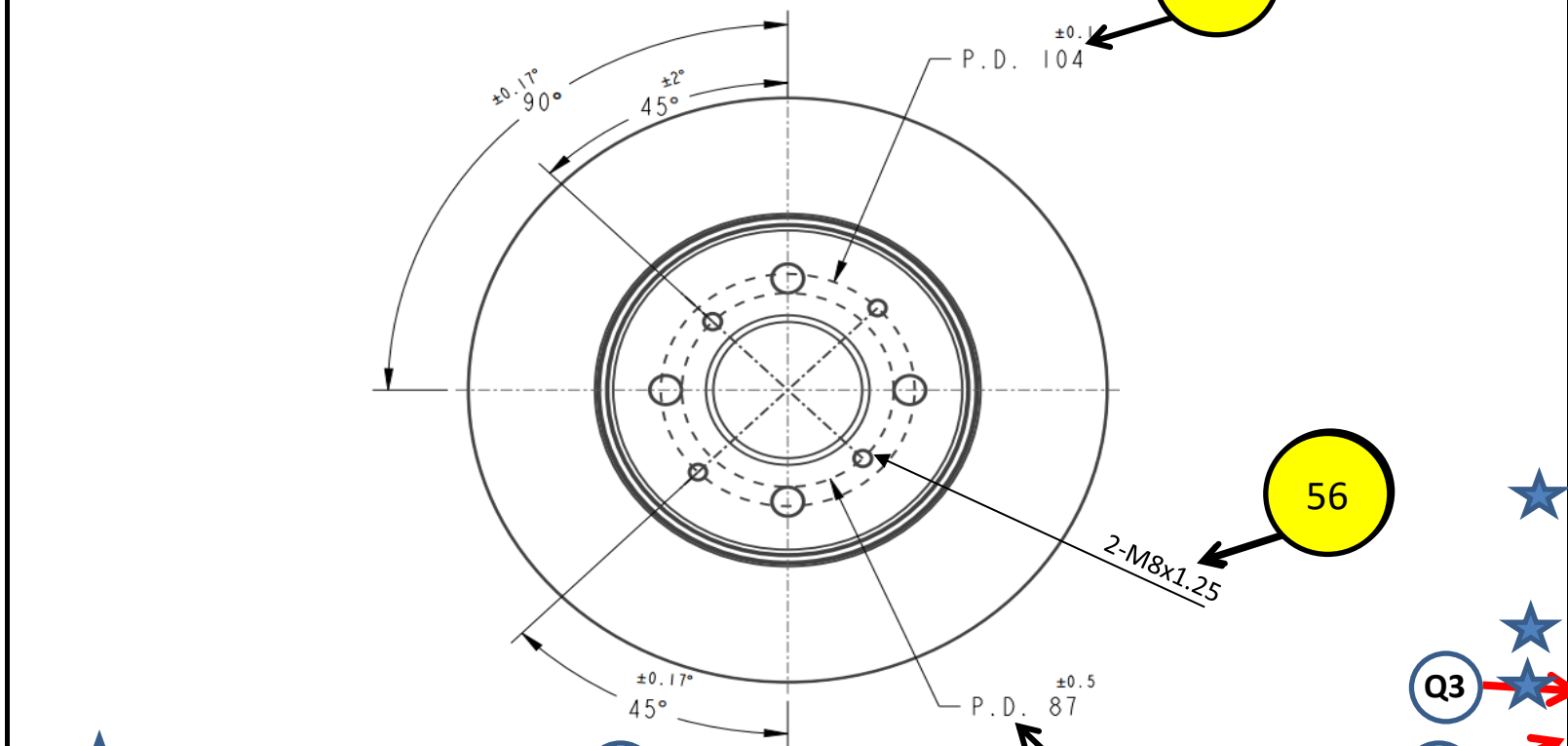




NOTE:

Feature	Requirement
Runout Surf "Y"	$\sqrt{0.1}$
Thickness Variance Before Burnishing (Radial)	0.1
Thickness Variance Circumferential Before Burnishing	0.05
Tilt on X face	0.08 MAX
ROUGHNESS X Face before Burnishing	$\sqrt{RZ 15 \times 2.5}$
Runout on $\phi 132$ Face	0.08 MAX

<u>3</u>				PROCESS No	09	APPR by	CHKD by	CHKD by	DWG by
<u>2</u>									
<u>1</u>									
ISSUE	15-03-25	NEW WRITE	00	PROCESS NAME	Semi Final Inspection				
	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	Emery Paper	Grid 120	-	1		-		
						-		
						-		
						-		
						-		
						-		
JIGS & FIXTURES								
No	ITEM NAME	SPECIFICATION				ACTIVITY No.		
1	Runout Fixture							
2	PCD CHK. Fixture							
3	Height Gauge							
4	Tapping Gauge							
5	Go No-go Gauges							
6	Flatness Fixture							
7	Micro Meter							
8	Thickness Variation & Perpendicularity Chk.Fixture							
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%	-		
12	4-HOLES DRILLING	4-ø12.5 ^{+0.4-0.0}	Vernier Caliper / Go/NoGo Gauge	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
13	4-HOLES PCD ø12.5	ø100 ^{±0.1}	Checking Fixture	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
14	2-HOLES DRILLING	ø6.5 ^{+0.2-0.0}	Vernier Caliper / Go/NoGo Gauge	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
58	CC-ø6.5	87 ^{±0.5}	Checking Fixture	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
22	THICKNESS BEFORE BURNISHING	21.6 ^{+0.2-0.0}	Micro Meter	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
8	BORING DIA	ø61.0 ^{+0.076+0.03}	Vernier Caliper / Go/NoGo Gauge	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
1	DIAMETER	ø262.0 ^{+0.0-0.5}	Vernier Caliper	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
11	DIAMETER	ø134.0 ^{±0.25}	Vernier Caliper	-	1 Pcs/ Shift	5 Pcs/Shift 1 Pcs / 1.5 Hr		
6	DIAMETER	ø124.0 ^{±0.25}	Knife Vernier Caliper	-	1 Pcs/ Shift	5 Pcs/Shift 1 Pcs / 1.5 Hr		
7	DIAMETER	ø123.0 ^{+0.5-0.0}	Knife Vernier Caliper	-	1 Pcs/ Shift	5 Pcs/Shift 1 Pcs / 1.5 Hr		
5	DIAMETER	ø148 ^{±0.25}	Knife Vernier Caliper	-	1 Pcs/ Shift	5 Pcs/Shift 1 Pcs / 1.5 Hr		
29	FLATNESS	 0.06	Checking Fixture / (CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
19	DIMENSION (Height)	38.8 ^{±0.1}	Depth Vernier Caliper	-	1 Pcs/ Shift	5 Pcs/Shift 1 Pcs / 1.5 Hr		
85	CONCENTRICITY ON ø262	 0.15 A	Checking Fixture/ (CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
-	RUNOUT on ø132 Face	0.08	Checking Fixture/ (CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
64	RUNOUT SURF Y	 0.1	Checking Fixture	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
65	Thickness Variation in radial Before Burnishing	3 Equal Sides 0.1	Checking Fixture/ (CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
66	THICKNESS VARIANCE CIRCUMFERENTIAL BEFORE BURNISHING	0.05	Checking Fixture/ (CPK)	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
20-	WALL THICKNESS "X"	7.3 ^{±0.7}	Vernier Caliper	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
17-	WALL THICKNESS "Y"	7.3 ^{±0.7}	Vernier Caliper	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
56	Thread	2-M8 X 1.25	Tapping Gauge	-	100%	5 Pcs/Shift 1 Pcs / 1.5 Hr		
27 28	CONCENTRICITY ON ø124 & ø148	 0.15 A	Checking Fixture	-	Every New Setting	5 Pcs/Shift 1 Pcs / 1.5 Hr		
 Legend Show Jaws Clamping  Legend Show Critical Dimension								
MATERIAL		FC220P						
PARTS NAME		DISK FR BRAKE (262mm Painting)						
PARTS No		45251-3S6-T000						
MODEL		3AM						