DOCUMENT NO QA/PQCS/529 DATE08 05 2017 Rev No 01

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Quality Assurance Division Musashi Auto Parts India Pvt. Ltd.

Original to be retained untill:-

Honda Motor Co., Ltd. (Recieved)

## PROCESS QUALITY CHECK TABLE-I

Process Qualit	ty Control Table (I)						PROCESS QU
MODEL	KONA	DESIGNATION OF PARTS	HS	(HA)	НВ	OTHERS	
PART NUMBER	23121-KONA-D010						

MODEL	KONA	DESIGNATION OF PARTS	HS (F	на нв отн	HERS	1			Approved Confirmed by by	Create		BL BL	BL B	SL.
PART NUMBER	23121-KONA-D010					250			Dy Dy	by				
PART NAME	GEAR PRIMARY DRIVE								10 the Charles	100	-			
						J	r							
Pf	ROCESS FLOW CHART							1		CONDITION OF COMP				
	-			60	CARBURISING		SL No	PART NO	PART NAME	OUTSOURCING	ORDER STATUS	DUSE	MAKER NAME	
		MATERIAL STORAGE								N-		40	BHAGWAN AUT	· · · · · · · · · · · · · · · · · · ·
	V	THE THE STATE OF STAT						1 23121-K0NA-D010 2 23121-K0NA-D010	GEAR PRIMARY DRIVE GEAR PRIMARY DRIVE	v .			SONIA FORGIN	
	^							3 23121-K0NA-D010	GEAR PRIMARY DRIVE	N			AMTEC	
	10	DESCRIPTION OF THE PROPERTY OF		C04			-							
		RECEIVING INSPECTION			POST WASHING									
	Ŏ			Ó										
	<u></u>													
	(20)	45.0444.		70										
		KEYWAY BROACHING			TEMPERING	8								
	Ō			Ó										
	30	Henrika		C05										
		HOBBING			SHOT BLASTING		-	1						
	Ô			V										
	40	SHAVING		Ş										
		SILVING		<b>*</b>				1						
	17			Ó						1				
	Y													
	C)			(an)	HONNING	8	-	l						
	\$				HONNING									
	•			Ó										7
	(7)						-							
	50	JIG SETTING/CONDITION		(006)	WASHING			-						
		CHECKING			WAGIIIIG									
	0 .			0 .							-			
									(3)				•	
	(C02)	PRE WASHING		90							-			
					ROLL TESTING								18/	
	Ĭ			Ų			-							
					PACKING & DISE	PATCH								
	( co3 )	PRE HEATING					V							
	3.50				ě			100				*1		
		-												
	Flow process	chart symbols shall confirm	m to JISZ82	06 (Composite symbol : combine s	sub job symbol	in main job symbol)	а	10.02,2019	K0NA-E-118, PP-1 RELEASE	UMASANKAR	PRASHANT H	ARUN		
. 0	PROCESS	QUANTITY CHECK	<b>(-</b>	CROSS PART OF FLOW LINE	$\Diamond$	MAINLY AS INSPECTING QUALITY AND DOING QTY INSPECTION	3	12.09.2018	K0NA-E-103, PP-0 RELEASE	UMASANKAR	PRASHANT H	ARUN	QUALITY ASSURA	ANCE
0	TRANSPORT	QUALITY CHECK	W	CONTROL DIVISION OF FLOW CHART	(1)	PREVIOUS PAST TROUBLE HISTORY				APPROVED BY	CHECKED BY	PREPARED BY		
$\triangledown$	STORE	FLOW CHART	0	MAINLY AS PROCESSING PARTS AND DOING INSPECTION			CODE	DATE	REVISION RECORD		CREATION DIVISION	<u> </u>	DEPARTMENT CHE	OKED

## PROCESS QUALITY CHECK TABLE-II

MFG	PROCESS NAME EQUIPMENT NAME		QUALITY CHARACTERSTICS												PRODUCTION CONDITION CONTROL Equipment Die Fail safe equipment oil pressure voltage Jemprature and others								
ORDER	(SUPPLIER NAME)	SINO	FAILURE MODE	CRITICAL ITEM	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	SINO	CRITICAL	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	ILLUSTRATION		
		(3			Material	SCr420HV	QA	Supplier MTC (Latest by 6 months)	AS PER SAMPLING PLAN	Each Lot	INCOMING INSPECTION REPORT							,(e)		-4			
		2			Hardness	80~95 HRB	. 1	Hardness lesler	818	Ť "	1												
		3			Appearance	free from Burr dent damage & scraches etc	i	Visual	it:	Ť	1												
		4			Microstructure	Uniform distribution of famile & pearlife bainite 25% max	•	Microscope	1	Ť	†												
		5		$\Diamond$	Diameter	Ø18 950+0 02	î	Internal micrometre/Bore gauge	t	1	1												
		36			Roughness	Rz 12 5	Ť	Roughness tester	Ť	1.	†												
		7			Diameter	Ø39 4-0 05/-0 15	t	D V C/Micrometer	1	İ	1												
		8		<b>\Q</b>	Runout	0 05 wrt B	1	Mandrill, Dial & Bench centre	4	Ī	i												
	11	9			Roughness	Rz 100	t	Roughness tester/Visual	t	†	Ť												
		10			Roughness	Rz 12 5	ı	Roughness tesler	t	Ť	1												
		11		$\Diamond$	Dimension	13 5+0 05/+0 15	1	D V C/Height gauge	t	1	t												
	(4 DECEMBED	12		$\Diamond$	Parallelism	D 02	1	Height gauge	1	Ť	1												
10	RECEIVING INSPECTION	13			Runoud	0.02 wrt B	1	Mandrill, Dial & Bench centre	1	1	1												
		14			Roughness	Rz 12 5	1	Roughness Lester	t	†	1												
		15			Charmfer (both side)	C0.5+0.2	t	Contour	t	ţ-	1			0									
		16			Chamfer (both side)	C0 5+0 2	t	Contour	t	Î	1												
		17			Supplier identification	Supplier A: Dirnension 4+0 2 Supplier B Dirnension 4-0 2 Supplier C Feed mark on chamfer-1 as shown	t	Contour/Visual	1	ţ	İ												
		18		$\Diamond$	Runout (On Ø26 circumf)	0 02 wrt 8	1 2	Mandrill, Dial & Bench centre	1	, t	18												
		19			Diameter	Ø26 +0 3	†	DVC	t	Ţ	†												
		20			Dimension	0.1~0.3	†	Contour / DVC	1	t	1												
		21			Radius	R	†	Visual/Contour	Ť	Ť	1												
		22			Dimension	2-25	†	Contour / DVC	Ť	†													
		23			Dimension	4±0 2	t	Contour / DVC	Ť	†	Ť						•			,			
9*		24			Condition	This face & bore should be made in same setup	t	Controle plan	t	Ť	†						2						
		25			Hazardous or ELV	Hazardous items should be within limit	t	ELV or Hazardous report	t	Ť	†				-								
		1		$\Diamond$	KEY WAY WIDTH	4 04~ 4 06	LINE ASSOCIATE	SLIP GAUGE	5/SETUP & TC	5/SETUP & TC	SETTING APPROVAL SHEET LOT CONTROL & INSPECTION CHECK	1		RESTING FACE	NO DENT	LINE ASSOCIATE	VISUAL	1/100	-	- 446			
	× .				1	ок	1	SPLINE GAUGE	1/10	1/10	SHEET	2		LUBRICATION PRESSURE	1.4-1.8 Mpa	LINE ASSOCIATE	PRESSURE GUAGE	1/SHIFT	1/FIRST SHIFT	EQUIPMENT CHECK SHEET	AMETERS 404-406 4005-212 4004		
		2		<b>♦</b>	KEY WAY DEPTH	21 05-21 2	116	VERNIER CALIPER	5 /SETUP & TC 1/50	5 /SETUP & TC 1/50	1	3		AIR PRESSURE	0.4-0.6 Mpa	LINE ASSOCIATE	PRESSURE GUAGE	t,	_ †	t	CONTROL PARAMETERS KEYWAY WIDTH = 21.05-PLZ KEYWAY DEPTH = 21.05-PLZ SYMMETRYCTY = 0.003		
24		3			SYMMETRICITY	≤0.04	, t	SLIP GAUGE & DIAL INDICATOR	5 /SETUP & TC	5 /SETUP & TC	†										ATENTI POR PARTITION OF THE PARTITION OF		
20	KEYWAY BROACHING				1	ок	1	SPECIAL GAUGE	1/10	1/10	ţ										YWAY Y		
		4			KEY WAY TAPER	≤0 03	t	V-BLOCK & DIAL INDICATOR	t	t	t					5:					0 0 0 0		
					SURFACE ROUGHNESS	Rz25	QA	ROUGHNESS TESTER	1 /SETUP & TC	1 /SETUP & TC	SETTING APPROVAL SHEET									-			
		5			t	ок	1	1	t	1	1												
	-1				APPERNACE	NO DENTS & BURRS	LINE ASSOCIATE	VISUAL	100%	****	-												
	R	ê		₩	1	NO DOUBLE OPERATION/ NO OPERATION MISS	t	Ť	†					,			-						

## PROCESS QUALITY CHECK TABLE-II

AFG.	PROCESS NAME EQUIPMENT NAME					QUALITY	CHARACTERSTICS			PRO	PRODUCTION CONDITION CONTROL  equipment, oil pressure, voltage, temprature and others  Equipment Dia, Fail safe										
RDER	(SUPPLIER NAME)	SINO	FAILURE MODE	CRITICAL ITEM	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	SI NO.	CRITICAL	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	ILLUSTRATION
		1		$\wedge$	OBD (BALL Ø 3 175mm)	Ø39 450~39 480	LINE ASSOCIATE	OBD MICROMETER/OBD FIXTURE	5/SETUP &TC	5/SETUP &TC	SETTING APPROVAL SHEET LOT CONTROL &	1		TAIL STOCK CLAMPING PRESSURE	6-7 5 Mpa	LINE ASSOCIATE	PRESSURE GAUGE	1/SHIFT	1/FIRST SHIFT	EQUIPMENT CHECK SHEET	14 3
			- 1		†	İ	1	Î	1/5	1/10	INSPECTION CHECK SHEET	2		ONE TOUCH ARBOR R/O & DIA WEAR LIMIT	0 005 & Ø18 93 -0 025/-0 035	†	BENCH CENTER & MICROMETER	,	1	Ť	CTH = 19
		2		$\Diamond$	PCD RUNOUT	s0 035	t	PCD TESTER	5/SETUP &TC	5/SETUP &TC	•	13		HOB ARBOR RIO	0 005 MAX	1	DIAL INDICATOR & MAGNETIC STAND	1.	1	EQUIPMENT CHECK SHEET X R CHAET	ARAMETE VOOF TE
				V	Ť	· †	1	Ť	1/50	1/50		9		BASE CENTER & WORK ARBOUR TAPER	NO DENTS	ì,	VISUAL	Ť	1	EQUIPMENT CHECK SHEET	E. O. P.
		3			PROFILE	12µмах	QA	GEAR TESTER	1/SETUP & TC	1/SETUP & TC	SETTING APPROVAL SHEET & GRAPH										CON PADDUE ELTX ANG
0	HOBBING				1	Ť	t	1	1/10	1/10	1										0 0
		4			LEAD	14µMAX	t	Ť	1	1	T										
		5		×	ROOT DIAMETER (AS SHOWN IN FIG)	Ø30 € <sup>0-3</sup>	LINE ASSOCIATE	VERNIER CALIPER	5/SETUP & TC 1/50	5/SETUP & TC 1/50	SETTING APPROVAL SHEET  LOT CONTROL SHEET &										
		6			TOOTH SURFACE	RZ 25 MAX	Q.A.	ROUGHNESS	1/50 1/SETUP & TC	1/50 1/SETUP & TC	INSP CHECK SHEET SETTING APPROVAL										
					ROUGHNESS		LINE ASSOCIATE	TESTER	100%	INSERT & IC	SHEET										
		7			t	NO DENTS & BURRS NO DOUBBLE OPERATION	t	†	t	9 <del>-0</del>	3,000										
				$\Diamond$	O8D (# 3 175)	39.250-39.280	LINE ASSOCIATE	OBD MICROMETER/ OBD FIXTURE	5/SETUP & TC	5/SETUP & TC	SETTING APPROVAL SHEET	1	$\Diamond$	TAIL STOCK CLAMPING PRESSURE	2-4 Mpa	LINE ASSOCIATE	PRESSURE GAUGE	1/SHIFT	1/FIRST SHIFT	EQUIPMENT CHECK SHEET	
	20	1		V	t	t	†	t	1/5	1/10	LOT CONTROL & INSPECTION CHECK SHEET	2	$\Diamond$	FIXTURE CONDITION	NO DENTS/WEAR	t	VISUAL	t	1	1	
		2		$\Diamond$	PCD RUNOUT	s0.025	t	PCDRIO TESTER	S/SETUP & TC	S/SETUP & TC	#P	3	$\Diamond$	MASTER WORK R/O	0 010 MAX	1	DIAL INDICATOR & MAGNETIC STAND	t	t	t t	
					†	1	t	t	1/60	1/50	t	3	$\Diamond$	CUTTTER FACE RIO	0 005 MAX	†	†	t	t	1	Talkelow /
	SHAVING	3			PROFILE	AS PER TABLE	QA	GEAR TESTER	1 /SETUP & TC	1/SETUP & TC	SETTING APPROVAL SHEET										
	SHAVING				T .	1	t	†	1/10	1/10	†										
		4	10		LEAD	<u>†</u>	t	t	†	1	1										
		5		MQS	TOOTH SURFACE ROUGHNESS	≤ Rz 6.3	QA .	ROUGHNESS TESTER (ALONG PROFILE)	1/SET UP & TC	1/SET UP & TC	SETTING APPROVAL SHEET				٠.			14			*
		6			APPEARANCE	NO DENTS & BURRS	LINE ASSOCIATE	VISUAL	1/50	=-	-										
			_		1	NO UNCLEAN	İ	†	†	=7	=										D.
Δ		1			JIG SETTING OF CAMPONENT	SEE NOTES	LINE ASSOCIATE	VISUAL	18.01	=	-	- 21		BASE TRAY	NO CRACK BEND,DAMAGE	LINE ASSOCIATE	VISUAL	1/LOT			
•	JIG SETTING / CONDITION CHECKKING	2			SETTING CONDITION	NO COLLAPS	t	t	t	=	=	2		STACKING BASKET	1	t	†	†			
		3			APPEARANCE	NO DENTS &DAMAGE NO OPERATION MISSED	Ť	t	100%	44		3		MESH	1	1	†	1	**	0.75	
	FRE WASHING & POST	1			APPEARANCE	NO OIL, NO DIRT ON THE COMPONENT	LINE ASSOCIATE	VISUAL	100%		v.##						FOR NACIONAL MACHINE				
1004	WASHING											1		TEMPRATURE	110±10°C	LINE ASSOCIATE	DIGITAL TEMP INDICATOR	1/SHIFT	1/FIRST SHIFT	EQUIPMENT CHECK SHEET	
		1			JIO SETTINO	SEE NOTE-2	LINE ASSOCIATE	VISUAL	100%	===	1-3	2		WASHING TIME	20±5 MIN 400±10°C	LINE ASSOCIATE	TWER  CONTROL METER	1/LOT EACHLOT	1/LOT EACH LOT	EQUIPMENT CHECK SHEET EQUIPMENT CHECK	*.
								-				2		PRE HEATING SCAKING TIME	110±10 MINUTES	LINE ASSOCIATE	TIMER	EACHLOT	EACHLOT	SHEET	
03	PRE-HEATING								201			3		HEATING VOLTAGE	350-450V	LINE ASSOCIATE	VOLTMETER	EACHLOT	EACHLOT	†	
												.4:		HEATER CURRENT	50-75A	LINE ASSOCIATE	AMMETER	EACH LOT	EACHLOT	1	

## PROCESS QUALITY CHECK TABLE-II

IFG	PROCESS NAME														PRODUCTION CONDITION CONTROL  Equipment,oil pressure, voltage, temprature and others  Equipment, oil pressure, voltage, temprature and others										
DER	(SUPPLIER NAME)	SI,NO.	FAILURE MODE	CRITICAL ITEM	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	SI.NO.	CRITICAL	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	ILLUSTRATION				
		1		♦ Mgs	CASE DEPTH	0.3-0.5 MM	QA	MICRO VICKERS (CLIT. OFF, 513 Hv LOAD 0.3 KG)	1/LOT	14LOT	OCF PROCESS CONTROL SHEET						FOR CCF		7						
		2		$\Diamond$	HARDNESS OF TOOTH FLANK (0.1MM FROM THE SURFACE)	720-800 HV (300g) (TARGRT 750 MIN.)	İ	Ĩ	†	†	Ť	1	<b>♦</b>	CARBON POTENTIAL	REF. CYCLE DIAGRAM	t	CP CONTROLLER	EACH LOT	EACHLOT	CCF PROCESS CONTROL SHEET					
		3			SURFACE HARDNESS(BEFORE TEMPERING)	80-85 HRA (REFERENCE)	Ť	ROCKWELL HARDNESS TESTER (LOAD 60NG)	10/LOT	19A.OT	Ť	2	<b>♦</b>	CARBURISING TEMP	880°C±10°C	t	CONTROL METER	t	1	t					
		4		♦ MQS	SURFACE HARDNESS(AFTER TEMPERING)	78-83 HRA	†	†	Ť	Ť	Ĭ	3	<b>♦</b>	CARBURISING TIME	50±5 MINUTES (3 ZONES)	1	RECORD METER	t	1	t					
		5		♦ MQS	CORE HARDNESS	25-46 HRC	†	ROCKWELL HARDNESS TESTER (LQAD 150KG)	14.01	1/LOT	†	4	<b>♦</b>	HARDENING TEMP	840°C±10°C	1	CONTROL METER	t	1	1					
0	CARBURSING &TEMPERING	6		$\Diamond$	MICRO STRUCTURE AT SURFACE	MARTENSITE ABOVE C CLASS	t	MICROSCOPE	1	† -	t	3	<b>♦</b>	HARDENING TIME	30±5 MINUTES	t	RECORD METER	†	t	1					
		7		$\Diamond$	MICRO STRUCTURE AT CORE	LOW CARBON TEMPERED MARTENSITE	t	MICROSCOPE	t	†	t		<b>♦</b>	QUENCH OIL TEMP	140°±10°C	1	CONTROL METER	†	1	t					
		8			APPEARANCE	FREE FROM OIL	LINE ASSOCIATE	VISUAL	EACHLOT	-		7	<b>♦</b>	QUENCHING TIME	10±5 MINUTES	Ť	RECORD METER	†	1	ţ.					
									, ×				<b>\Q</b>	AGITATOR RPM	нон	1	INDICATOR	†	1	1					
								,				9	<b>\Q</b>	TEMPERING TEMP	170°C±10°C	t	CONTROL METER	t	1	t					
												10	<b>♦</b>	TEMPERING TIME	3545, MINUTES (4 ZONES)	†	RECORD METER	1	1	1					
		1			APPEARANCE	PARTS SHOULD FRBE FROM SCALES, BURRS AND SHOTS	LINE ASSOCIATE	VISUAL	100%	3400	3e 3t	74		SHOT BLASTING TIME	5- 20 MINUTES	LINE ASSOCIATE	TIMEN	EACH LOT	287	724	8				
												2		AIII PRESSURE	S ~ 6 RG/DN <sup>3</sup>	LINE ASSIDCIATE	PRESSURE GALIGE	1/SHIFT	1/FIRST SHIFT	EQUIPMENT CHECK SHEET					
	SHOT BLASTING											-16	12	APPELLER MOTOR CURRENT	12 - 20 A FOR M/C 265602 & 265000	1	AMMETER	1	1	.↑					
														IMPELLER MOTOR CURRENT	8 - 15 A FOR M/C 265004,265005	1	AMMETER	1	1	1					
												15		ED MOTTOR CLANIENT	20 A MAIL FOR M/C 265003 & 265004,265005		AMMETER	1	1	1					
														MANGMETER REPOING	PSG 13 MAX	1	MANDALTIA SCALE	1	<b>↑</b>	1	-				

1FG	PROCESS NAME EQUIPMENT NAME	QUALITY CHARACTERSTICS											PRODUCTION CONDITION CONTROL  Equipment Die Fail safe equipment on pressure voltage temprature and others								
RDER	(SUPPLIER NAME)	SI NO	FAILURE MODE	CRITICAL ITEM	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	SI NO.	CRITICAL ITEM	CONTROL ITEM	SPECIFICATION	PERSON IN CHARGE	CHECK METHOD	MEASURING FREQUENCY	RECORDING FREQUENCY	CONTROL METHOD	ILLUSTRATION
				$\Diamond$	BORE DAMEYER	Q15-01-0-00	LINE ASSOCIATE	PLUG GAUGE	5 CASSATE ATC	5 CASSATE &TC	SETTING APPROVAL SHEET		ò	FOCTURE CONCETTON	NO DENTE 4 DAMAGES	LINE ASSOCIATE	VIIUAL.	SHEET	18951 SHFT	EQUIPMENT CHECK SHEET	
	(4)	7,4		Mos	1	Ť	+	AIR PLUG GAUGE	100%	1/10	LOT CONTROL L INSPECTION CHECK SHEET	2	٥	HITMAUUC PRESSURE	504 MPs	t	PRESSVIR GAUGE	1	1	,	
					BORE SURFACE ROUGHNESS	Rz E3 MAX	O.A.	ROUGHNESS TEXTER	1)CADSATE STC	1/CASSATE &TC		3	0	IP O PRESSURE	1013MPs	ĵ	1	,	1	1	
		2		MOS	02	ť	1	1	1/SHIFT	NOME	SETTING APPROVAL SHEET LOT CONTROL & INSPECTION CHECK SHEET										
		3			OVALITY	at 003	1	AIR PLUG GANGE	SICASSATE BTC	S/CASSATE &TC	SETTING APPROVAL SHEET										
		4			TAPER	#0 kb3	,	•	100%	1/10	LGT CONTROL & NEPECTON CHECK SHEET										
	HONING	5			ROUNDNESS	att 003	QA.	ROUNOMESS TESTER	1.CASSATEATC	1/CASSATEATC	SETTING APPROVAL SHEET										
					FACE R/O	20:03	¥	TAPER MANDREL & DAL	5 /CASSATE &TC												
		6				•	,	INDICATOR		5./CASSATE ATC	SETTING APPROVAL SHEET  LOT CONTROL &										
-				$\Diamond$		'		<u> </u>	166	1/50	INSPECTION CHECK SHEET										
		7		MQS	PCD RUNOUT	s0.002	-1	PCD TESTER	5 /CASSATE &TC	5 /CASSATE &TC	SETTING APPROVAL SHEET										
					1	f	1	t	1/50	1/50	LOT CONTROL & INSPECTION CHECK SHEET	in.									
		8		MQS	APPERNACE	NO DENTS & BURRS	LINE ASSOCIATE	VISUAL	100%	=	100										
1		Ŧ			APPEARANCE AFTER WASHING	CLEAN & DRY COMPONENT WITH NO DRY	LINE ASSOCIATE	VISUAL	1/TRAY	=	35	1	<b>\</b>	DRY TANK PRESSUR		LINE ASSOCIATE				EQUIPMENT CHECK	
		2			APPEARANCE AFTER ANTI- RUST OIL APPLICATION	COMPONENT FULLY COVERS WITH OIL		VISUAL	100%	-		2	<b>♦</b>	CLEAN TANK	2-3 lug/cm <sup>2</sup> 13-15 KG/CM2	†	PRESSURE GUAGE	1/SHIFT	1/FIRST SHIFT	SHEET	
07	WASHING	3		<b>♦</b>	CONTAMINATION AS PER HINSI-SOM	SEE NOTE-1	OA.	MILLIPORE	1.MONTH	1/MONTH	LOG BOOK	3	<b>♦</b>	PRESSURE  CLEANING AGENT	60°c-60°c	1	TEMPRATURE CONTROLLER	†	†	-	
												4	<b>\Q</b>	TEMPRATURE HOT AIR TEMP	90°c~80°c		DISPLAY.  TEMPRATURE CONTROLLER	<u>'</u>	1	+	
												5	<b>\Q</b>	CLEANING AGENT		†	DISPLAY	1		1	
					TOE	s0 04 mm	LINE ASSOCIATE	DIAL INDICATOR	1/SETUP & TC	1/SETUP & TC	SETTING APPROVAL SHEET			CONCENTRATION  LOCATOR WEAR	3%-5% @18.990-18.895	LINE ASSOCIATE	REFRACTOMETER  OD MICROMETER	164	144	FIXTURE CALIBRATION SHEET	
		1			ja .	t	. f	7	100%	1/10	LOT CONTROL & INSPECTION CHECK SHEET	2		MASTER GEAR	NO DENTS & NO BURRS	•	VISUAL	MART	1/FIRST SHIFT	EQUIPMENT CHECK	I. ENSURE NO DENTS, NICKS AND BURRS ON THE GEAR FACE, IN THE REPAIRING DENTS/NICKS AND BURRS ON THE GEAR FACE USE PRIDER DIANDING FILE DURING THIS PRICESS FILE MARKS ARE NOT ALLOWED ON DK. FACES.
		2			NICK MARKS	NO RECK MARKS	t	VISUAL	100%		-	3		FIXTURE BOLT LOOSING CHECK	NO LOOSING	†	MANUAL CHECK	•	+		NO DENTS: PAIRING DEN DPCR DIAND ALLOVED
		3			DIRECTION OF ROTATION OF COMPONENT	FIRST C.W THEN COW	t		†		-			8		'					NICKS ANI NIS,NICKS I NID FILEDU INI DK FAI
		4			APPERANCE	NO DENT NO BURR SEE NOTE 2				:=	-										DURRS ON BURRS RING THIS
	ROLL TESTING							J <sub>0</sub>	I												ON THE GEAR PROCESS F
		5		₩	CENTER DISTANCE	80 003 ±0 029	i.l.	DIAL INDIACTOR &	Ť		SETTING APPROVAL		(4		MASTER GEAR		VERIFICATION FROM	ONOCALDA			R FACE. EAR TACE TILE MARKS
				Ψ		an see		MASTER DISC SET		1/SET UP & TC	SHEET	1		MASTER GEAR	PARAMETERS	QA ASSOCIATE	MASTER GEAR MANUFACTURER DRAWING	ONCE/NEW MASTER GEAR	ONCE/NEW MASTER GEAR	SUPPLIER MASTER GEAR DRAWING	
						KEYWAY BROACHING				\ <del>4</del> 4	-										
					OPERATIONS	HOBBING	·			725	=										
		6			COMPLETED	SHAVING	i.	VISUAL	100%	1,50	275										
						HONING				:						ř.			_		
-	PACKING &	-	_																		