
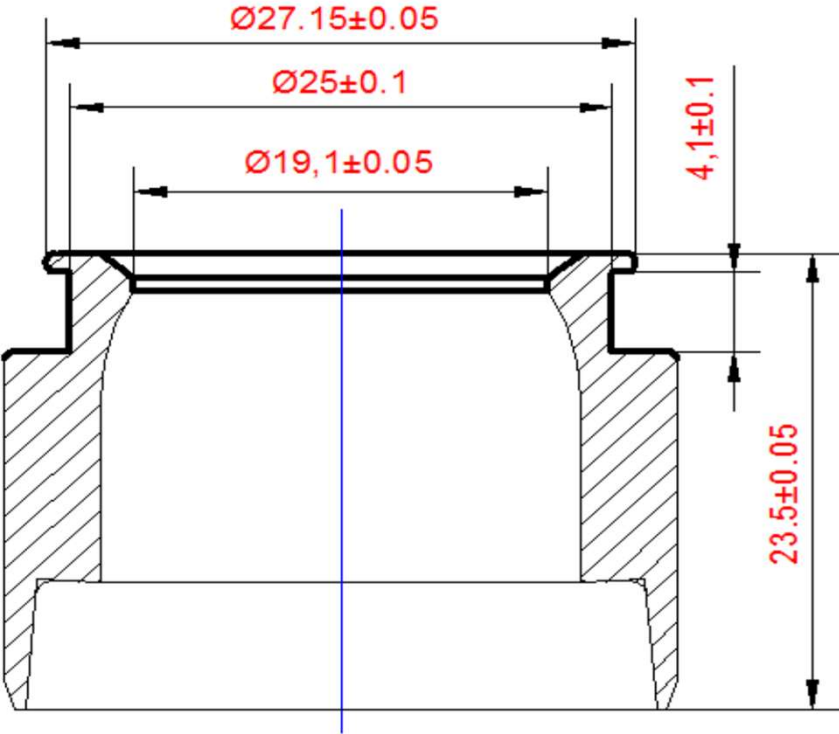
		<h1>WORK STANDARD</h1>							
WORK STAND. NUMBER		PROCESS NO.	PROCESS NAME	PART NAME	PART NUMBER	MACHINE NAME	FORMAT NUMBER	REVISION NO. / DATE	
WS / ILJIN / CASE / OP-100		OP-100	2ND SETTING CNC MACHINING	CASE-LINK ASS'Y, STABILIZER BAR	210031-025	ACE 4/ACE 5 / ACE6 / ACE7/ACE 8/ACE 9/ACE 10/ACE11	KAVIA / WIS / 06	04/ 03.01.2023	
MACHINE PARAMETER	COOLANT OIL LEVEL	SYSTEM PRESSURE		PROCESS PARAMETER	OD ROUGH MACHINING SPEED	OD GROOVING SPPED	ID FINISH CHAMFERING SPEED	TOOL PARAMETER	OD FACING AND CHAMFERING INSERT
	INBETWEEN MIN. MAX	28 ~ 40kg /cm ²			2500 ~ 3200 RPM	2000 ~ 3000 RPM	2000 ~ 3000 RPM		550 NOS/EDGE (WNMG)
	COOLANT CONCENT.	CLAMP'G PRESSURE			OD ROUGH FEED	OD GROOVING FEED	ID FINISH CHAMFERING FEED		OD GROOVING INSERT
	4 ~ 6 %	12 ~ 20 kg/cm ²			0.1 ~ 0.25 mm/rev	0.05 ~ 0.20 mm/rev	0.05 ~ 0.20 mm/rev		600 NOS/EDGE (TDC)
	LUB OIL LEVEL				PROGRAM NO.				ID FINISH CHAMFERING INSERT
	IN BETWEEN MIN & MAX				8900 (FANUC)				500 NOS/EDGE (CCMT)
PROCESS			PHASE	PRODUCTION		WORK INSTRUCTION			
<div><div>▼ : CHUCKING</div><div> : DATUM</div><div>— : WORK SURFACE</div><div>← : TOOL ROUTE</div></div> <div></div>					<div><div>1. EVERY SETTING SET THE PROCESS PARAMETER & MACHINE PARAMETER.</div><div>2. GET THE FIRST PIECE APPROVAL FROM QC</div><div>3. INSPECT THE PART DIMENSIONS AS PER WORK STANDARD</div><div>4. USE YELLOW PAINT FOR REWORK PART & FIX YELLOW TAG</div><div>5. USE RED PAINT FOR REJECTION PART & FIX RED TAG</div><div>6. WEAR SAFETY WEARS (GLOVES, MASK, SAFETY SHOES & ETC.,)</div><div>7. FOLLOW 3C STANDARD FOR FINISH PRODUCT</div></div>				
					GAUGE CHECK POINTS				
					<div><div>1. CHECK THE GAUGE CALIBRATION STATUS</div><div>2. MINIMUM SIX MONTH ONCE NEED TO RE- CALIBRATE</div></div>				
SELF INSPECTION CONTROL		SELF INSPECTION CHECK SHEET NO.							
		SI / ILJIN / CASE / OP-100							
S.NO	PRODUCT PARAMETERS	DIMENSION	SPECIAL CHAR.	CHECK METHOD	SAMPLE		CONTROL METHOD		
					SIZE	FREQ.	CHECK	RESP.	REACTION PLAN
1	STEP DIAMETER	Ø27.15±0.05	Z	SNAP GAUGE	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
2	GROOVE DIAMETER	Ø25±0.10		SNAP GAUGE	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
3	CHAMFER DIA	Ø22.2±0.20		DIGITAL VERNIER CALIPER	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
4	BORE DIA	Ø19.1±0.05	Z	PLUG GAUGE	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
4	GROOVE WIDTH	4.1±0.1		SLIP GAUGE	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
5	DIMENSION	23.50±0.05		SNAP GAUGE	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
6	STEP HEIGHT	16.97±0.05	Z	FLUSH PIN GAUGE	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
7	DIMENSION	1.0±0.05		DIGITAL VERNIER CALIPER	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
8	APPEARANACE	FREE FROM OD DEFECTS, DENT & DAMMAGE MARK		VISUAL	1 NO.	HOUR	HOURLY INSPECTION REPORT	PROD	INFORM TO SUPERVISOR
REV.NO.	CONTENTS			DATE	APPROVAL	NPD	PRODUCTION	QUALITY	
1	RELEASED			15.12.2018					
2	WORK STANDARD REVIEWED & REVISED AS PER CUSTOMER REQUIREMENT			11.08.2021					
3	INTERNAL SPC ADDED FOR Z (CRITICAL) CHARACTERITICS			10.11.2021					
4	INSERT LIFE CHANGED ON PROCESS VALIDATION			03.01.2023					