



- 1. EVERY SETTING SET THE PROCESS PARAMETER & MACHINE PARAMETER.
- 2. GET THE FIRST PIECE APPROVAL FROM QC
- 3. INSPECT THE PART DIMENSIONS AS PER WORK STANDARD
- 4. USE YELLOW PAINT FOR REWORK PART & FIX YELLOW TAG
- 5. USE RED PAINT FOR REJECTION PART & FIX RED TAG
- 6. WEAR SAFETY WEARS (GLOVES, MASK, SAFETY SHOES & ETC.,)
- 7. FOLLOW 3C STANDARD FOR FINISH PRODUCT

GAUGE CHECK POINTS

- 1. CHECK THE GAUGE CALIBRATION STATUS
- 2. MINIMUM SIX MONTH ONCE NEED TO RE- CALIBRATE

CI	ELF INSPECTION CONTROL	SELF INSPECTION CHECK SHE			ET NO.								
SELF INSPECTION CONTROL		SI / ILJIN / CASE / OP-90			0								
S.NO	PRODUCT PARAMETERS	DIMEN	NSION	SPECIAL	CHECK N	ETHOD	SAN	1PLE		CONTROL METHOD			
5•	TROBUCT FARAINETERS	2		CHAR.	CITECK	VILTITOD	SIZE	FREC	ე.	CHEC	K	RESP.	REACTION PLAN
*	APPEARANACE	NO SKRATCH , RUST, DENT & DAMMAGE			VISI	VISUAL		нои	JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
1	DIAMETER	Ø31.4±0.10 AS FORGED			VERNIER CALIPER		1 NO.	нои	JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
2	DIMENSION	15.03±0.02			PLUSH PI	N GAUGE	1NO.	нои	IR	HOURLY INSPECTION		PROD	INFORM TO SUPERVISOR
3	DIMENSION-2	24.1±0.2			VERNIER	CALIPER	1 NO. HOUR		JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
4	DIMENSION-3	19.0±0.5			VERNIER CALIPER		1 NO.	HOU	IR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
5	DIMENSION	6.53±0.05			FLUSH PI	N GAUGE	1 NO.	HOU	JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
6	DIAMETER	Ø22.1±0.02		Z	PLUG (GAUGE	1 NO.	HOU	JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
7	INNERDIAMETER-2	Ø28.03±0.05			VERNIER	CALIPER	1 NO.	HOU	JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
8	OUTER DIAMETER	Ø30.95±0.05			SNAP	GAUGE	1 NO.	HOU	JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
9	DIAMETER	Ø29.05±0.05		VERNIER CALIPER		1 NO.	нои	JR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR	
10	DIMENSION	0.5±	:0.1		VERNIER		1 NO.	нои	IR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
11	DIMENSION	1.5±0.1		VERNIER CALIPER		1 NO.	HOU	IR	HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR	
12	DIMENSION	18.85±0.05 VERNIE			VERNIER	CALIPER	1 NO.	HOUR		HOURLY INSPECTION REPORT		PROD	INFORM TO SUPERVISOR
REV.NO.							TE		NPD		PRODUCTION		QUALITY
1	TELEAGE						2018 2021 2021						
2							.2021	8					
3	INTERNAL SPC ADDED FOR Z (CRITICAL) CHARACTERITICS 10.11.3							PR					