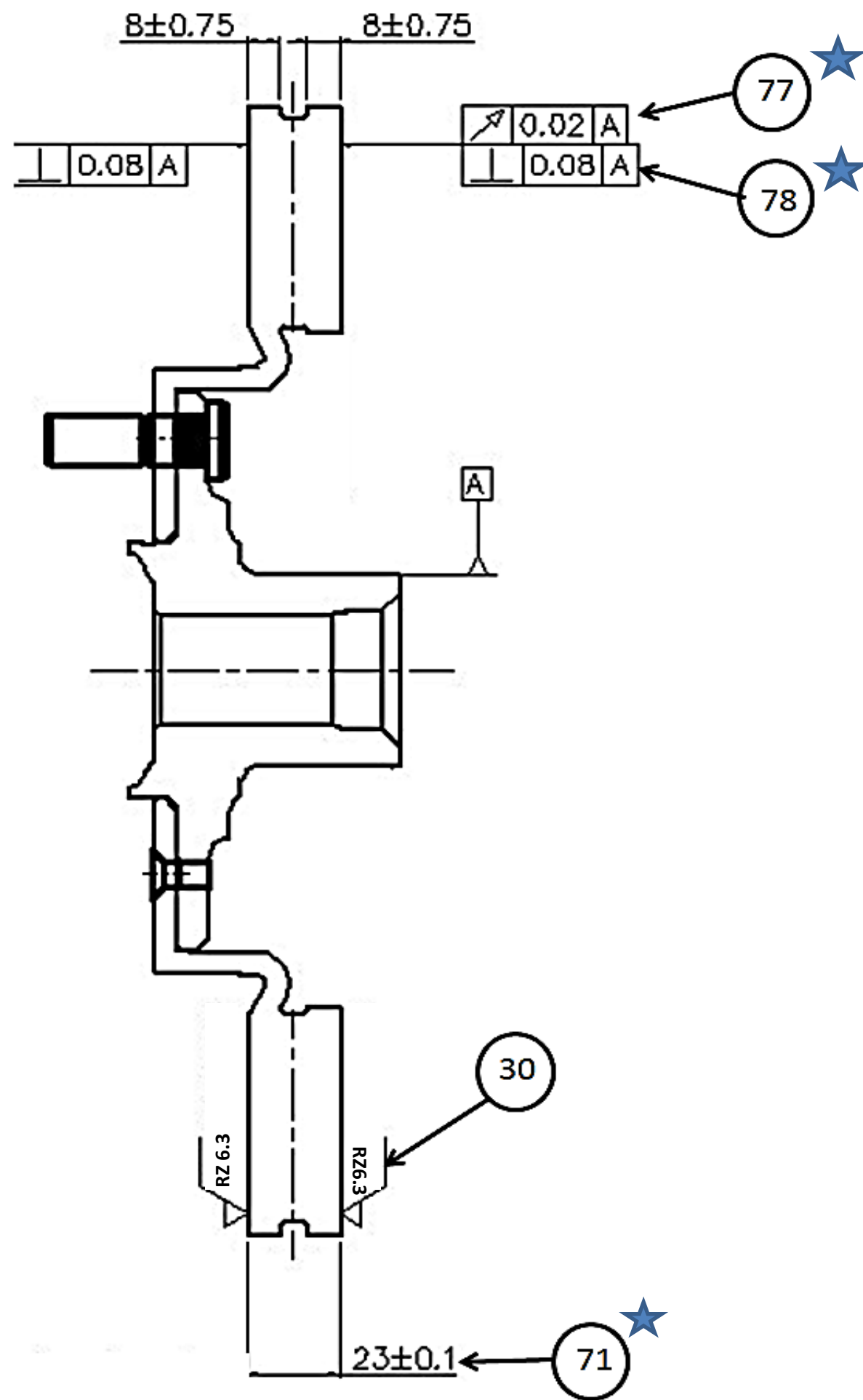


OPERATION STANDARD

PROCESS DRAWING



NOTE:

Thickness Variation (Radial) After Burnishing
Thickness Variance Circumferential After
Burnishing on Ø282

QC Checking M/C Parameter : ($\lambda C 0.8 \times 2$)

APPEARANCE- Dent or Damage ,Bur, Rust ,Blow Hole M/C Area or Non M/C Area not Allowed

<u>3</u>				PROCESS No	17	APPR by	CHKD by	CHKD by	DWG by
<u>2</u>									
<u>1</u>									
ISSUE	02-11-22	NEW WRITE	01	PROCESS NAME	FINAL INSPECTION (Dismantling Of Nuts)				
	D.M.Y	CORRECT REVISE REASON	ISSUE						

MACHINE NAME / No		-						
CUTTING OIL		-			ST			
No	CUTTING TOOL NAME	SPECIFICATION	ACTIVITY NAME	Qty	N (rpm)	V (m/min)	f (mm/rev)	
1								
2								
3								
4								
5								
6								
JIGS & FIXTURES								
No	ITEM NAME	SPECIFICATION				ACTIVITY No.		
1	Thickness Variation & Perpendicularity Chk.Fixture							
2	Micro Meter							
3	Roughness Tester							
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%	-		
71	★ DIMENSION	23.0 ±0.1	Micro Meter/(CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
78	★ PERPENDICULARITY X & Y	⊥ 0.08 A	Checking Fixture/(CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
77	★ RUN OUT WITH REFERENCE TO A	↗ 0.02 A	Checking Fixture/(CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
75	★ Thickness Variation (Radial) After Burnishing	3 Equal Sides 0.03	Checking Fixture/(CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
76	★ Run Out Circumferential FTER BURNISHING	0.007	Checking Fixture/(CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
30	ROUGHNESS X & Y Face After Burnishing	Rz 6.3x0.8	Roughness Tester	-	Every New Setting	5 Pcs/Shift 1 Pcs / 1.5 Hr		
</								