RULE

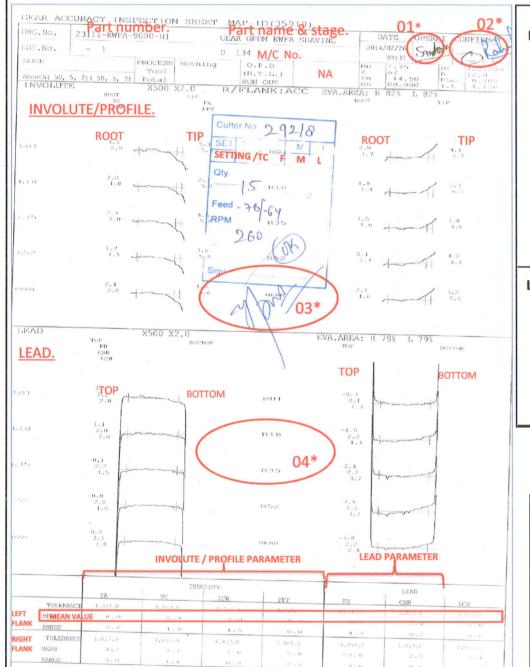
Lead and Profile Graph Check / Judgemnet Rule (Process - Shaving)

ISD-QA-030

DATE :27.02.14 Issue 01 Rev. 00

Tooth Profile at Shaving Process Judgement Standard 2W Decision rule at Shaving Process on the actual pattern of lead /profile.

Note: First check pattern if found OK then verify value of Lead & Profile parameters against the specification given in Process Sheet.



7	PROFILE [NG]	(-) (+)						+
			Tooth root step Effective length of the SV is short(Trochoid interference)	Bulged of the tooth root. SV profile not good	Big concave at middle SV profile not good	Big bulge profile SV profile not good	High waviness SV profile not good	Bend at middle SV profile not good
			+					
	2		Average pressure angle minus (Finish parts) (Tooth tip is up)	FFT minus (Tooth tip is up) SV profile not good	Tooth tip dent or tip bulging	Big FFT SV profile not good	High variation in FA Teeth R/O, Before SV teeth R/O, End face R/O	
	LEAD [NG]					-		
			Big FH	Crowning minus SV profile not good	Big crowning SV profile not good	Tooth end face dent or end face bulging	High waviness Cutter mark	High variation in FH Teeth R/O, End face R/O

Responsibility Matrix for signing the Lead Profile Graph						
Sign.	Section	For Set up	For Mass Prod.			
1*	Standard Room(QA)	0	0			
2*	Operator /Line leader/Shift Engineer-Prod.	0	0			
3*	Inprocess-QA	0	X			
4*	Section Head(Prod.) in case on any abnormality found.	0	0			
O- Applicable , X-Not Applicable						

Teeth Profile Evalation<SV process >

Lead & profile will have to evaluate based on actual pattern as per graph check rule and value according to process sheet.

Decision to be taken as per the responsibility matrix .

0 27.02.2014 New Releases
Rev.No. Date Description

Prepared By : Gurmukh Singh

Checked By: Navender San/DKD San

Approved By : Matsui San / Sandeep Kalia San

RULE

Lead and Profile Graph Check / Judgemnet Rule (Final)

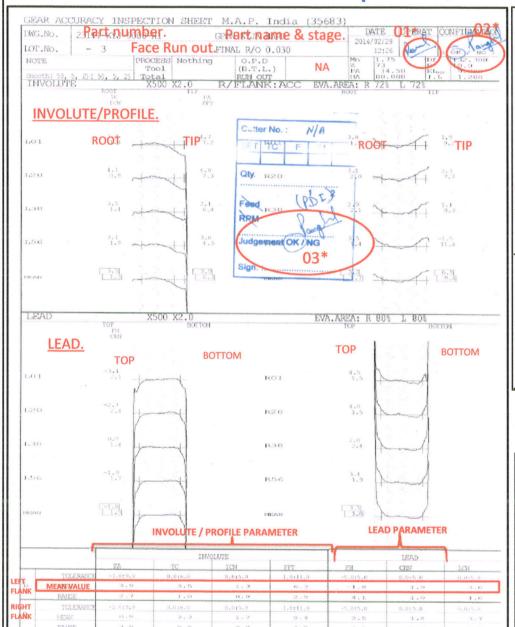
ISD-QA-031

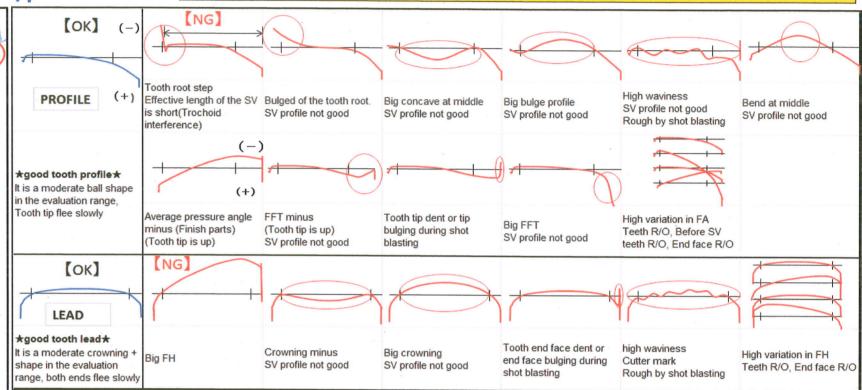
DATE :28.02.14 Issue 01 Rev. 00

Tooth Profile at Final Judgement Standard 2W

Decision rule at Final on the actual pattern of lead /profile.

Note:-First check pattern if found OK then verify value of Lead & Profile parameters against the specification given in Customer product drawing





Sign.	Section	Mass Prod.
1*	Standard Room(QA)	0
2*	Shift incharge PDI-QA	0
3*	Section Head(PDI-QA) in case on any abnormality found.	0
O - Appl	icable, X-Not Applicable	

Teeth Profile Evalation<Final >

Lead & profile will have to evaluate based on actual pattern as per graph check rule and value according to Customer Product Drawing.

Decision to be taken as per the responsibility matrix .

0 28.02.2014 New Releases

Rev.No. Date Description

Prepared By : Gurmukh Singh

Checked By: Navender San/DKD San

Approved By : Matsui San / Sandeep Kalia San