

PP\FM\024
ISSUE 00
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NOTE:
Thickness Variation (Radial) After Burnishing
Thickness Variance Circumferential After Burnishing $\varnothing 210$
X and Y Surf Roughness After Burnishing Can be
 0.03
 0.007
 $Rz_{max} 6.3$

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

MACHINE NAME / No		CNC VERTICAL TURNING CENTER						
CUTTING OIL		-			ST			
No	CUTTING TOOL NAME	SPECIFICATION	ACTIVITY NAME	Qty	Ins.Or Brn. per edge consumption	N (rpm)	V (m/min)	f (mm/rev)
1	WTXNL	(TNMG 0.8)		1	15pieces/Edge	1200/500	-	0.1
2	WTXNL	(TNMG 0.8)		1	15pieces/Edge	1200/500	-	0.1
3	Burnishing roller		Face	1	500 pieces/Roller			
4	Burnishing roller		Face	1	500 pieces/Roller			
5								
6								
JIGS & FIXTURES								
No	ITEM NAME	SPECIFICATION				ACTIVITY No.		
1	Micro Meter							
2	Checking Fixture							
3	Roughness Tester							
4	Height Gauge							
5	Vernier Caliper							
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%		-	
10	★ DIMENSION	21 ^{±0.1}	Micro Meter/(CPK)		100%		5 Pcs/Shift 1 Pcs / 1.5 Hr	
54	RUNOUT of Y Surf Shall be (Measurement Of Run out Runout Ø180~Ø242)	0.05 Max	Checking Fixture		Every New Setting		5 Pcs/Shift 1 Pcs / 1.5 Hr	
30	★ ROUGHNESS X & Y Face After Burnishing	Rzmax 6.3	Roughness Tester/(CPK)		100%		5 Pcs/Shift 1 Pcs / 1.5 Hr	
16	Dimension	38.5 ^{±0.2}	Height Gauge		Every New Setting		5 Pcs/Shift 1 Pcs / 1.5 Hr	
55	THICKNESS VARIATION AFTER BURNISHINGØ 210	0.007	Checking Fixture		Every New Setting		5 Pcs/Shift 1 Pcs / 1.5 Hr	
14	★ WALL THICKNESS AFTER BURNISHING X & Y FACE	7 ^{±0.75}	Vernier Caliper/(CPK)		100%		5 Pcs/Shift 1 Pcs / 1.5 Hr	
36	CHAMFER ON SURF "X"	C 0.3 ^{+0.2-0.0}	Bevel Protector +Depth Micro Meter		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
37	CHAMFER ON SURF "Y"	C 0.3 ^{+0.2-0.0}	Bevel Protector +Depth Micro Meter		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
19	DIMENSION	4 ^{±0.2}	Height Gauge		Every New Setting		5 Pcs/Shift 1 Pcs / 1.5 Hr	
8	DIAMETER	Ø154.0 ^{+0.0-1.0}	Vernier Caliper		Every New Setting	-	5 Pcs/Shift 1 Pcs / 1.5 Hr	
28	DIMENSION	0.5 Max	Height Gauge/Depth Micro Meter		Every New Setting		5 Pcs/Shift 1 Pcs / 1.5 Hr	
76	Radial THICKNESS VARIATION (3 Equally Spaced)	0.03	Checking Fixture/(CPK)		100%	-	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						