

PROCESS DRAWING

±0.7

7.3

20

26

68

33

+0.2-0.0

0.6

Surf Y

0.05

Rz 15

7

6

5

4

1

±0.5-0.0

±0.25

±0.25

+0.0-1.0

±0.0-0.5

Ø 123

Ø 124

Ø 148

Ø 154

Ø 262

±0.5

Ø 60

+0.4-0.0

C 3

Rz 25

C 0.5 Max

35

29

0.06

±0.1

38.8

19

53

10

1.2 ±0.4

0.8 MAX

φ 154

φ 160

d. 5 MIN

DETAIL E (5:1)

15

±0.5

55

±0.2

2

±0.2

1.2

54

DETAIL "D"

APPEARANCE- Dent or Damage ,Bur, Rust ,Depressions, Blow Holes M/C Area or Non M/C Area Not Allowed

[illegible]

No	CHECK POINT	STANDARD	INSPECTION TOOL	INSPECTED BY OPERATOR	INSPECTED BY LINE INSPECTOR	INSPECTED BY QC INSPECTOR
-	APPEARANCE	Dent or Damage ,Bur, Rust Depressions, Blow Holes M/C Area or Non M/C Area Not Allowed	Visual/Pictorial sheet	100%	-	-
1	★ DIAMETER	ø262.0 ^{+0.0-0.5}	Vernier Caliper/ (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
4	DIAMETER	ø154.0 ^{+0.0-1.0}	Knife Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
5	★ DIAMETER	ø148 ^{±0.25}	Knife Vernier Caliper/ (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
19	★ DIMENSION (Height)	38.8 ^{±0.1}	Depth Vernier Caliper/ (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
29	FLATNESS	 0.06	Height Gauge + Lever Gauge	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
-	DIMENSION (Height)	0.8 MAX	Depth Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
39	CHAMFER	C 3.0 ^{+0.4-0.0}	Depth Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
15	DIMENSION (Height)	3.0 ^{±0.5}	Depth Vernier Caliper+Bevel Protector	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
20-	★ WALL THICKNESS "Y"	7.3 ^{±0.7}	Vernier Caliper (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
54	RADIUS	R1.2 ^{±0.2}	Check By Program	-	-	-
7	DIAMETER	ø123.0 ^{+0.5-0.0}	Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
6	★ DIAMETER	ø124.0 ^{±0.25}	Vernier Caliper/ (CPK)	100%	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
55	RADIUS	R2.0 ^{±0.2}	Check By Program	Every New Setting	-	-
53	RADIUS	R1.2 ^{±0.2}	Check By Program	-	-	-
35	CHAMFER	C 0.5 MAX	Bevel Protector /Check By Program	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
33	CHAMFER "Y"	C 0.6 ^{+0.2-0.0}	Bevel Protector /Check By Program	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
-	DIMENSION (Rough Bore)	ø60 ^{±0.5}	Vernier Caliper	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
68	ROUGHNESS Y FACE BEFORE BURNISHING	RZmax 15	Roughness Tester	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
26	STRIGHTNESS Y FACE	— 0.05	Checking Fixture	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr
69	ROUGHNESS ON Ø123 DISK FACE	RZmax 25	Roughness Tester	Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr

 **Legend Show Critical Dimension**

MATERIAL	FC220P
PART NAME	DISK FR BRAKE (262mm Painting)
PART No	45251-3S6-T000
MODEL	3AM