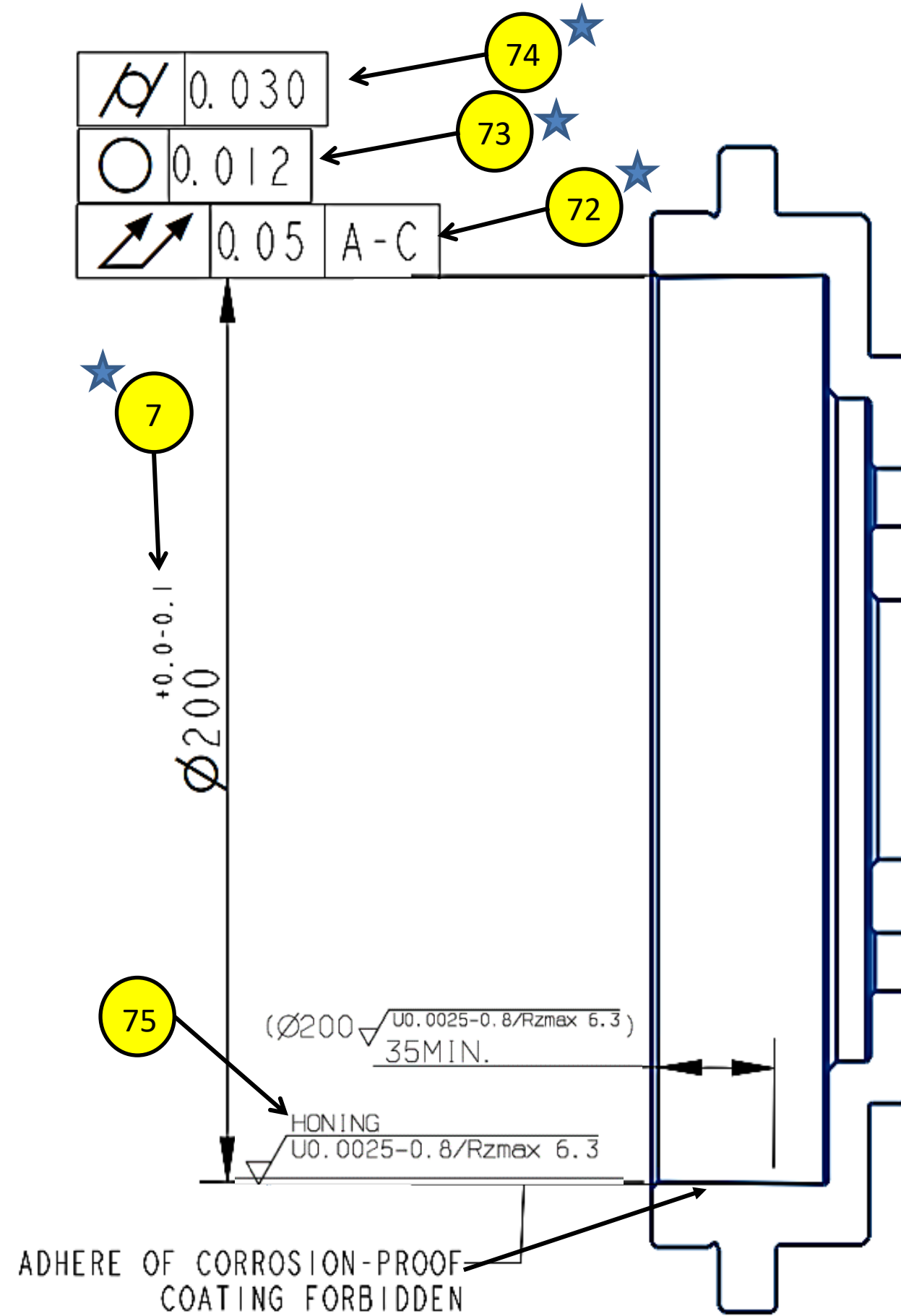


OPERATION STANDARD

PROCESS DRAWING



NOTE:

8) CONCAVE OF CARBON HOLE ABOUT UPPER AREA OF HONING SURFACE CAN BE EXCLUDED FROM SURFACE ROUGHNESS MEASUREMENT.

9) C SURF, W SURF, AND $\phi 200$ INNER DIA. SHALL BE FREE FROM DENT SPOTS.

1* After Dressing Cut on Grinding Wheel Drum Roughness Should Be Verify From QC and Roughness Should be As Per Drawing Standard

APPEARANCE- Dent or Damage ,Bur, Rust ,Blow Hole , on marking area Blur and Disappearing not Allowed

3				PROCESS No	14	APPR by	CHKD by	CHKD by	DWG by
2									
1									
ISSUE	11-03-25	NEW WRITE	01	PROCESS NAME	HONING				
	D.M.Y	CORRECT REVISE REASON	ISSUE						

MACHINE NAME / No		CNC VERTICAL TURNING CENTER						
CUTTING OIL		-				ST		
No	CUTTING TOOL NAME	SPECIFICATION	ACTIVITY NAME	Qty	Grinding Dressing consumption	N (rpm)	V (m/min)	f (mm/rev)
1	Grinding Wheel	Fine Grade NO# 120	Honing	1	20pieces or Roughness Up So Cut 0.1~0.2	3450/2300	-	700
2	Grinding Wheel	Ø150	Honing	1				
JIGS & FIXTURES								
No	ITEM NAME	SPECIFICATION					ACTIVITY No.	
1	Internal Micro Meter							
2	Bore Gauge							
3	Run Out Checking Fixture							
4	Roundness Checking Fixture							
No	CHECK POINT	STANDARD	INSPECTION TOOL		INSPECTED BY OPERATOR	INSPECTED BY LINE INSPECTOR	INSPECTED BY QC INSPECTOR	
-	APPEARANCE	Dent or Damage ,Burr, Rust ,Blow Hole , on marking area Blur and Disappearing not Allowed	Visual / Pictorial Sheet (PD\FM\017)		100%	-	-	
7	DIAMETER	ø200 ^{+0.0-0.1}	Internal Micro Meter / Bore Gauge		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
75	ROUGHNESS Face After Honing	Rzmax 6.3	Roughness Tester		Every New Setting/ Every After 5 pieces	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
74	Cylindricity	 0.030	Checking Fixture		Every New Setting/ Every After 5 pieces	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
73	Roundness	 0.012	Checking Fixture		Every New Setting/ Every After 5 pieces	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
72	RUNOUT WITH REFERENCE TO A	 0.05 A-C	Checking Fixture		Every New Setting/ Every After 5 pieces	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
 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						