QA MATRIX SHEET

KONA

Model

Part 14101-K0NA-D000 - no. H1

Part

Date 28.02.2018

SHAFT COMP CAM

XPQCS / FMEA Sheet must be attached

DCN KONA-E-109

Supplier name

MAP -BLR

 Total
 Category
 Nos ≥ 1.33
 Cp/Cpk ≥ 1.33
 Double or More Check
 PAC-V OK NG

 2
 Measurable
 - - - - OK
 -

 Non Measurable
 2
 2
 OK
 -

Supplier

HMSI

Quality Head	In charge
PRASHANTH	SHIVA

Approved by	Checked by

	rocess-based, please write ere is a change in the new	PQCS ≪Base p □Base Model □Base Plant	rocess flow»	RECEIVING INSPECTION OF CHILD	PARTS (ASSEMBLY) CHILD PART MANUAL	ASSEMBLY BEARING ASSY	FLANGE ASSY	FINAL INSPECTION									«Change point Detail of chang		"					
	ess (Use V for marking)	PQCS «New p New Model New Plant New Supplier	rocess flow»	RECEIVING INSPECTION OF CHILD	PARTS (ASSEMBLY) CHILD PART MANUAL	ASSEMBLY (ASSEMBLY) BEARING PIN DOWEL PRESSING		FINAL INSPECTION																
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		Die Mainter						-									Specific information							
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	ned process	Jig and Fixtu Mfg. Tools Insp. Tool	re																					
1)No c	change from base - ●	Mfg. Tools						-						1			_							
2)Ther	re is a change from base - 🖈		ining	- +	 *	*		 ★																
<u>-) 111e1</u>	ie is a ciialige Hulli nase - 🛪	bOC2	15	×	*	*	-	<u>*</u>																
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QA MATRIX SHEET

14101-K0NA-D000 -H1

28.02.2018

SHAFT CAM

※PQCS / FMEA Sheet must be attached

DCN KONA-E-109

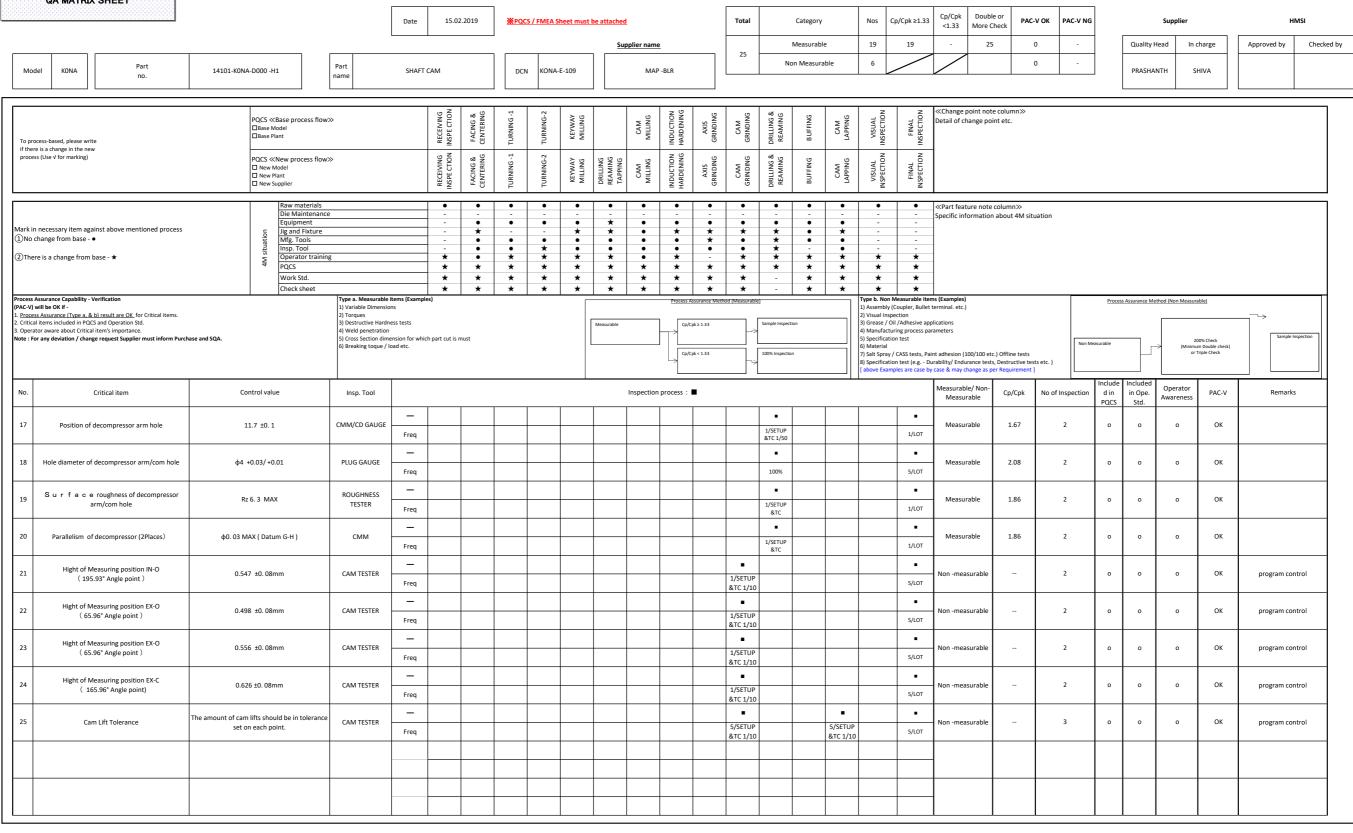
Supplier name

Category Nos Cp/Cpk ≥1.33 Cp/Cpk Double or <1.33 More Check PAC-V OK PAC-V NG 25

			12.55	Work Check							_
Measurable	19	19	-	25	0	-	Quality Head	In charge	Approved by	Checked by	
Non Measurable	6			6	0	-					

To process-based, please write if there is a change in the new	PQCS «Base process flow» Base Model Base Plant	>		RECEIVING INSPE CTION	FACING & CENTERING	TURNING -1	TURNING-2	KEYWAY		CAM MILLING	INDUCTION	AXIS GRINDING	CAM GRINDING	DRILLING & REAMING	BUFFING	. CAM LAPPING	VISUAL	FINAL	«Change point note co Detail of change point of							
process (Use v for marking)	PQCS «New process flow» New Model New Plant New Supplier	>		RECEIVING INSPE CTION	FACING & CENTERING	TURNING -1	TURNING-2	KEYWAY	DRILLING REAMING TAPPING	CAM MILLING	INDUCTION HARDENING	AXIS GRINDING	CAM	DRILLING & REAMING	BUFFING	CAM LAPPING	VISUAL	FINAL								
Mark in necessary item against above mentioned process ①No change from base - ◆ ②There is a change from base - ★	Raw materials Die Maintenance Equipment Of Jig and Fixture Mig. Tools Jinsp. Tool Operator training POCS Work Std. Check sheet			- - - - * *	- - - + - - - - + * * *	- - - + *	- - - * * *	* * * * * *	* * * * * * * * * * *	- - - - - - - - - - - - - - - - - - -	* * * * * *	* * * *	- - * * * *	* * * *	- - - - * *	* * * * * * *		- - - - * *	«Part feature note col Specific information ab		,					
Process Assurance Capability - Verification (PAC-L) will be OK if - 1. Process Assurance (Type a, & b) result are OK, for Critical items. 2. Critical items included in PQCS and Operation Std. 3. Operator aware about Critical item's importance. Note: For any deviation / change request Supplier must inform Purchase a	and SQA.	Type a. Measurable ite 1) Variable Dimensions 2) Torques 3) Destructive Hardnes 4) Weld penetration 5) Cross Section dimens 6) Breaking toque / loa	s ss tests nsion for which		ust				Measurable		Cp/Cp	ssurance Metho pk≥1.33 pk<1.33	d (Measurable	Sample Inspection			1) Assembly (C 2) Visual Inspe 3) Grease / Oil 4) Manufacturi 5) Specification 6) Material	ction /Adhesive app ing process par n test	terminal. etc.)) Offline tests	Non Mez		s Assurance Me	→ (Minimu	able) 30% Check m Double check) Friple Check	Sample Inspection
No. Critical item	Control value	Insp. Tool								Inspection	n process : I	•					To I Specification	rtest te.g Du	Measurable/ Non- Measurable	Cp/Cpk	No of Inspection	d in PQCS	in Ope. Std.	Operator Awareness	PAC-V	Remarks
1 INDUCTION HARDENING	0.5~3.0	EYE PIECE VERNIER CALIPER	— Freq								1/SETUP &TC 1/S							1/LOT	Measurable	3.59	2	0	0	0	ОК	Destructive Item
2 HARDNESS	HRC50∼60	ROCKWELL HARDNESS TESTER	— Freq								4/SETUP &TC 5/S							1/LOT	Measurable	4.86	2	0	0	0	ОК	Destructive Item
3 HARDNESS s	easure the hardness distribution with Micro Vickers and check the distance from the surface of the hardened layer to the point iere the hardness is the same as the internal	MICROVICKER	— Freq								1/SETUP &TC 1/S							1/LOT	Non -measurable		2	0	0	0	ОК	Destructive Item
4 Total runout of sprocket installation (φ19. 8 area)	hardness. 0.05 MAX(Datum G-H)	HEIGHT GAUGE & DIAL	 Freq		5/SETUP &TC 1/50													■ 5/LOT	Measurable	1.46	2	0	0	o	ОК	
Surface roughness of sprocket installation (φ19. 8 area)	Rz 12.5 MAX	ROUGHNESS TESTER	— Freq		1/SETUP &TC													■ 1/LOT	Measurable	1.76	2	0	0	0	ОК	
6 Outer diameter of BRG press-fit area (φ20 shaft area)	ф20m6 +0.021/+0.008	ARG & FUNCTIONAL RING GAUGE	— Freq									5/SETUP &TC 100%						■ 5/LOT	Measurable	1.74	2	0	0	0	ОК	
7 Surface roughness of BRG press-fit area (φ20/10 shaft area) . On 20 area	Rz 6.3 MAX	ROUGHNESS TESTER	— Freq									5/SETUP &TC						■ 1/LOT	Measurable	1.89	2	0	0	0	ОК	
8 Surface roughness of BRG press-fit area (φ20/10 shaft area) . On 10 area	Rz 6.3 MAX	ROUGHNESS TESTER	— Freq									5/SETUP &TC						■ 1/LOT	Measurable	2.38	2	0	0	0	ОК	
9 Surface roughness of cam face	Rz 3. 2 MAX	ROUGHNESS TESTER	— Freq									a.c	1/SETUP &TC		1/SETUP &TC			■ 1/LOT	Measurable	1.78	3	0	0	0	ОК	
10 Surface roughness of cam face(All around circumferential direction)	Rz 2 MAX (LAPPED)	ROUGHNESS TESTER	— Freq													5/SETUP &TC 1/50		■ 1/LOT	Measurable	1.567	2	0	0	o	ОК	
11 Outer diameter of BRG press-fit area (φ10 shaft area)	ф10 +0.015/+0.006	ARG & FUNCTIONAL RING — GAUGE	— Freq									5/SETUP &TC 100%				,,,,,		■ 5/LOT	Measurable	1.504	2	0	0	o	ОК	
12 Position of BRG press-fit area (ф10 shaft area)	16.2 +0.1/0	HEIGHT GAUGE & DIAL	— Freq				5/SETUP &TC 1/50					. ,						■ 5/LOT	Measurable	1.711	2	0	0	0	ОК	
13 Cam surface parallelism (2Places)	0. 015 MAX (Datum G-H)	GEAR TESTER & DIAL	— Freq				- ,						5/SETUP &TC					■ 5/LOT	Measurable	2.121	2	0	0	0	ОК	
14 Cam base circle diameter	ф28 ±0.04	HEIGHT GAUGE & MASTER	— Freq										5/SETUP &TC					■ 5/LOT	Measurable	1.679	2	0	0	o	ОК	
15 Circular runout of cam base	0. 02 MAX (Datum G-H)	BENCH CENTER & DIAL INDICATOR	— Freq										5/SETUP &TC 1/50					■ 5/LOT	Measurable	1.514	2	0	0	0	ОК	
16 Position of decompressor cam hole	10 ±0.05	CMM/CD GAUGE —	— Freq											1/SETUP &TC 1/50				■ 1/LOT	Measurable	1.645	2	0	0	o	ОК	

QA MATRIX SHEET



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ok	Ср	Max.	Min.	Aver.	Rang	Dev	USL	LSL	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29
59	19.02	2.780	2.740	2.764	0.040	0.022	3.000	0.500	2.780	2.780	2.740	2.780	2.740																								
86	5.49	56.000	55.200	55.580	0.800	0.303	60.000	50.000	56.000	55.200	55.700	55.400	55.600																								
###	####	0.000	0.000	#####	0.000	####	-	-																													
46	1.70	0.038	0.018	0.029	0.020	0.005	0.050	0.000	0.032	0.029	0.038	0.018	0.030	0.026	0.031	0.029	0.036	0.022	0.019	0.036	0.028	0.026	0.033	0.025	0.027	0.029	0.036	0.025	0.028	0.028	0.030	0.026	0.020	0.030	0.033	0.028	0.031
76	1.86	10.150	4.860	6.575	5.290	1.121	12.500	0.000	6.840	6.660	5.860	5.920	6.840	6.230	5.710	5.930	6.880	7.540	6.930	10.150	5.870	5.660	5.920	5.780	6.290	6.110	5.860	5.740	6.150	5.240	6.580	6.860	7.920	8.180	9.140	6.470	4.860
.74	2.09	20.018	20.014	20.016	0.004	0.001	20.021	20.008	20.016	20.014	20.016	20.014	20.015	20.016	20.018	20.015	20.014	20.016	20.015	20.018	20.016	20.015	20.014	20.016	20.015	20.016	20.015	20.017	20.016	20.015	20.016	20.015	20.017	20.016	20.015	20.016	20.015
.89	1.94	5.240	2.590	3.232	2.650	0.540	6.300	0.000	2.840	4.160	3.140	3.980	3.240	3.190	3.260	3.560	2.893	3.560	2.980	2.710	3.450	3.220	3.330	3.220	3.540	2.960	5.240	2.840	3.150	2.690	2.660	2.590	2.670	3.240	3.120	2.690	3.590
.38	2.46	3.986	2.345	3.056	1.641	0.427	6.300	0.000	2.223	3.312	3.091	3.980	3.240	2.345	3.260	3.986	2.987	3.560	2.980	2.710	3.256	3.220	3.330	3.220	3.540	2.960	2.354	2.840	3.150	2.690	2.660	2.590	2.670	3.240	3.120	2.690	3.230
.78	2.10	2.630	1.360	1.849	1.270	0.254	3.200	0.000	1.980	1.840	2.140	2.220	1.960	1.730	1.850	1.360	2.100	1.920	2.630	2.140	1.960	1.580	1.690	1.730	1.690	1.540	1.680	1.590	1.740	1.690	1.760	1.850	1.750	1.860	1.690	2.240	1.860
567	2.102	1.660	0.960	1.254	0.700	0.159	2.000	0.000	1.240	0.960	1.220	1.290	1.120	1.360	1.060	1.050	1.110	1.240	1.140	0.980	1.020	1.630	1.260	1.380	1.360	1.280	1.340	1.660	1.280	1.310	1.290	1.330	1.260	1.270	1.360	1.250	1.260
504	1.812	10.012	10.010	10.011	0.002	0.001	10.015	10.006	10.009	10.012	10.010	10.012	10.011	10.012	10.011	10.012	10.012	10.011	10.012	10.011	10.011	10.010	10.010	10.011	10.012	10.011	10.012	10.011	10.012	10.012	10.011	10.012	10.010	10.012	10.011	10.012	10.011
711	1.821	16.260	16.220	16.253	0.040	0.009	16.300	16.200	16.260	16.240	16.260	16.250	16.220	16.260	16.250	16.260	16.240	16.260	16.250	16.260	16.260	16.250	16.260	16.260	16.250	16.260	16.250	16.260	16.240	16.260	16.250	16.260	16.260	16.250	16.250	16.250	16.260
.216	2.121	0.012	0.008	0.011	0.004	0.001	0.015	0.000	0.010	0.012	0.010	0.010	0.012	0.008	0.008	0.010	0.011	0.011	0.011	0.009	0.012	0.012	0.010	0.012	0.009	0.012	0.011	0.010	0.010	0.010	0.011	0.011	0.012	0.011	0.012	0.011	0.011
.679	1.737	28.010	27.989	28.001	0.021	0.008	28.040	27.960	27.996	28.008	27.996	27.999	28.009	28.000	28.009	27.999	27.990	28.008	28.008	28.005	28.006	28.010	28.006	28.005	28.010	28.010	28.010	27.990	27.990	27.992	27.990	27.999	27.998	27.990	28.009	28.009	27.989
514	1.721	0.014	0.006	0.011	0.008	0.002	0.020	0.000	0.010	0.008	0.012	0.010	0.010	0.010	0.012	0.014	0.010	0.010	0.008	0.010	0.014	0.012	0.006	0.012	0.012	0.010	0.012	0.010	0.012	0.014	0.012	0.014	0.012	0.012	0.014	0.012	0.010
645	1.750	10.020	9.990	10.003	0.030	0.010	10.050	9.950	10.010	9.990	9.990	10.000	10.010	10.010	9.990	10.000	10.010	10.010	10.010	9.990	10.010	9.990	10.010	9.990	9.990	9.990	10.000	10.010	10.020	10.020	10.010	10.000	10.000	10.010	10.010	10.010	10.000

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Cpk	Ср	Max	. M	/lin.	Aver	· e	Ď	ev.	USL	LSL	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30
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