

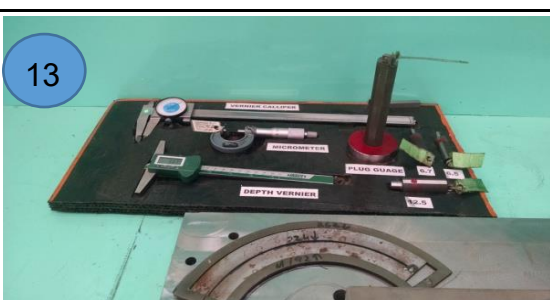
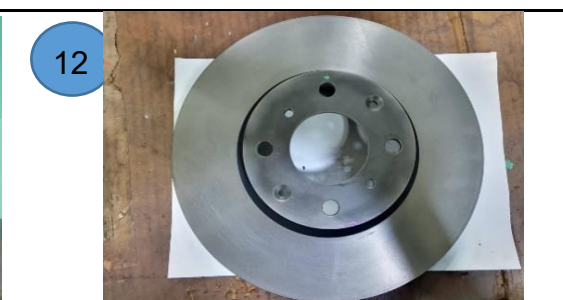
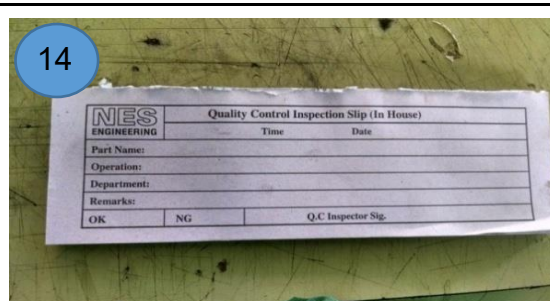
Manufacturing Operation Standard

Manufacturing Operation Standard

Model	3AM	Process / Operation Name	Semi-Final Inspection
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Preparing Department	
NES	
Confirmed by	Prepared by
	

Control No.
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	No.	Operation	Quality Standard	Working Point	Tool & Material	Comments	Safety Points
	1	Bur Remove & Appearance	Make sure at this stage all Previous Process must be done & also make sure Drum should be free from Bur & Dent. Empery Paper Grid (120)	Visually check Complete Disk.Bur Remove with Help of Empery Paper	Disk, Empery Paper (120)	If inspector found some missing in previous processes then give it back to its position.	Gloves, Shoes
 	2	Check PCD of $\phi 6.5$ & $\phi 6.7$ with the reference of $\phi 12.5$	Fixture Should be clean from Bur. PCD Checking Fixture Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 00 PAGE 09of16	Inspection on PCD checking fixture.	PCD Checking Fixture	In case the fixture is identified as NG, notify the Supervisor immediately.	Gloves, Shoes
 	3	Check Flatness Of Disk.	Fixture Should be clean from Bur. Flatness Checking Fixture Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 00 PAGE 09 of 16	Inspection to Verify Flatness Using Flatness Checking Fixture	Flatness Checking Fixture	In case the fixture is identified as NG, notify the Supervisor immediately.	Gloves, Shoes
 	4	 Check Runout	Fixture Should be clean from Bur. Runout Checking Fixture Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 00 PAGE 09of16	Inspection on Runout &with the help fixture.	Runout Checking Fixture Lever Gauge & Height Stand	In case the fixture is identified as NG, notify the Supervisor immediately.	Gloves, Shoes
 							
 	5	Check thickness variation & Perpendicularity.	Fixture Should be clean from Bur.PCD Checking Fixture Should be Calibrated & Tagged from QC. Check the part with reference to this document. PP\FM\024 ISSUE 00 PAGE 09of16	Inspection on thickness variation & Perpendicularity checking fixture.	1-Fixture 2-Dial indicator	In case the fixture is Identified as NG, notify the Supervisor immediately.	Gloves, Shoes
 	6	Inspection	These all instruments & Gauges should be calibrated from QC. PP\FM\024 ISSUE 00 PAGE 09of16	Check disk dimensions with using these instruments & Gauges	Instruments & Gauges	If instruments, Gauges are not calibrated and approved by QC, the risk of product rejection increases	Gloves, Shoes
 	7	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.	Gloves, Shoes

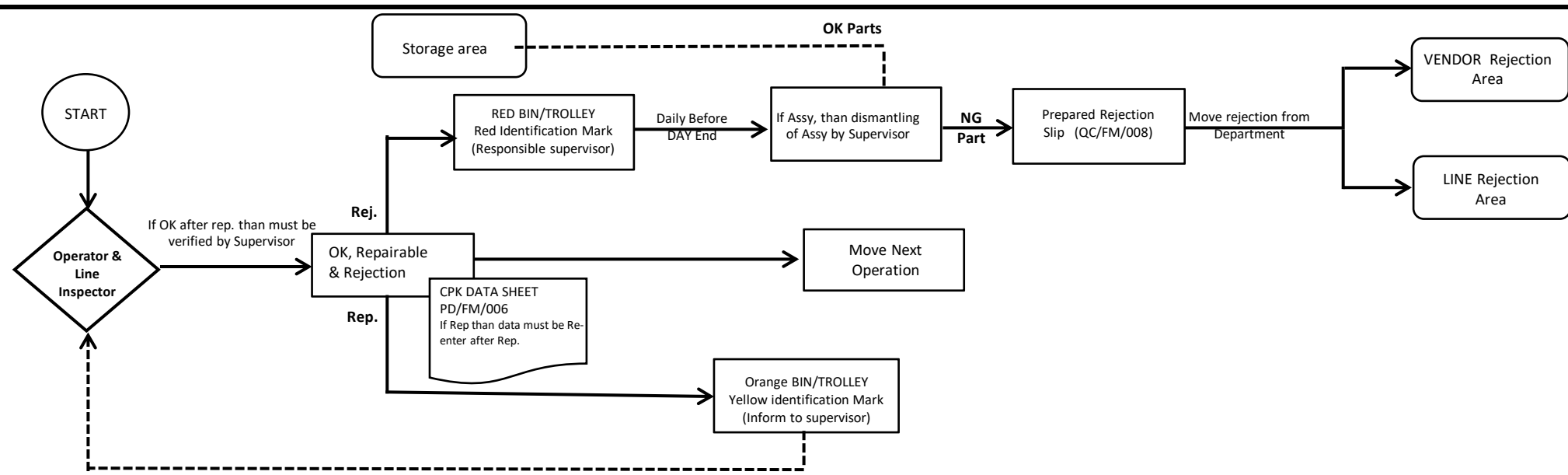
Day First Part Manufacturing

* For first part manufacturing Operator must follow these process: All process 1,2,3,4,5,6,7,8

Routine Part Manufacturing

* For Routine part manufacturing Operator must follow these process: 1,2,3,4,5,6,7

OK,REJ.& REPAIRING PART RULES & ROUTE

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