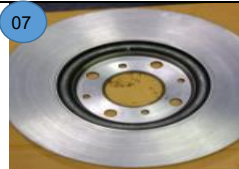


Manufacturing Operation Standard

Preparing Department		Control No. PP\FM\025 ISSUE 00 PAGE 15 of 17
NES		
Confirmed by	Prepared by	
		

Model	3AM	Process / Operation Name	Final Inspection
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PICTORIAL VIEW		No.	Operation	Quality Standard	Working Point	Tool & Material	Comments	Safety Points
		1	Check Runout of Disk	Make sure checking fixture should be calibrated from QC & No bur or Dust on Fixture. Inspect this part with the reference of this document. PP\FM\024 ISSUE 00 PAGE 15of16	After mounting disk on fixture check Runout of Disk with the help of Dial lever gauge.	Perform runout inspection using the checking Fixture with lever gauge, then identify low runout area and mark the low runout point with a green marker.	If fixture & Lever gauge is NG then immediate inform to Supervisor.	Gloves, Shoes
		2	Check Thickness variation on fixture	Make sure checking fixture should be calibrated from QC & No bur or Dust on Fixture. Inspect this part with the reference of this document. PP\FM\024 ISSUE 00 PAGE 15 of 16	After mounting disk on fixture check Thickness variation with the help of moving slides & note reading from dial gauge.	Checking Fixture Dial Gauge	If fixture is NG then immediate inform to Supervisor.	Gloves, Shoes
		3	Check the depth of 38.5 mm	Surface should be clean where lever gauge is move or slide & make sure level gauge is not touch with disk surface only lever touches with disk surface. Inspect this part with the reference of this document. PP\FM\024 ISSUE 00 PAGE 15of16	Place a disk on smooth surface then slide Height gauge /Depth vernier on disk and check reading on it.	Height Gauge/Depth vernier	1)This Dimension Should be Checked By Q.C Department 2)If disk or surface not clean then it can be effected on reading.	Gloves, Shoes
		4	Inspection With Micro Meter	Inspect this part with the reference of this document. PP\FM\024 ISSUE 00 PAGE 15of16	Check Thickness 21mm with the help of Micro meter Check the disk in 3 equal Space i-e- Approx. 120 °	Micro Meter	If micro meter is not calibrated then it give you a not good result.	Gloves, Shoes
		5	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

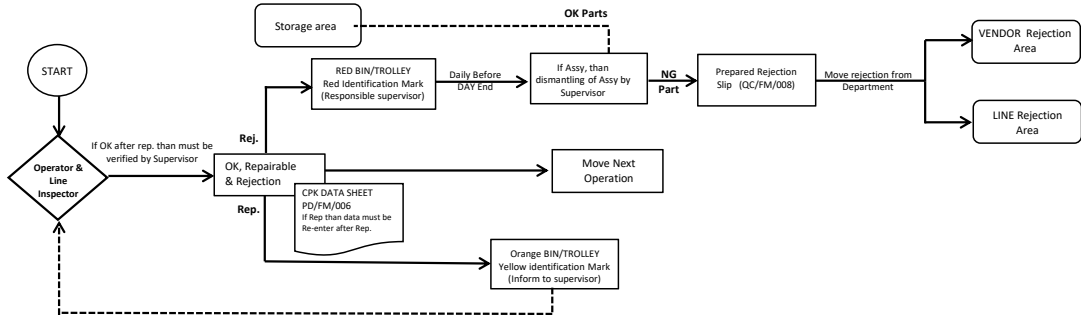
Day First Part Inspection

* For first part packing Operator must follow these process: 1,2,3,4,5

Routine Part Inspection

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

OK, Rej. & REPAIRING PART RULES & ROUTE

[illegible]