

PP\FM\024
ISSUE 01
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MACHINE NAME / No		CNC VERTICAL TURNING CENTER						
CUTTING OIL		WATER SOLUBLE Ratio (1:30)				ST	V	f
No	CUTTING TOOL NAME	SPECIFICATION	ACTIVITY NAME	Qty	Ins.or Dr. per edge consumption	N (rpm)	(m/min)	(mm/rev)
1	WTXNL	(TNMG 0.8)	Rough Turning & Facing	1	10pieces/Edge	510~1252	-	0.2
2	SVYBM	(VYBMT) 0.8	Finish Turning & Facing	1	12 pieces/Edge	1252~84	-	0.15~0.3
3	DRILL	GCMT 0.4 (Ø12.5)	Drilling	1	110pieces/drill	1454	-	105
4	DRILL	GCMT 0.4 (Ø6.5)	Drilling	1	110pieces/drill	1212	-	90
5	DRILL	GCMT 0.4 (Ø6.7)	Drilling	1	110pieces/drill	1212	-	90
6	SDUCR	(DCMT) 0.8	Finish Boring	1	80 pieces/Edge	1241	-	0.23
7	ROSE BIT	45°	Chamfer & Counter	1	200pieces/Rose	1212	-	105
8								
JIGS & FIXTURES								
No	ITEM NAME	SPECIFICATION					ACTIVITY No.	
1	4 Jaws Chuck	HYDRAULIC JIG					1	
2	Go/No Go Gauge	ø12.5					2	
3	Go/No Go Gauge	ø6.7 & 6.5					3	
4	Go/No Go Gauge	ø64.13					4	
5								
6								
7								
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	Visual/Pictorial sheet		100%	-	-	
17	1 HOLE DRILLING	ø6.5 ^{+0.2-0.0}	Vernier Caliper / Go/NoGo Gauge		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
19	CC-φ 6.5	50 ^{+0.05}	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
27	ROUGHNESS ON HOLE φ 6.5	R2100 X 6.5	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
2	★ 5-HOLE DRILLING	ø12.5 ^{+0.3-0.0}	Vernier Caliper / Go/NoGo Gauge(CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
43	Angle B/W Rib to Rib	8°22'19"	Checking Fixture / Rib Ref. Jig		Every New Setting	-	-	
3	5-HOLE PCD φ 12.5	ø114.3 ^{+0.1}	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
34	RADIUS	R 2.0 ^{+0.0 -0.4}	Radius Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
72	RUNOUT SURF Y	0.1	Checking Fixture		Every New Setting	-	-	
4	ANGLE	72° ±10'	Checking Fixture		Every New Setting	-	-	
-	2 HOLE DRILLING	ø6.7 ^{+0.2-0.0}	Vernier Caliper / Go/NoGo Gauge		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
16	CC Distance M6 Hole φ 6.7	ø100 ^{+0.5}	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
13	★ DIAMETER	ø152.0 ^{+0.0-0.5}	Vernier Caliper /(CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
60	DIAMETER	ø173.0 ^{+0.0-1.0}	Vernier Caliper		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
14	DIMENSION (Height)	0.5Max	Height Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
33	RADIUS	R 1.0 ^{+0.4}	Radius Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
41	ANGLE	30° ±1°30'	Bevel Protector		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
56	DIMENSION (Height)	28 ^{+0.4 -0.0}	Height Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
57	HEIGHT BEFORE BURNISHING	1.7Max	Height Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
1	★ BORING DIA	ø64.13 ^{+0.05-0.0}	Vernier Caliper / Go/NoGo Gauge/ (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
24	ROUGHNESS ON φ 64.13	R225 X 0.25	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
61	★ WALL THICKNESS "X"	8.3 ^{+0.75}	Vernier Caliper (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
12	★ THICKNESS BEFORE BURNISHING	23.6 ^{+0.2-0.0}	Micro Meter/ (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
68	★ DIMENSION	6.0 ^{+0.3-0.0}	Micro Meter (CPK)		100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
23	ROUGHNESS ON φ 152 Face	RZ25 X 2.5	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
45	CHAMFER "X"	C0.4°0.8	Bevel Protector		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
69	Thickness Variation in radial Before Burnishing	3 Equal Sides 0.1	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
48	5- HOLE CHAMFER	C 0.5	Bevel Protector+Height Gauge		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
20	STRIGHTNESS X FACE	0.03	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
69	THICKNESS VARIANCE BEFORE BURNISHING	0.1	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
70	THICKNESS VARIANCE CIRCUMFERENTIAL BEFORE BURNISHING	0.05	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
74	Tilt on X Face	0.08 Max	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
73	RUNOUT on φ152 Face	0.08	Checking Fixture		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
25	Roughness on ø 152	Rz100 x 8.0	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
26	Roughness on 5-Hole ø 12.5	Rz100 x 0.25	Roughness Tester		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
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MATERIAL	FC220P
PARTS NAME	DISK FR BRAKE (15" 23T)
PARTS No	45251-TEA-T100-H1
MODEL	2YN