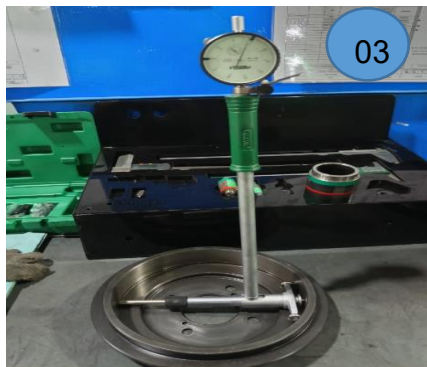
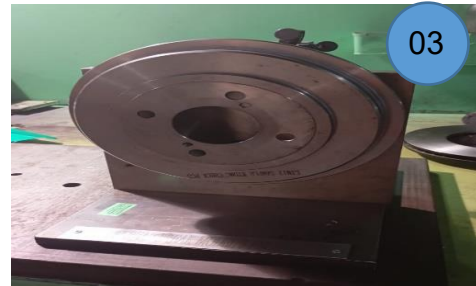
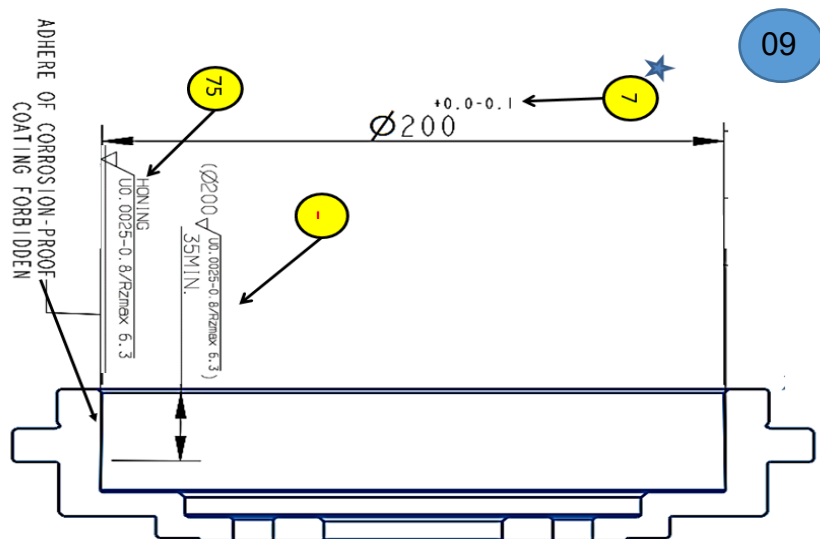
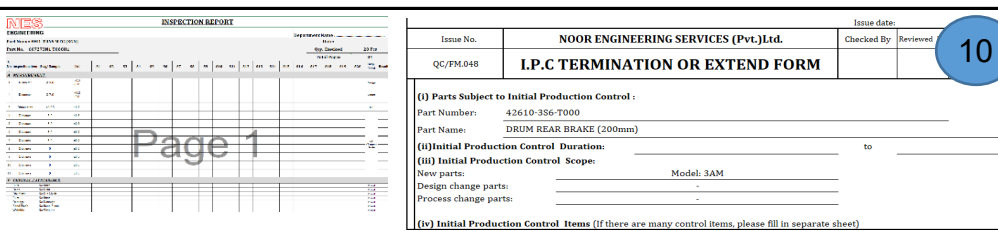


Manufacturing Operation Standard

Manufacturing Operation Standard				Preparing Department			Control No.	
Model		3AM		Process / Operation Name	Final Inspection		PP\FM\025 ISSUE 01 PAGE 15of17	
PICTORIAL VIEW		No.	Operation	Quality Standard	Working Point	Tool & Material	Comments	Safety Points
 		1	Appearance	Make sure at this stage all previous process must be done & also make sure Drum should be free from Bur & Dent.	Visually check completely	Drum	If inspector found some missing in previous processes then give it back to its position.	Gloves, Shoes
		2	Check the Diameter 200mm	Surface should be clean where Bore gauge is move Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 15 of 15	Rest a Drum on smooth Surface and Check The Part Bore gauge and check reading on it.	Bore Gauge	If Bore Gauge Damane Or NG then immediate inform to Supervisor.and Stop Process	Gloves, Shoes
 		3	Check Cylindricity  fixture	Make sure checking fixture Should be Calibrated & Tagged from QC. No bur or Dust on Fixture.Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 15 of 15	After mounting Drum on fixture check Cylindricity with the help of moving slides & note reading from dial gauge.	Cylindricity Checking Fixture	If fixture is NG then immediate inform to Supervisor.and Stop Process	Gloves, Shoes
 		4	Check Roundness  On Same fixture	Make sure checking fixture Should be Calibrated & Tagged from QC. No bur or Dust on Fixture. Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 15 of 15	After mounting Drum on fixture check Circularity with the help of moving slides & note reading from dial gauge.	Circularity Checking Fixture	If fixture is NG then immediate inform to Supervisor.and Stop Process	Gloves, Shoes
 		5	Check Runout  of Drum	Make sure checking fixture Should be Calibrated & Tagged from QC. No bur or Dust on Fixture. Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 15 of 15	After mounting Drum on fixture check Runout of Drum with the help of lever gauge.	Runout Checking Fixture & Lever Gauge	If fixture & Lever gauge is NG then immediate inform to Supervisor.and Stop Process	Gloves, Shoes
		6	Check Roughness of Drum	Frequency of Roughness Every New Setting / Every After 5 piece	Check Roughness from QC Department Every New Setting and Every After 5 piece	Drum & QC Department & Roughness Tester	Quality check Every 5 Pcs/Shift 1 Pcs / 1.5 Hr and record data	Gloves, Shoes
		7	Check Honing Depth 35 mm MIN	Check With Drum Help of Depth Vernier Caliper PP\FM\024 ISSUE 01 PAGE 15 of 15	Check With Drum Help of Depth Vernier Caliper Every New Setting / Every After 5 pieces	Drum , Depth Vernier Caliper	if not Achieved the 35 mm Dimension so Checked Program Parameter & 0 height of Tool In Z Axis	Gloves, Shoes
		8	I.P.C TERMINATION OR EXTEND FORM	100% Checked Dimensions from INSPECTION REPORT	After Checked 100% Form Dimensions and part mark with Yellow Marker	INSPECTION REPORT Format	If any problem found during IPC Period so I.P.C TERMINATION EXTEND FOR Next 3 Months	Gloves, Shoes
		9	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
		10	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

