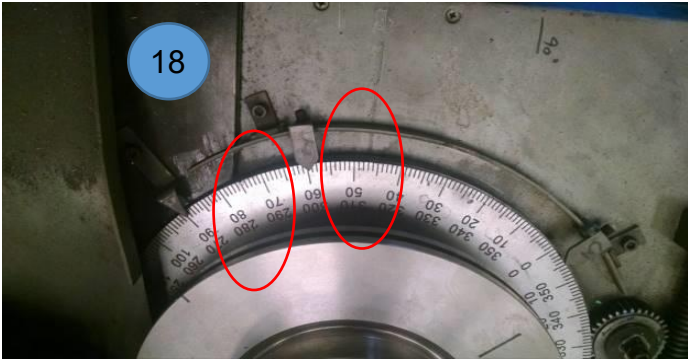
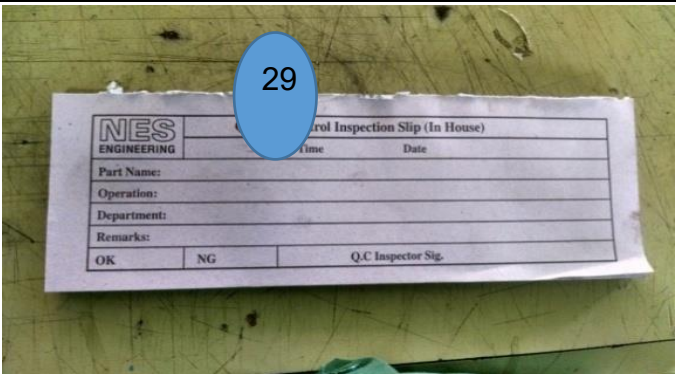
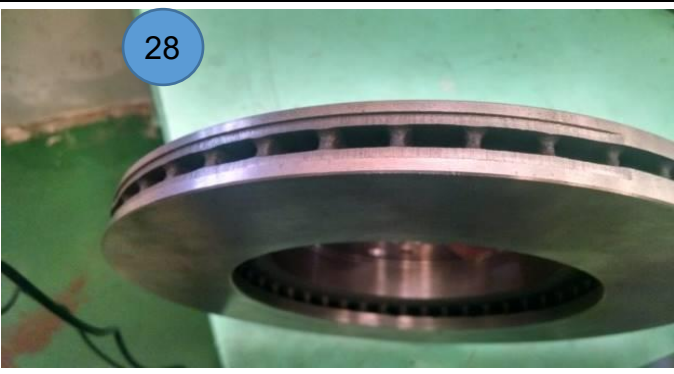


Manufacturing Operation Standard

| Manufacturing Operation Standard |        |                        |  | Preparing Department<br>NES |                                                                    | Control No.                                                                                                      |                                                                                                                                                                                |                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |    |                 |        |            |    |                |
|----------------------------------|--------|------------------------|--|-----------------------------|--------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----|-----------------|--------|------------|----|----------------|
| Model                            |        | 3AM                    |  | Confirmed by                |                                                                    | Prepared by                                                                                                      |                                                                                                                                                                                |                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |    |                 |        |            |    |                |
| Process / Operation Name         |        | Balancing & Correction |  |                             |                                                                    | PP\FM\025<br>ISSUE 00<br>PAGE 11of17                                                                             |                                                                                                                                                                                |                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |    |                 |        |            |    |                |
| PICTORIAL VIEW                   |        |                        |  | No.                         | Operation                                                          | Quality Standard                                                                                                 | Working Point                                                                                                                                                                  | Tool & Material                                               | Comments                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Safety Points  |    |                 |        |            |    |                |
|                                  |        |                        |  | 1                           | Switch on button                                                   | -                                                                                                                | By hand switch on<br>1) Power Sw<br>2) Power System<br>3) Cutter Motor main breaker                                                                                            | 1) Breakers<br>2) Button                                      | It is necessary to on these button to start machine & see the display is working                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Gloves / Shoes |    |                 |        |            |    |                |
|                                  |        |                        |  | 2                           | Feed Tolerance in machine / Program Setting at start up Production | 120 gf.cm MAX<br>(12 g.mm)<br>PP\FM\024<br>ISSUE 01<br>PAGE 9of15                                                | Software<br>↓<br>Rotor<br>↓<br>Rotor Parameter<br>↓<br>S tol & L tol                                                                                                           | Keyboard / Mouse                                              | If this activity is not performed then part checking is on wrong Tolerance & part can be rejected..                                                                                                                                                                                                                                                                                                                                                                                                                                 | Gloves / Shoes |    |                 |        |            |    |                |
|                                  |        |                        |  | 3                           | Cutter Head Position Check                                         | Should in contact with stopper # 1                                                                               | Through Radius cutting handle move the position of cutter head                                                                                                                 | Stopper # 1<br>Handle                                         | If this activity is not perform then balancing M/c will not RUN                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Gloves / Shoes |    |                 |        |            |    |                |
|                                  |        |                        |  | 4                           | Mount Fixture on machine surface                                   | Surface should be clean                                                                                          | By using air gun clean the surface before mounting fixture                                                                                                                     | Ln-Key<br>Air Gun<br>Socket Head Bolt                         | If this activity is not perform then it can cause calibration out/cause an Accident                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Gloves / Shoes |    |                 |        |            |    |                |
|                                  |        |                        |  | 5                           | Close the guard & verify calibration of fixture on screen          | 1) Dialing Limit Maximum 0.1 mm<br>2) tolerance of unbalance 1 gm.mm Maximum                                     | 1)Dial the fixture with lever dial gauge & reclamp the fixture until Run out is within 0.1mm<br>2)Run Balancing till unbalance amount of Fixture close to 1gm.mm               | Lever Dial Gauge<br>Ln-Key<br>weight Brass or Copper          | If this activity is not perform then it can cause fixture calibration out                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Gloves / Shoes |    |                 |        |            |    |                |
|                                  |        |                        |  | 6                           | Visually Check & clamp the disk on fixture                         | 1) No dust or burr allowed.<br>2) Disk & Fixture should be cleaned<br>3) Nut Tightening torque range 40 ~ 50 psi | Visually check the Pcs.<br>Mount disk then add spacer and tight Nut with Air torque gun (Forward)                                                                              | Air torque gun<br>Nut<br>Spacer                               | If pressure is not set within specified range then result is not accurate.                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Gloves / Shoes |    |                 |        |            |    |                |
|                                  |        |                        |  | 7                           | Run Balancing                                                      | 1) All confirmation switch on reference.<br>2) RPM of machine should be 930 ± 10                                 | 1) Press Green button to start cycle<br>2) Press space button on keyboard<br>3) when result appears then press "H" button on keyboard<br>4) Stop cycle by pressing Red Button. | Green Button<br>Keyboard<br>Red Button<br>Confirmation switch | If confirmation switch not ON reference then machine not start.<br>If space button not Press during balancing it will not show machine RPM & result of on unbalance amount. To hold result for correction of unbalance amount press "H" button.<br>if Result is in OK limit then process next operation # 10.<br>if Result is in Repairing limit then process next operation # 08.<br><table><tr><td>≤ 1500 gmm</td><td>OK</td></tr><tr><td>1501 ~ 2600 gmm</td><td>Repair</td></tr><tr><td>≤ 2601 gmm</td><td>NG</td></tr></table> | ≤ 1500 gmm     | OK | 1501 ~ 2600 gmm | Repair | ≤ 2601 gmm | NG | Gloves / Shoes |
| ≤ 1500 gmm                       | OK     |                        |  |                             |                                                                    |                                                                                                                  |                                                                                                                                                                                |                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |    |                 |        |            |    |                |
| 1501 ~ 2600 gmm                  | Repair |                        |  |                             |                                                                    |                                                                                                                  |                                                                                                                                                                                |                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |    |                 |        |            |    |                |
| ≤ 2601 gmm                       | NG     |                        |  |                             |                                                                    |                                                                                                                  |                                                                                                                                                                                |                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |    |                 |        |            |    |                |

| PICTORIAL VIEW                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | No. | Operation                                  | Quality Standard                                                                       | Working Point                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Tool & Material                                                                                                       | Comments                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Safety Points  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|--------------------------------------------|----------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
|        | 8   | Correction of unbalance amount             | 1)Max depth 1.5mm<br>2)Min thickness 3.5 mm both side of wall.<br>3)Max cut range 90°. | a)Un balance degree aligned on arrow (1) and then move value of arrow (2) on arrow (1) and lock it.<br>b)Now lock disk with the help of locking gauge which is place on Rib profile of Disk.<br>c)Now press cutter motor button ON.<br>d)Depth of cut should not more then 0.3 ~ 0.5mm on first time cutting unbalance amount from disk.<br>e)for cutting R100 please rotate radius cutting handle to stopper (2)<br>f)for cutting radialy in range of 30 degree rotate, Radial handle until the value of arrow (2) reach on a arrow (1)<br>g)Again cutting R100 please rotate, radius cutting handle till seat on stopper (3)<br>h)Now OFF Button Cutter Motor Switch and then rotate, radius cutting handle to its switch ref position on stopper (1) | Stopper 1,2,3<br>Radius cutting handle<br>Radial Handle<br>Cutter Dia 60<br>locking Rib gauge<br>Cutter motor Button. | a)If not move value of arrow (1) on arrow (2) then value is not in range.<br>b)If do not lock the disk by rib profile gauge then unbalance can not cut from disk.<br>c)If motor button do not press ON before cutting then motor will not work.<br>d)If depth of cut is not in define value range, part can be reject.<br>e) If not rotate radius cutting handle to stopper (2) then Radius R100 is not shown on disk./ work uncomplete.<br>f) If cutting radially not in range of 30 degree then unbalance amount position will shift.<br>g) If not rotate radius cutting handle to stopper (3) then Radius R100 is not shown on disk./ work uncomplete.<br>h) If donot OFF cutter motor switch then its cause of an accident and if donot rotate radius cutting handle to its switch ref position on stopper then M/c will not work | Gloves / Shoes |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 9   | Checking of correction unbalance amount    | Follow Seq # 7                                                                         | Follow Seq # 7                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Following Same tools of seq # 7                                                                                       | If Pc is OK Then Follow Seq #10<br>If Pc is REPAIRE Then Follow Seq #8<br>If Pc is NG Then Follow Seq #10                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Gloves / Shoes |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 10  | Unmounting / Unclamp the disk from Fixture |                                                                                        | Unmounting the disk from fixture by using Air torque gun (Reverse)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Air torque gun                                                                                                        | If Disk is Ok then Ok Disk shifted from the trolley and if disk is NG so disk shifted from Reject area                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Gloves / Shoes |
|                                                                                                                                                                                                                                                                                                                                     | 11  | Inspection                                 | As per document<br>PP\FM\024<br>ISSUE 00<br>PAGE 11 of 16                              | Check the disk following drawing                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Vernier caliper                                                                                                       | If Disk is Ok then Ok Disk shifted from the trolley and if disk is Reject so disk shifted from Reject area                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Gloves / Shoes |
|                                                                                                                                                                                                                                                                                                                                                                                                                        | 12  | 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 Reject then go and come until QC didn't give you OK slip.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Gloves / Shoes |
|                                                                                                                                                                                                                                                                                                                                                                                                                        | 13  | Storage & Handling Of Finish Part          | Finish Disk set in Storage Location                                                    | Place the disk properly in the Disk Racks, so it doesn't hit or collide with Other Disk.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Finish Disk , Storage Rack                                                                                            | Disk needs to repair then place into Repairing rack and rejected Disk then place into Rejection rack.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Shoes, Gloves  |

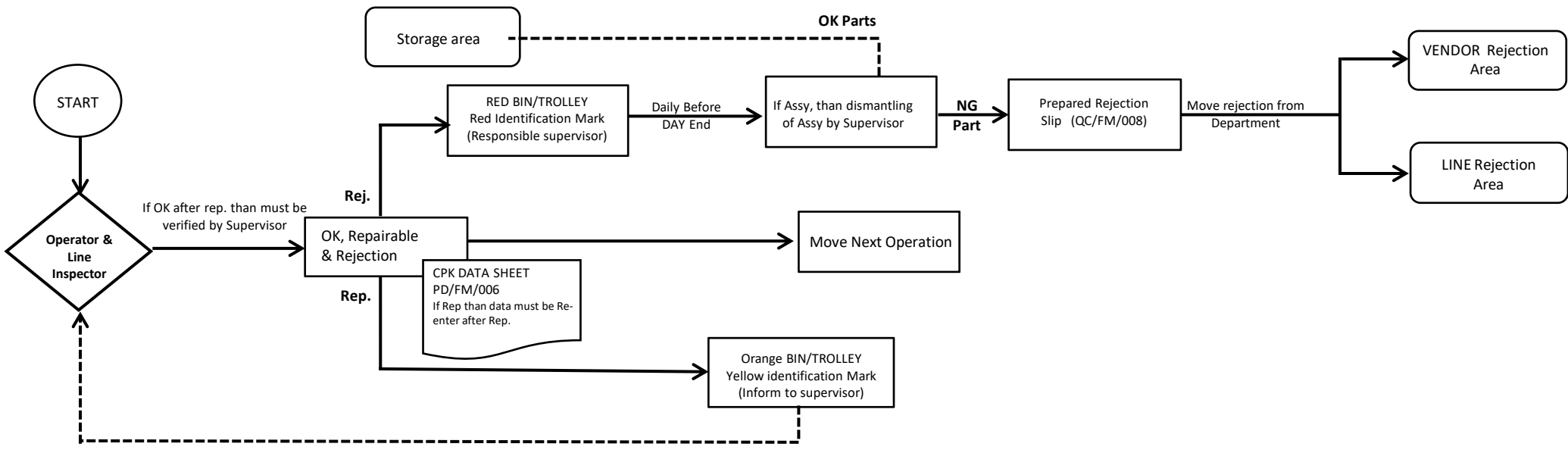
### Day First Part Manufacturing

For first part manufacturing Operator must follow these process: 1,2,3,5,6,7,8,9,10,11,12

### Routine Part Manufacturing

For Routine part manufacturing Operator must follow these process: 5,6,7,9,10 & 11.

### OK ,Rej. & REPAIRING PART RULES & ROUTE



|                                                                                                                                |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
|--------------------------------------------------------------------------------------------------------------------------------|--|--|--|-------------------------------------------------------------|--|--|--|-----|----------------|--|--------------------------------|------------------|-----|------|---------------|------------------------------------------------------------------------------------------------------------|-----------------|--|----------|--|---------------|--|--|
| PICTORIAL VIEW                                                                                                                 |  |  |  |                                                             |  |  |  | No. | Operation      |  |                                | Quality Standard |     |      | Working Point |                                                                                                            | Tool & Material |  | Comments |  | Safety Points |  |  |
| Designated Safety Wears                                                                                                        |  |  |  |                                                             |  |  |  | No. | Parts Number   |  | Parts Name                     |                  | QTY | Rank | Model         | -                                                                                                          |                 |  |          |  |               |  |  |
|                                              |  |  |  |                                                             |  |  |  | 1   | 45251-3S6-T000 |  | DISK FR BRAKE (262mm Painting) |                  | 1   | HA   | 3AM           |                                                                                                            |                 |  |          |  |               |  |  |
|                                                                                                                                |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
|                                                                                                                                |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
|                                                                                                                                |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| Material                                                                                                                       |  |  |  | Torque Importance                                           |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| <div>T Torque</div> <div>B Bond</div> <div>G Grease</div> <div>O Oil</div> <div>SS Solution</div> <div>R Anti Rust Agent</div> |  |  |  | <div></div> Class A <div></div> Class B <div></div> Class C |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
|                                                                                                                                |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               | <div>0</div> Issue <div>28-03-25</div> Date <div>New Issue</div> Revision <div>Contents</div> CheckConfirm |                 |  |          |  |               |  |  |
| TRAINEE NP#                                                                                                                    |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| Date                                                                                                                           |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| Associate Confirmation Signature After 7 DAYS/M                                                                                |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| <hr/>                                                                                                                          |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| TRAINEE NP#                                                                                                                    |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| Date                                                                                                                           |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |
| Associate Confirmation Signature After 7 DAYS/M                                                                                |  |  |  |                                                             |  |  |  |     |                |  |                                |                  |     |      |               |                                                                                                            |                 |  |          |  |               |  |  |