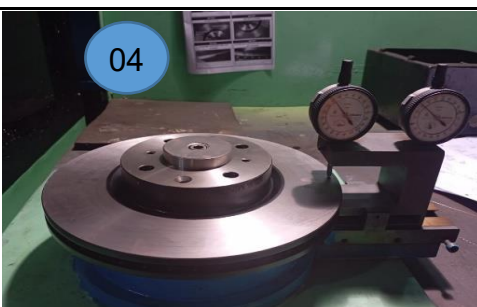
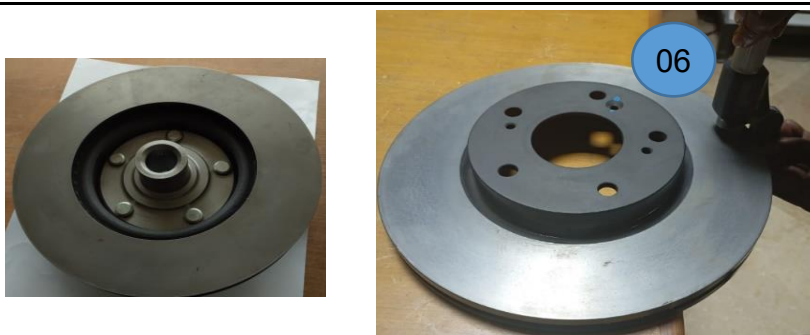


Manufacturing Operation Standard

Manufacturing Operation Standard

Model		2YN	Process / Operation Name		Final Inspection				
Preparing Department Confirmed by Checked by Prepared by Control No. PP\FM\025 ISSUE 01 PAGE 18of19									
PICTORIAL VIEW			No.	Operation	Quality Standard	Working Point	Tool & Material	Comments	Safety Points
02  01 			1	Check Runout & Perpendicularity of Disk	Make sure checking fixture should be calibrated from QC & No bur or Dust on Fixture. Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 17of17	After mounting disk on fixture check Runout & Perpendicularity of Disk with the help of lever gauge.	Runout & Perpendicularity Checking Fixture & Lever Gauge	If fixture & Lever gauge is NG then immediate inform to Supervisor.	Gloves, Shoes
04  03 			2	Check Thickness variation on fixture	Make sure checking fixture should be calibrated from QC & No bur or Dust on Fixture. Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 17of17	After mounting disk on fixture check Thickness variation with the help of moving slides & note reading from dial gauge.	Checking Fixture Dial Gauge	If fixture is NG then immediate inform to Supervisor.	Gloves, Shoes
05 			3	Check the depth	Surface should be clean where lever gauge is move or slide & make sure level gauge is not touch with disk surface only lever touches with disk surface. Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 17of17	Place a disk on smooth surface then slide hight gauge /Depth vernier on disk and check reading on it.	Height Gauge/Depth vernier	1)This Dimension Should be Checked By Q.C Department 2)If disk or surface not clean then it can be effected on reading.	Gloves, Shoes
06 			5	Inspection With Micro Meter	Inspect this part with the reference of this document. PP\FM\024 ISSUE 01 PAGE 17of17	Check Thickness 21mm with the help of Micro meter Check the disk in 3 equal Space i-e- Approx. 120 °	Micro Meter	If micro meter is not calibrated then it give you a not good result.	Gloves, Shoes
09  08 			7	QC inspection	PP\FM\024 ISSUE 01 PAGE 17of17 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, Goggles

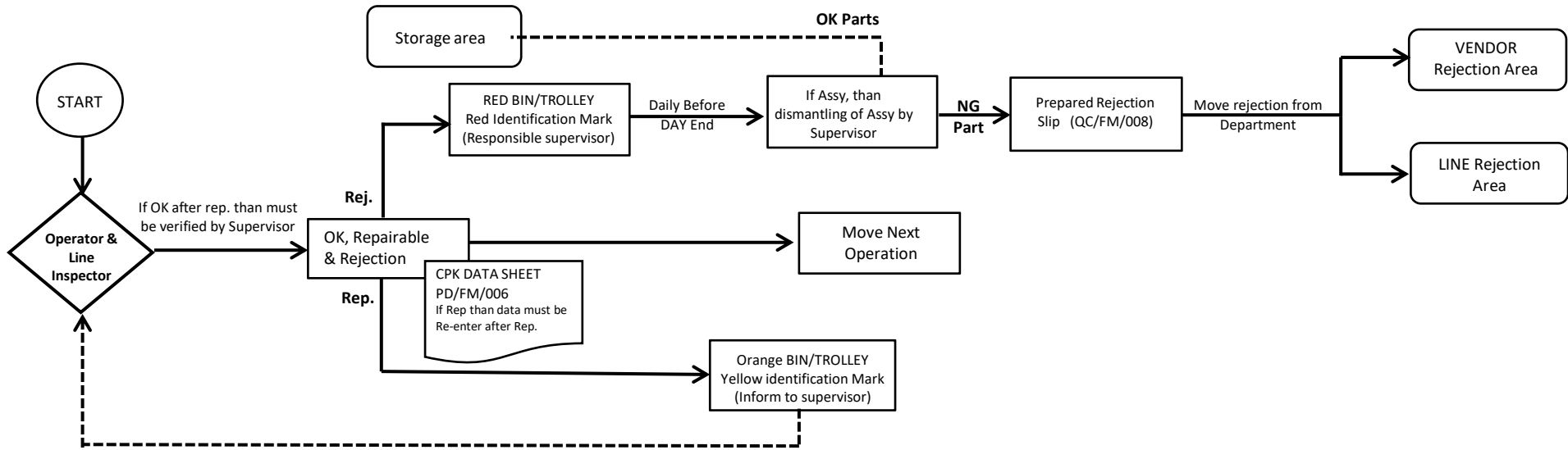
Day First Part Inspection

* For first part packing Operator must follow these process: 1,2,3,4,5,6

Routine Part Inspection

* For Routine part Packing Operator must follow these process: 1,2,3,4,5,6

OK,Rej. & REPAIRING PART RULES & ROUTE



Designated Safety Wears						No.	Parts Number	Parts Name	QTY	Rank	Model												
						1	44400-TEA-T000	Hub & Disk Assy (15")	1	HA	2YN												