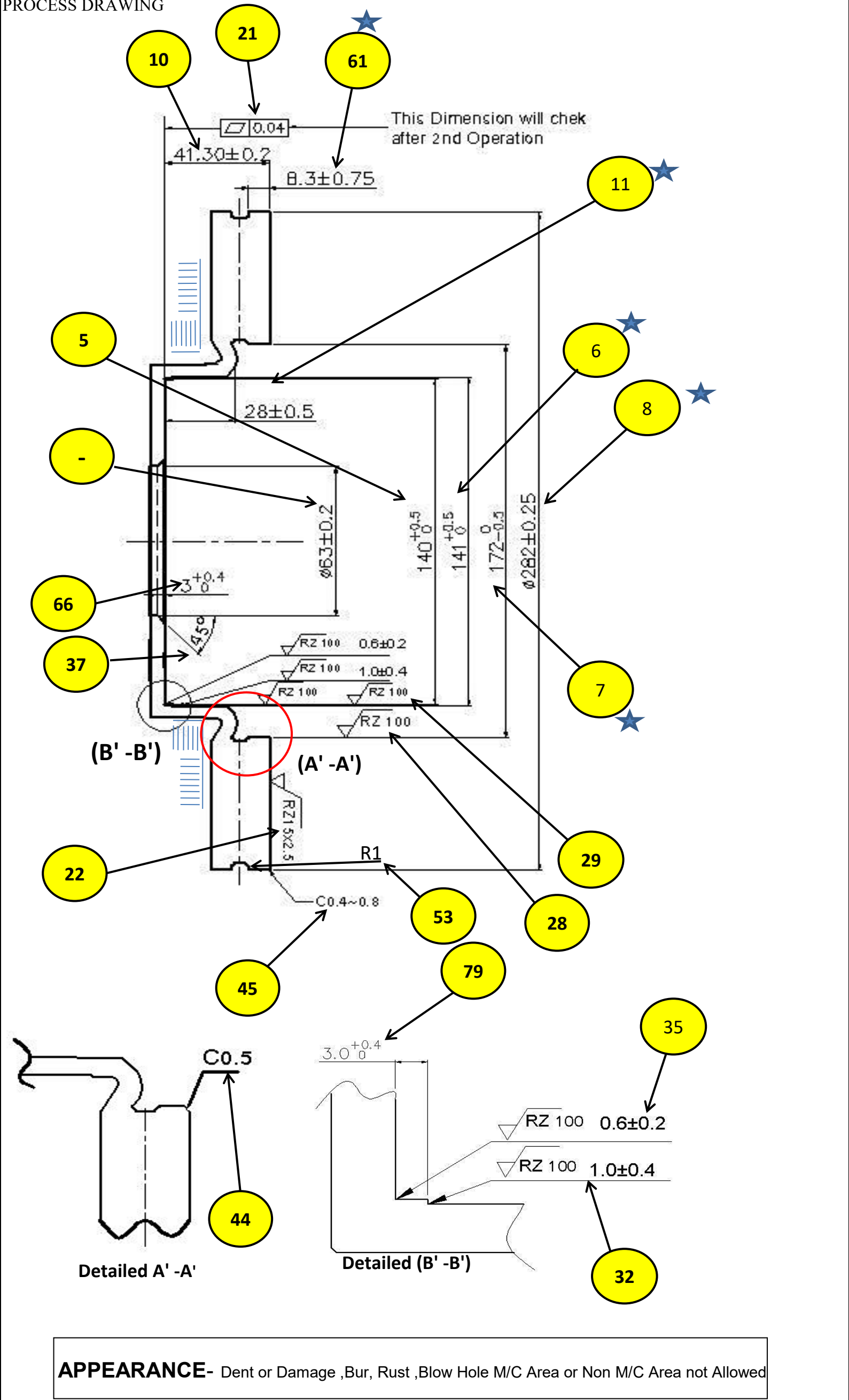


OPERATION STANDARD

PROCESS DRAWING



MACHINE NAME / No		CNC VERTICAL TURNING CENTER						
CUTTING OIL		WATER SOLUBLE Ratio (1:30)				ST		
No	CUTTING TOOL NAME	SPECIFICATION	ACTIVITY NAME	Qty	Insert per edge consumption	N (rpm)	V (m/min)	f (mm/rev)
1	WTXNR (Rough)	(TNMG 0.8)	Outer Dia & Face	1	25 pieces/Edge	3000/280	-	0.15
2	DCLNP	(CNMG 0.8)	Rough Boring & Facing	1	25 pieces/Edge	3000/280	-	0.13
3	DCLNP	(CNMG 0.8)	Final Boring & Facing	1	15 pieces/Edge	2000/250	-	0.15
JIGS & FIXTURES								
No	ITEM NAME	SPECIFICATION					ACTIVITY No.	
1	4 JAWS CHUCK	HYDRAULIC JIG						
2	Hydraulic Pressure Gauge	20–22 Bar						
No	CHECK POINT	STANDARD	INSPECTION TOOL		INSPECTED BY OPERATOR	INSPECTED BY LINE INSPECTOR	INSPECTED BY QC INSPECTOR	
-	APPEARANCE	Dent or Damage ,Bur, Rust ,Blow Hole M/C Area or Non M/C Area not Allowed	-		100%	-	-	
8	★ DIAMETER	ø282.0 ±0.25	Vernier Caliper/ (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
7	★ DIAMETER	ø172.0 +0.0-0.5	Knife Vernier Caliper/(CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
-	DIMENSION (Rough Bore)	ø63 ±0.2	Vernier Caliper		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
11	★ DIMENSION (Height)	28.0 ±0.5	Depth Vernier Caliper/ (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
21	FLATNESS	0.04	Height Gauge +Lever Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
10	DIMENSION (Height)	41.30 ±0.2	Depth Vernier Caliper		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
66	DIMENSION (Height)	3.0 +0.4-0.0	Depth Vernier Caliper		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
79	DIMENSION (Height)	3.0 +0.4-0.0	Check By Program		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
61	★ WALL THICKNESS "Y"	8.3 ±0.75	Vernier Caliper (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
35	RADIUS	R0.6 ±0.2	Check By Program		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
6	★ DIAMETER	ø141.0 +0.5-0.0	Knife Vernier Caliper/ (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
5	DIAMETER	ø140.0 +0.5-0.0	Knife Vernier Caliper		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
53	RADIUS	R1.0	Radius Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
29	ROUGHNESS ON Φ 141	RZ100 X 8.0	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
28	ROUGHNESS ON Φ 172	RZ100 X 2.5	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
44	CHAMFER	C-0.5	Bevel Protector		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
45	CHAMFER "Y"	C0.4~0.8	Bevel Protector		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
37	ANGLE	45° ±1°30'	Bevel Protector		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
32	RADIUS	R 1.0 ±0.4	Radius Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
22	ROUGHNESS Y Face before Burnishing	Rz15 X 2.5	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
 Legend Show Jaws Clamping  Legend Show Critical Dimension								

3				PROCESS No	04	APPR by	CHKD by	CHKD by	DWG by
2									
1									
ISSUE	02-11-22	NEW WRITE	01	PROCESS NAME	CNC 1st SIDE MACHINING				
	D.M.Y	CORRECT REVERSE REASON	ISSUE						

MATERIAL	FC220P		
PARTS NAME	DISK FR BRAKE (15" 23T)		
PARTS No	45251-TEA-T100-H1		
MODEL	2YN		