HOURLY INPROCESS INSPECTION REPORT Case -Link Assy, Stabilizer PARTYON PARTYON Case -Link Assy, Stabilizer PARTYON PARTYON Case -Link Assy, Stabilizer PARTYON PARTYON Case -Link Assy, Stabilizer Case -Link Assy, Assy, Case -Link Assy, Stabilizer Case -Link Assy, Assy, Case -Link Assy, Stabilizer Case -Link Assy, Assy, Case -Link Assy, Case -Link Assy, Case -Link Assy, Assy, Case -Link Assy, Assy, Case -Link Assy, Case -Link Assy, Case -Link Assy, Case -Link Assy, Assy, Case -Link Assy, Case												,			24
NAME CLASS Light A SAN STABILIZES NAME OF	KAVIA ENG	A INEERING PVT LTD	4	ПОН	RLY INP	ROCESS	INSPECT	TION REI	ORT					DATE: 4 SHIFT: 34	
PARAMETRIES	PART NAMI	Ε;	Case -Link Assy, S	tabilizer		PART NO:		21003	11-025	5		**	SAMPLE SIZE:		
National Strictications National Stricti	SUPPLIER / U	CUSTOMER NAME:	ILJIN	ROUTE CARD NO				OPERATION:	100 (2nd	Setting)		-	TOTAL QUANT	IITY:	
Apperance Proceedings Processing Pro				METHODOR					ACTU	AL MEASUREN	TENTS				
Supplement Tendaharan and the control principle of the control prin	SL NO	PARAMETERS	SPECIFICATIONS	INSPECTION	8:00	8:00	00 , 00	11:00		00:1	2:00	3.00	00 th	5:00	
2 Groove Diameter 250±0.10 Diameter 250±0.10 Octobe 194-99 ock	-)<	Apperance	Free from crack,burr,rust,scratch, pitmark,damages,dents etc	VISUAL	X	alk	40	₹	9) po	A A	C. A.	are		
3 Groove Diameter 25.0 ± 0.10 DVC/Sup 9/4-94 GK GK GK GK GK 9/4-98 24-48 4 Chamfer Dia 222±0.2 DVC 9/4-96 3/3-94 9/3-34 9	7	Step Diameter		DVC/Gauge	B	\	× 6	-86	¥		7	51-16	al		e e e e e e e e e e e e e e e e e e e
4 Chamter Dia 222202 DVC 93-34 334 3426 3834 93-34 32-5 8 Bore Dia 1914 0.045 DVC/PALIO 14 0 04 04 04 04 04 04 04 04 04 04 04 04	7	Groove Diameter	25.0 ± 0.10	DVC / Snap Gauge	34.99	As S	¥	¥	OF S	SW.	AK.	24 98	ewn		
S Bore Dia 19.1 ± 0.05 DVC/FILE 15.0 OV OV OV OV OV OV OV O	4		22.2 ± 0.2	DVC	33-36	16.88	99-21	32.20	hB-BB	88-88		12.28	20.00		To the state of th
6 Growe Width 4.1±0.1 DPC/SNP OK 6K 6K 6K 6L 04 4L 4L 8 Dimension 23.50±0.05 DPC/Snap 6K 6K 6K 6K 6K 4L 9 Step Height 1.6.97±0.05 Naster GA 6K 6K 6K 6K 6K 4L 9 Step Height 1.6.97±0.05 Naster GA 6K 6K 6K 6K 6K 4L 9 Step Height 1.6.97±0.05 Naster GA 6K 6K 6K 6K 6K 6K 4L 1.0±0.05 Naster GA 6K	vs.	Bore Dia	19.1 ± 0.05	DVC/PLUG GAUGE	(3.10	*o	ž	É	S. C.	AS S	ak	10. Po	out		
7 Dimension 23.50 ± 0.06 DVCSnap of de	9	Groove Width	4.1 ± 0.1	DVC/Slip GAUGE	*	X	Z	\$	¥	7	36	24	OT		
Step Height 1.0±0.05 DVC 1.0°	7	Dimension	23.50 ± 0.05	DVC/Snap Gauge	1	¥	×	8	*	6k	Z	ak	at		
Step Height 16.97±0.05 Plush pin Gauge	∞	Dimension	1.0± 0.05	DVC	00:	10	00-1	0	101	1.00	(0)	1.6%	1.02		
REMARKS: ACCEPTED ON DEVIATION/SEGREGATION/ REJECT QUALITY ASSURANCE: NOTE: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and patroling inspection Note: Hourly Inspection to be carried out by Operator and Patroling inspection Note: Hourly Inspection to be carried out by Operator and Patroling inspection by Operator	6	Step Height	16.97 ± 0.05	Master GA/ Flush pin Gauge	de	7	7	*	SIL	3	910	al	ale		
REMARKS: ACCEPTED / ACCEPTED ON DEVIATION / SEGREGATION / REJECT OUALITY ASSURANCE: NOTE: In case of any complaint or deviation Q1 & CEO to signary Note: Hourly Inspection to be carried out by Operator and patroling inspector								·						POLICE DE L'ORDE, LÉGICO VERRE DE RÉCLEMENTE	
REMARKS: ACCEPTED / ACCEPTED ON DEVIATION / SEGREGATION / REJECT QUALITY ASSURANCE: Note: Hourly Inspection to be carried out by Operator and patroling inspection.										,					
REMARKS: ACCEPTED / ACCEPTED ON DEVIATION / SEGREGATION / REJECT QUALITY ASSURANCE: Note: Hourly Inspection to be carried out by Operator and patroling inspection.										2					
OUALITY ASSURANCE: NOTE: Hourly Inspection to be carried out by Operator and patroling inspection.	REMARK	S: ACCEPTED/ACCEPTED C	ON DEVIATION / SEGREGATI	ON/ REJECT											
Note: Hourly Inspection to be carried out by Operator and patroling inspection by line inspector	nò	ALITY ASSURANCE:		INSPECTED BY:	Lahor			•	e e	APPROVED BY					The state of the s
Note: Hours in Special to be carried out by Operator and partoning inspection by Inic inspection	-		0	NOTE: In	case of any compla	int or deviation Q	4 & CEO to sign							AND THE PERSON NAMED IN COLUMN TWO IS NOT THE PERSON NAMED IN COLUMN TWO IS	
	Note: HOUR	iy inspection to be carrie	ed out by Operator and	patrolling ilispec	tion by line i	IIspector	Trouble of the second	STO CHIEF LINE	I di I OII I di I de	OTTOTAGEN	id Edodia is	ransia Oladi	TATIO TOOK H	TON	

Filing Responsibility Line QC inspector and Retention perod 1 year

RETENTION PERIOD: 1 YEAR

S.NO. CHECK POINTS SPECIFICATION Lubrication oil level above minimum line above minimum line pressure Hydraulic oil level above minimum line pressure Chuck clamp pressure System pressure System pressure By System pressure Chuck clamp above minimum line red/yellow/green colour mindication red/yellow/green colour condition AC temperature Coolant level above minimum line above minimum line above minimum line above minimum line condition AC temperature Scrap collection maintain 55 at work area maintain 55 at work area maintain 55 at work area condition All push button no overflow from scrap trolley All push button ensure no damage condition AC filter free from dust and oil free from dust and oil chuck & tool kolder free from scrap& bolts are in ightened condition ightened condition	above minimum line oil level indicator above minimum line oil level indicator above minimum line oil level indicator above minimum line cadyellow/green colour red/yellow/green colour monitor & machine stop above minimum line coolant level indicator actemperature display above minimum line coolant level indicator actemperature display waste & dirts observe abnormal sound consultation observe abnormal sound	MACHINE CODE ACTION FOR CHECK POINT FAIL topup oil upto maximum line inform to supervisor inform to maintenance supervisor topup coolant upto maximum level topup coolant oil do 5s activity inform to supervisor	M/242/12.03.22 1 2 3 4 5 6 7 0 0 0 0 0 0 0 3030 30 30 30 0 0 0 0	MONTH B 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25	YEAR-2022 3 26 27 28 29 30 31 REMARKS
CHECK POINTS Lubrication oil level Hydraulic oil level Chuck clamp pressure System pressure Machine status indication Emergency stop button working condition AC temperature Coolant level Coolant concentration Work area all motors working condition Scrap collection All push button switch working condition AC filter Tool & chuck condition		ACTION FOR CHECK POINT FAIL topup oil upto maximum line inform to supervisor inform to supervisor inform to maintenance supervisor inform to maintenance supervisor inform to maintenance supervisor inform to maintenance supervisor topup coolant upto maximum level topup coolant oil do 5s activity do 5s activity	4	8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24	26 27 28 29 30
		topup oil upto maximum line inform to supervisor inform to supervisor inform to maintenance supervisor inform to maintenance supervisor inform to maintenance supervisor topup coolant upto maximum level topup coolant oil do 5s activity do 5s activity			
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		topup coolant oil do Ss activity inform to supervisor	70		
		do 5s activity inform to supervisor	0		
		inform to supervisor			
			0 0 0		
	no overflow from scrap chips conveyor trolley	check often and remove	0 0		
	ensure no damage operating panel	inform to supervisor	0 0 0		
	free from dust and oil ac panel	weekly cleaning of filter	0 0 0 0		
	chuck & tool holder free visual check during from scrap& bolts are in clamping & insert tightened condition	inform to supervisor	0000000		,
FILLED BY	OPERATOR SIGNATURE		MAN WAY		
VERIFIED BY	MAINTENANCE SIGNATURE	JATURE	, 1.		
JCTIONS :- EVERY DAY BEFORE STA	/ DAY BEFORE START PRODUCTION FILL THIS MACHINE CHECK SHEET, WRITE MEASURAL IF ANY PRODIEM: (OPERATOR → SUPERVISOR → MAINTENANCE INCHARGE) TAKE.	NE CHECK SHEET, WRITE MEASURAB MAINTENANCE INCHARGE) TAKE A	BLE PARAMETERS IN NUMERICAL VA ACTION IMMEDIATELY	INSTRUCTIONS :: EVERY DAY BEFORE START PRODUCTION FILL THIS MACHINE CHECK SHEET, WRITE MEASURABLE PARAMETERS IN NUMERICAL VALUE, NON MEASURABLE PARAMETERS PUT 'O' FOR OK & PUT 'Y' FOR NOT OK	
S.NO DATE	PROBLEM		ROOT CAUSE	ACTION TAKEN	STATUS
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FIRST OFF / MIDDLE OFF / LAST OFF / INSPECTION REPORT

DATE 7/12/22

QAD/F/02A

Rev Date 01.06 19Rev No.06

REMARKS SHIFT 15+ SAMPLE SIZE: LAST OFF INSPECTION TIME: ACTUAL MEASUREMENTS 100 (2nd setting) MIDDLE OFF INSPECTION Set up approval & first off approval to be carried by Line setter/Supervisor/QC inspector

Set up approval to ba carried out during setting change only. TIME: 210031-025 **OPERATION** 29.93 23.18 APPROVED BY: 0.07 0.98 66.91 3 27.15 12.77 45.0 19:10 60.5 015 0.31 H. FIRST OFF INSPECTION OS'. 36 PART NO: 94.99 1698 22.30 6.00 50.0 27.15 2,0% 45.0 23.49 3 55.0 , ; 210 2 ROUTE CARD NO: Master Gauge/Flush Pin Gauge V Block with Dial Profile Projector Profile Projector INSPECTED BY: METHOD OF INSPECTION Beval Protector DVC/Gauge CASE LINK ASSY STABLIZER BAR DVC/ Snap Gauge DVC/ Plug Gauge DVC/ DVC / Snap Gauge Slip Gauge VISUAL DVC REMARKS: ACCEPTED / ACCEPTED ON DEVIATION / SEGREGATION / REJECT DVC pitmark, damages, dents etc erack, burr, rust, seratch, SPECIFICATIONS, 23.50 ± 0.05 mm 16.97 ± 0.05 mm 27. 15 \pm 0.05 mm 19.1 ± 0.05 mm $C~0.3~\pm~0.1~\text{mm}$ $25.0 \pm 0.1 \text{ mm}$ R 0.5 ± 0.1 mm 22.2 ± 0.2 mm 4.1 ± 0.1 mm 1.0 ± 0.05 mm Free from 0.15 mm A ILJIN QUALITY ASSURANCE CUSTOMER NAME PARAMETERS Step Dia Meter Groov Width Apperance Chamfer Dia Concentricity Step Height Groov Dia Dimension Dimension **Bore Dia** Chamfer Radios Angle PART NAME SUNO 14 Note: 9 11 1.3 12 10 91

RETENTION PERIOD: 1 YEAR

	COSTOMER	CUSTOMER: ILJIN			Date of Origin			IO. 12.2010	07.11.22
Production Production		Key ContactiPhone		080-27809065	Key No / Date			1755	And the second s
210031-025	025	CFT Team	I MENT DA	AH STOWN OW	Customer Engine	Customer Engineering Approval/Date (if regd)	te (if reqd)		
NK ASSY,S	CASE-LINK ASSY,STABLIZER BAR	Supplier / Plant Approval / Date	ral (81	Customer Quality	Customer Quality Approval / Date (If reqd)	freqd)		JV
Supplier Code:	d ů	Other Approval / Date (II	NIC NIC		Other Approval / Date (If reqd)	Date (if reqd)			NIL
۴۴۴ Machine/Device/ Jig/ Tool for Mfg	No Product	Process Characteristic Spi Char	har Producti Process	Evaluation/ Measurement	Method	Fred	Sample	Responsibility	Reaction Plan
CNC M/C.ORR 2 ACE A ACE A ACE			NO SKRATCH, RUST, DENT &	Visu		ng / FML	SAR / FML	Setter & QC Line Inspector	BIN WITH
7, ACE 8, ACE 9	* Appearance	distribution and the second se	DAMMAGE	Visual	1 Every Hour	na / FML	HIR SAR / FML	Operator & QC Line Inspector Setter & QC Line Inspector	SEPAKATOR
Facing Tool Holder: Holder:	1 Step Diameter	Z	Ø27.15±0.05	D. Vernier D. Vernier /Gauge	1 Every Hour		HIR	Operator & QC Line Inspector	NO ton oi boddi
Insert: WINGGBG4GB	2 Groove Diameter		Ø25±0.10	D. Viring D. Vernier /spapiga	1 Every Setting / FML	ng / FML	SAR / FML HIR	Setter & QC Line Inspector Operator & QC Line Inspector	Reset the Programme
	3 Chamfer dia		Ø22.2±0.2	D. Vernier	1 Every Setting / FML	ng / FML	SAR / FML HIR	Setter & QC Line Inspector Operator & QC Line Inspector	parameter / Tool by Programmer / Setter
OD Grooving Toal Holder TTEL	4 Bore dia	7	Ø19.1±0.05	D. Vernier	1 Every Setting / FML	ng / FML	SAR / FML HIP	Setter & QC Line Inspector Operator & QC Line Inspector	
	d to Midth		4 1+0 1	D. Vernier	-	ng / FML	SAR / FML	Setter & QC Line Inspector	
			0000	D. Vernier /Slip Gauge	1 Every Hour	ng / FML	SAR / FML	Setter & QC Line Inspector	
Holder, SOLCL DIA16,AK-	7 Dimension		23.50±0.05	C. Vernier	-	ng / FML	SAR / FML	Setter & QC Line Inspector	2
T-06-0204		Manager of the state of the sta		D. Vernier /snap ga.	1 Every Setting / FML	ng / FML	SAR / FML	Setter & QC Line Inspector	
	1		1±0.05	D. Vernier		And the second s	HIR	Operator & QC Line Inspector	
	9 Radius	The state of the s	1 1.	Profile Projector	-	ng / rivil		Setter & QC Line Inspector	
	10 Concentricity		0 00.16 A.	V' Bíock with dail gauge	-	ng / FML	SAK / FML	Operator & QC Line Inspector	5
	11 Angle		51°±1°	Bevel Protragtor	-	ng / FML	SAR / FML	Setter & QC Line Inspector	ŭ
	12 Step Height	Z	16.97±0.05	Master gauge/Height ga/Dial ga	7	Every Hour	HIR	Operator & QC Line Inspector	agend A the old temperature a bit is depleted as the color of the colo
Į.	Machine Parameter	neter	In Between Min & Max	G. S. M.	1 Every Setui	Every Setup/ Shift Start	MCS	Check Machine Parameter	If Machine Parameter
Eunus/Eage,Wear offset No 9,Macro No :550		Lubricating oil level	In Between Min. & Max.	Visual		Every Setup/ Shift Start	MCS	Report Before run the	is not OK Reset
<	(A)	(PY) Clamping Pressure	√ 12-20 kg/cm²	Pressure Indicator		Every Setup/ Shift Start	MCS	Machine byOperator /	the Machine
3D Grooving TDC3 insert life: 400nos/ Edge, Wear 718		System Pressure	28 to 40kg/cm2 22	Pressure Indicator	1 Every Settii 1 Once/day	Every Setting / First Piece Once/day	MCS	Setter / line Supervisor	רמומוונופופו
0000	Process Parameter	eter	4 (0 0%				1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		
		OD Rough Machining speed	2500 ~ 3200RPM	(PPCS)		d	PPCS	Check Process Parameter	If Process Parameter
nos/Edge, Wear Offset No 29, Macro no 750.		OD Rough Machining feed	0.1-0.25 mm/rev	Drogramme		d	PPCS	Report Before run the	the Process
		OD Finishing Grooving speed	2000 ~ 3000RPM	00.00		d	2000	Machine by Operation	Darameter & Lick II
		OD Finishing Grooving Feed ID Rough Boaring speed	0.05-0.2 mm/rev 2000 ~ 3000RPM	No: 8900 (Fanuc) "PY"	1 Every Setup	d			5
(7 - Kavia Critical)		Sept and the sept	V5/0-20-0-0					00	T'NOQ
Monthly SPC to be carried out for 2	AND RESIDENCE OF THE PROPERTY AND PROPERTY A		(T)		(4)			1) Reject the part produced	
characteristics		+			J. (4)	(during power failure	
<u> </u>				7.1540.05		<u> </u>		2.) Use Drill Ø10.5 For	
Section of the Party of the Par			(2) (20,18] A	225401)FIT			Rough Drilling	
That	E STORY			\$25.0 A.D.A.				3.) Box Quantity: 300NOS.	
			(D) (A) (D) (A) (A) (A) (A) (A) (A) (A) (A) (A) (A	Ø19.1±0.05	Co	M		4)DO AIR BLAST EACH	10
		+			1	(IIME BEFORE LOADING OF TAIL	
760	#2000 #200 COM	+	337			2			Š
25	a programa		計		00+	\			
4	ne i i i e								
,	PY- POKAYOKE			12					
	Mademan				_			(0)) ()	
0075	THE REAL PROPERTY AND PERSONS ASSESSMENT OF THE PERSONS ASSESSMENT OF	THE RESERVE THE PERSON NAMED IN COLUMN TWO IS NOT THE PERSON NAMED IN COLUMN TWO IS NAMED I		The same of the sa	THE RESIDENCE AND ADDRESS OF THE PERSON NAMED IN COLUMN 2 IS NOT T	MANAGEMENT OF STREET OR STREET, STREET			THE REPORT OF THE PERSON OF TH