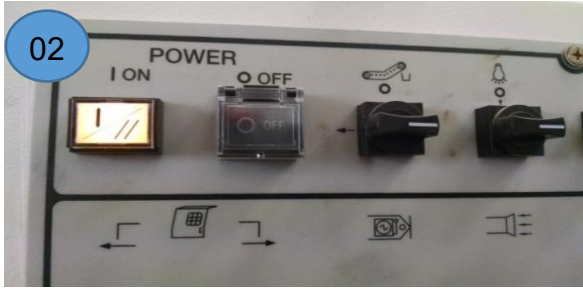
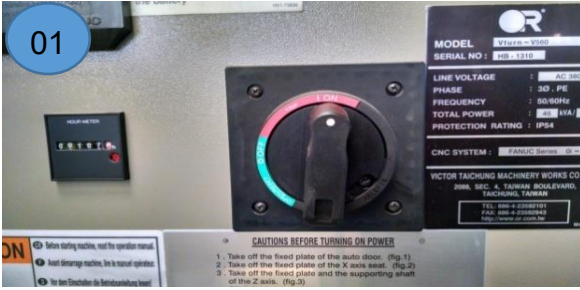
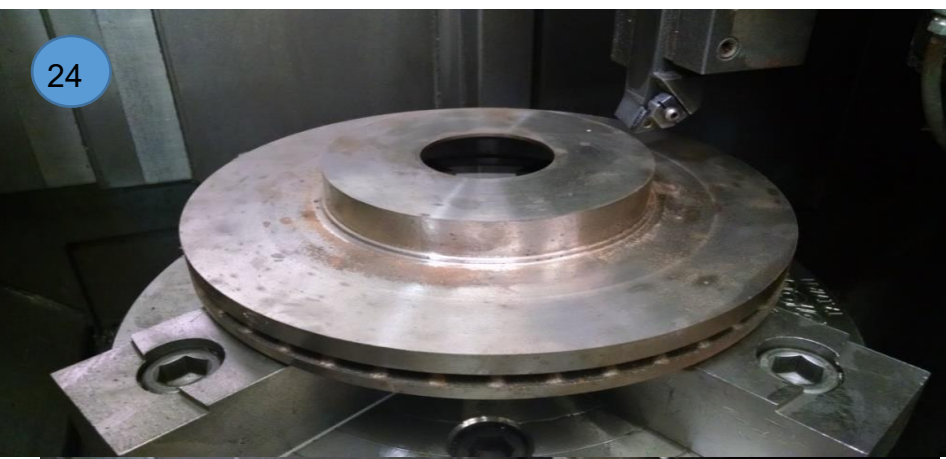
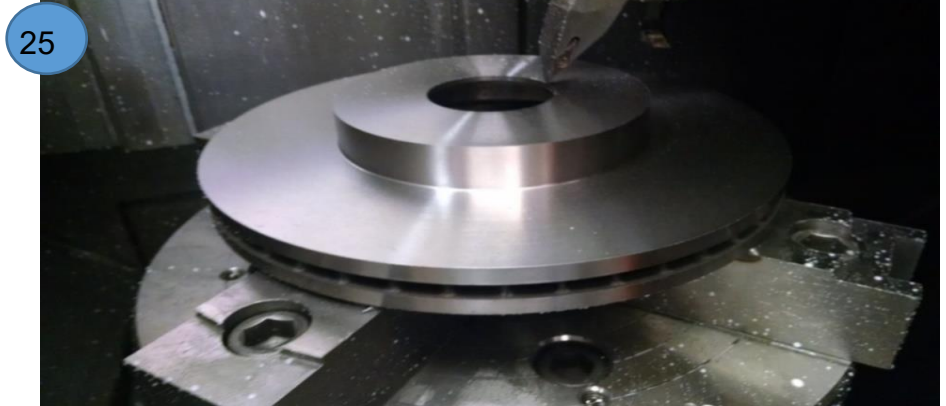


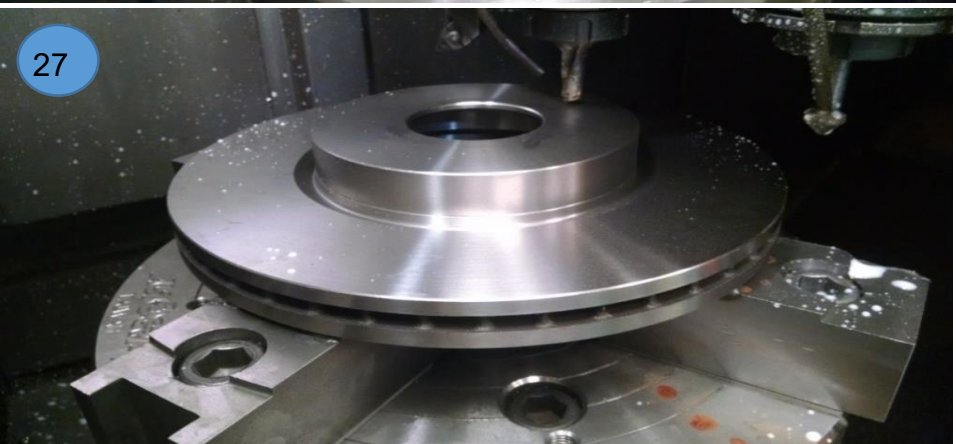
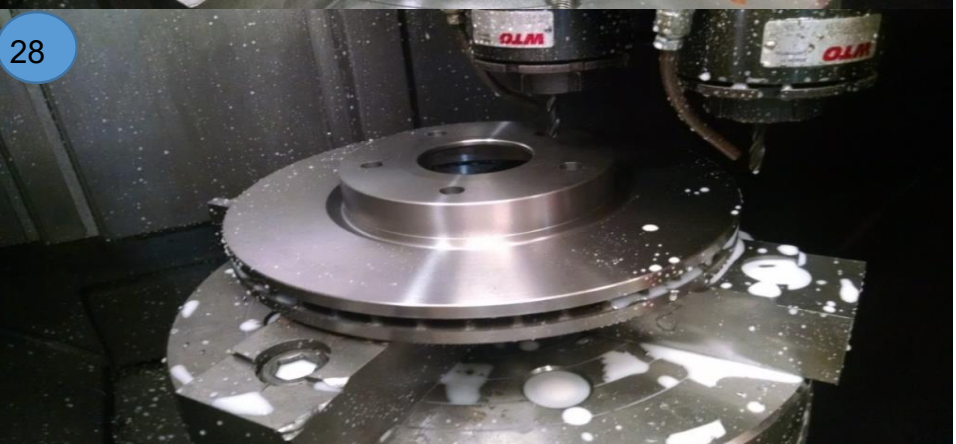
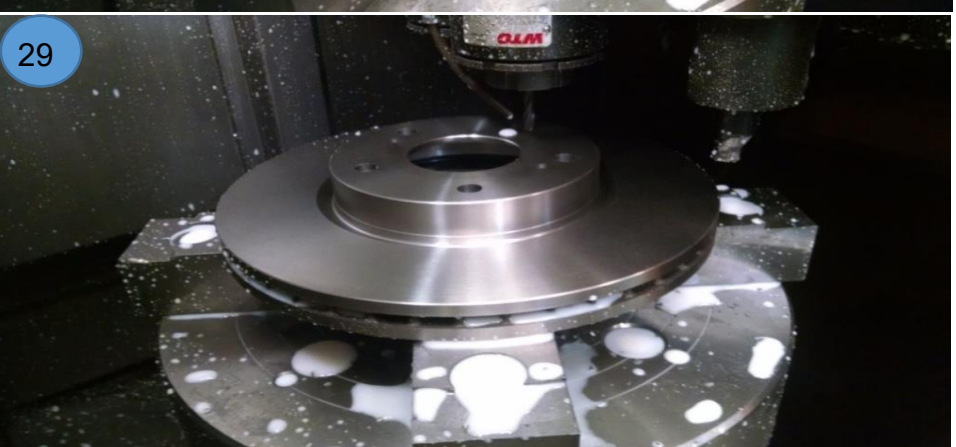
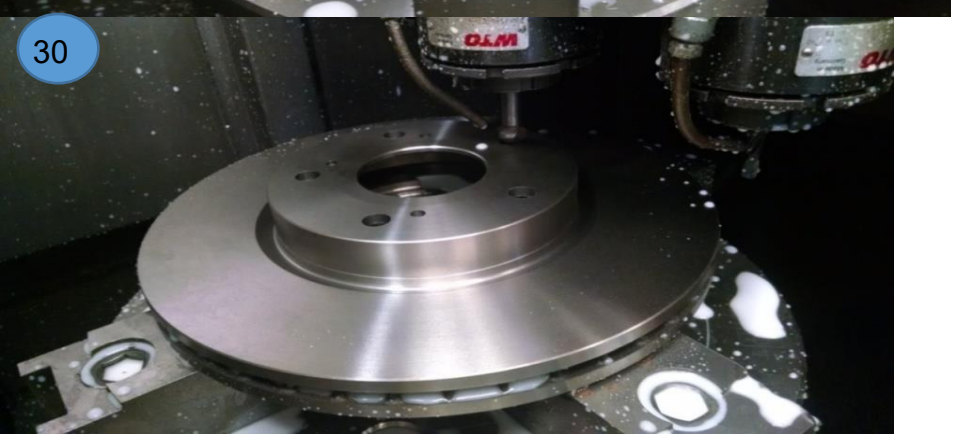
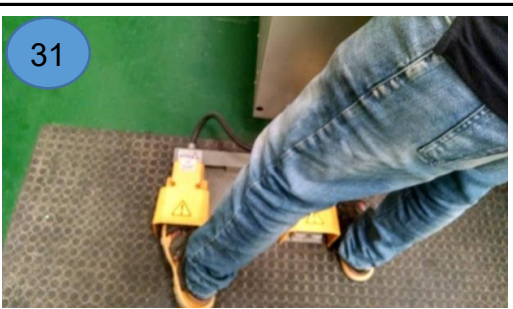
Manufacturing Operation Standard

Model	2YN	PROCESS NAME	CNC 2nd SIDE MACHINING WITH 08 HOLES DRILLING & 01 HOLE COUNTER
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Preparing Department			Control No.
Confirmed by	Checked by	Prepared by	PP\FM\025 ISSUE 01 PAGE 5of17

Job Setting

	No.	OPERATION	QUALITY STANDARD	WORKING POINT	TOOL & MATERIAL	COMMENTS	SAFETY POINTS
 	1	Main breaker ON & machine power on.	-	1- Rotate selector Red mark to Green mark. 2- Press Switch ON Button.	Selector & Button	If operator doesn't press button or move selector to its position then machine will no start.	Shoes, Gloves
 	2	Machine Reference	Before starting machine make sure your axis in reference point.	Press Both X & Z axis button	X & Z Axis button & Selector	If operator starts machine without sending reference point then it can cause accidents of machine.	Shoes, Gloves
 	3	Checking of Oil levels.	Check level gauge every day before starting machine.	Check oil level on gauge.	Level Gauge.	If level gauge is below than its standard level then machine will be alarming & it can effect on your production.	Shoes, Gloves
	4	Set clamping Pressure.	Clamping pressure should be 15~20 Kg/cm2	Clamping Jaws.	Pressure gauge	Always set pressure gauge reading in between 15~20 kg/cm2, Lose clamping can cause rejection & accident on machine.	Shoes, Gloves
	5	Greasing	-	Grease with the help of greasing Gun	Greasing Gun	-	Shoes, Gloves
 	6	Setting of Jaws	T slot seating area should be clean and free from Bur.	Tight all 4 jaws with the help of LN-key	LN-key	If bur found on T-slot area then jaws will not properly tight.	Shoes, Gloves
 	7	Jaws cutting	When ever setup change make cut on jaws touching profile .	Cut jaws with the help of boring bar.	Boring Bar	If operator didn't make cut on jaws teeth's then Run out found on part.	Shoes, Gloves
 	8	Checking of Tools & Inserts	Make sure all tools mount on Turret & don't damaged.	Mount all tools in turret with respect to 1st side machining.	Tools & Inserts.	-	Shoes, Gloves
   	9	Disk clamping & its appearance.	Make sure Rib should be insert before start machining. Make sure jaws should be free from Bur & also Disk should be free from Bur, Dust or blow hole & CNC 1st Side operation should be done .	Before starting operation insert slot key with the help of slot Jig. Before clamping disk on jaws clean jaws with the help of Air gun then place disk and press right pedal. Visually check the appearance of disk.	Air Gun Right Pedal	If bur found on Jaws then piece will not properly clamp & Run out found in disk. If CNC 1st side operation didn't done on disk then return it to back CNC 1st Side Operator	Shoes, Gloves
	10	Call program	Before start machining make sure Programed # (O016) Disk 2nd Side call on screen	Type program # & press Program search Button on screen.	Button	If operator call wrong program # then it can cause accidents in machine	Shoes, Gloves
 	11	Mode Setting	Make sure mode set on X1 & Single block and optional block ON	set selector position on X1 & optional block & Single block ON then On cycle start button when tool is near to part then press free hold button to hold process & then press reset button & after pressing reset button manually touch tool with part with the help of Handle then go to offset & select geometry option, in geometry option select whose tool which is working in process then give '0' offset value in X & Z axis.	Selector & Button	If this process will not proper follow then it can cause accident in machine.	Shoes, Gloves
 							
	12	N1 Rough Facing & Outer Dia Turning	After completing N1 process Inspect the part. make sure dimension should be 0.2~0.3mm up for final dimension.	Cycle start Button Press & Inspect the part with the help of Vernier Caliper & micrometer	Tool (WTXNR) Insert (TNMG 0.8) Instrument (Vernier Caliper & Micro Meter)	If sizes don't according to tolerance then repeat N1 process & give offset value & check again .	Shoes, Gloves
	13	N2 Finish Facing & Outer Dia Turning	After completing N2 process Inspect the part with reference to OPS document. Process & make sure dimension should be according to document. PP\FM\024 ISSUE 01 PAGE 5of17	Cycle start Button Press & Inspect the part with the help of Vernier Caliper Micro Meter.	Tool (SVVBM) Insert (VBMT 0.8) Instrument (Vernier Caliper & Micro Meter)	If sizes don't according to tolerance then repeat N2 process & give offset value & check again .	Shoes, Gloves

	No.	OPERATION	QUALITY STANDARD	WORKING POINT	TOOL & MATERIAL	COMMENTS	SAFETY POINTS
	14	N3 Inner Dia Turning	After completing N3 process Inspect the part with reference to OPS document. Process & make sure this dimension should be according to this document. PP\FM\024 ISSUE 01 PAGE 5of17	Cycle start Button Press & Inspect the part with the help of Vernier Caliper & Plug gauge	Tool (SDUCR) Insert (DCMT 0.8) Instrument (Vernier Caliper & Plug gauge)	If sizes don't according to tolerance then repeat N3 process & give offset value & check again .	Shoes, Gloves
	15	N4 Drilling ø12.5	Drilling Parameter Will Be set on Reject (NG) Part. After completing N4 process Inspect the part with reference to OPS document. Process & make sure dimension should be according to document. PP\FM\024 ISSUE 01 PAGE 5of17	During Setting Of Diameter of Hole Size and Holes PCD Operator Must Used Rejected (NG) Part for Setting. And Press Cycle start Button After Completing Process then Inspect the part with the help of Vernier Caliper & Plug Gauge.	Tool (Drill 12.5) Insert (GCMT 0.4) Instrument (Vernier Caliper & Plug Gauge)	If sizes don't according to tolerance then repeat N4 process & give offset value & check again .	Shoes, Gloves
	16	N5 Drilling ø6.7	Drilling Parameter Will Be set on Reject (NG) Part. After completing N5 process Inspect the part with reference to OPS document. Process & make sure dimension should be according to document. PP\FM\024 ISSUE 01 PAGE 5of17	During Setting Of Diameter of Hole Size and Holes PCD Operator Must Used Rejected (NG) Part for Setting. And Press Cycle start Button After Completing Process then Inspect the part with the help of Vernier Caliper & Plug Gauge.	Tool (Drill 6.7) Instrument (Vernier Caliper & Plug Gauge)	If sizes don't according to tolerance then repeat N5 process & give offset value & check again .	Shoes, Gloves
	17	N6 Drilling ø6.5	Drilling Parameter Will Be set on Reject (NG) Part. After completing N6 process Inspect the part with reference to OPS document. Process & make sure dimension should be according to document. PP\FM\024 ISSUE 01 PAGE 5of17	During Setting Of Diameter of Hole Size and Holes PCD Operator Must Used Rejected (NG) Part for Setting. And Press Cycle start Button After Completing Process then Inspect the part with the help of Vernier Caliper & Plug Gauge.	Tool (Drill 6.5) Instrument (Vernier Caliper & Plug Gauge)	If sizes don't according to tolerance then repeat N6 process & give offset value & check again .	Shoes, Gloves
	18	N7 Chamfer on ø12.5	After completing N7 process Inspect the part with reference to OPS document. Process & make sure dimension should be according to document. PP\FM\024 ISSUE 01 PAGE 5of17	Cycle start Button Press & Inspect the part with the help of Vernier Caliper & Counter Gauge.	Tool (Rose bit 45°) Instrument (Vernier Caliper & Counter Gauge)	If sizes don't according to tolerance then repeat N7 process & give offset value & check again .	Shoes, Gloves
 	19	Unclamp the disk	Before unclamping the disk make sure all work done on disk.	Press left pedal with the help of left leg & hold disk with the help of both hands.	Left pedal	-	Shoes, Gloves
 	20	Inspection	Inspect the part with using all instruments. PP\FM\024 ISSUE 01 PAGE 5of17	Check Dimension with the help of Instruments.	Instruments	Check with Sequence 1) Vernier Caliper 2) Gauge 61 3) Guage 12.5 4) Guage 6.7 5) Guage 6.5 6) Micro Meter 7) Depth 3.5 8) Depth Vernier 9) Knife Vernier	Shoes, Gloves
 	21	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.	Shoes, Gloves
 	22	Storage & Handling Of Finish Part	Finish Disk set in Storage Location	Place the disk properly in the Disk Racks, so it doesn't hit or collide with Other Disk.	Finish Disk , Storage Rack	Disk needs to repair then place into Repairing rack and rejected Disk then place into Rejection rack.	Shoes, Gloves

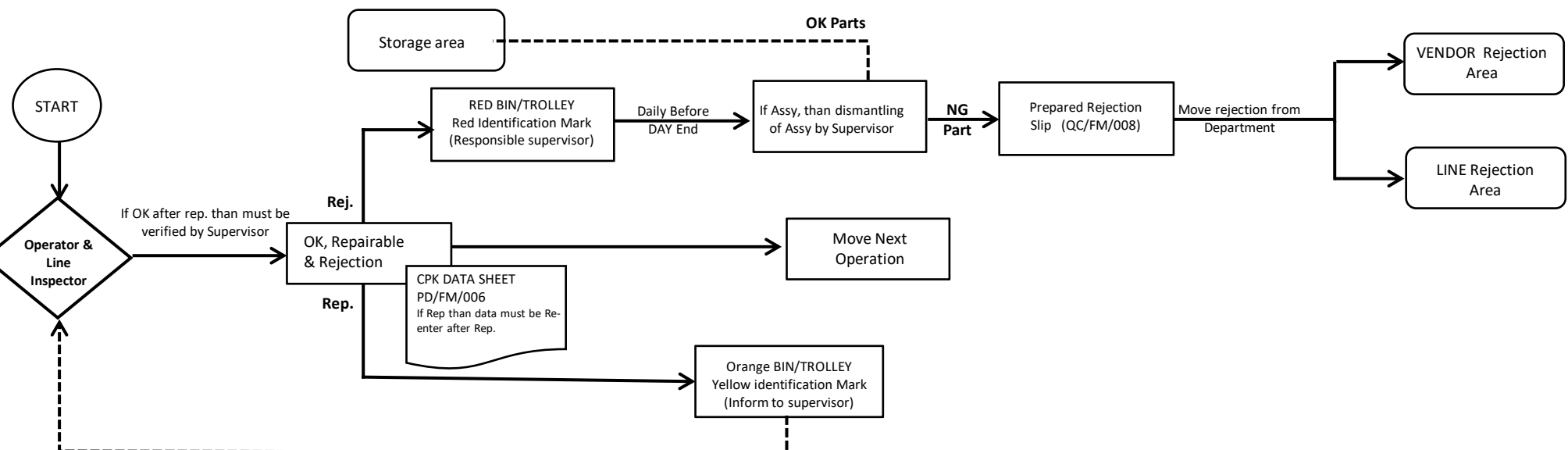
Day First Part Manufacturing

* For first part manufacturing Operator must follow these process: 1,2,3,4,5,8,9,10,12,13,14,15,16,17,18,19,20,21,22 & in Process # 11 operator should follow these Quality standards: Give offset 0.2+ in Outer Diameter & 0.2- in Inner Diameter in offset in wear option not try to insert in Geometry option.

Routine Part Manufacturing

* For Routine part manufacturing Operator must follow these process: 8,9, then Start Cycle then 19,20 & 22

OK,REJ.& REPAIRING PART RULES & ROUTE



Designated Safety Wears						No.	Parts Number	Parts Name	QTY	Rank	Model														
						1	45251-TEA-T100-H1	45251-TEA-T100-H1	1	HA	ZYN														
												</													