PROCESS MONITORING CHART

Date :	
Shift : I / II / III	

Part No: 2214G1125 / K - 02.01.2019	Part Name: RING - BRG ADJ. FIN.	Characteristics: Thread - Pitch Diameter	Spec: Ø 153.052 / 153.240
Operation No/Name: 10 / Machining	Machine Description/Code: DOOSAN / D - 2,3,4 & 9	Measuring Equipment: Lever type auto thread ring gauge	Least Count : 0.001 mm / QCC - 1

All Dimensions are in mm

	153.249																					
USL	153.240																					
	153.231																					
	153.221																					
	153.212																					
	153.202																					
	153.193																					
	153.184																					
	153.174																					
	153.165																					
	153.155																					
MEAN	153.146																					
	153.137																					
	153.127																					
	153.118																					
	153.108																					
	153.099																					
	153.090																					
	153.080																					
	153.071																					
	153.061																					
LSL	153.052																					
	153.043																					
Time and shift	I	6:30	7:00	7:30	8:00			8:30	9:00	9:30	10:00	10:30	11:00	11:30	12:00	12:30	1:00			1:30	2:00	2:30	3:00
	II	3:00	3:30	4:00	4:30			5:00	5:30	6:00	6:30	7:00	7:30	8:00	8:30	9:00	9:30			10:00	10:30	11:00	11:30
	III	11:30	12:00	12:30	1:00	QA		1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	QA		6:30			

PROCESS LOG CODE	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL
	A	TOOL CHANGE / INSERT CHANGE	D	POWER FAILURE	G	HARD MATERIAL	J	IDLE
	B	TOOL ADJUSTMENT	E	MACHINE BREAK DOWN	H	WAITING FOR MATERIAL	K	NO PLAN
	C	MACHINE VARIATION	F	SPEED / FEED CHANGE	I	MANDREL PROBLEM	L	NO MAN POWER

Rules for use of Process Monitoring Chart

Start-up & Setting	Five Consecutive Component Green	G	G	G	G	G	Stop and Correct the Production	Two Consecutive Pieces are Yellow	Y	Y		
Continue the Production	Two Consecutive Pieces are Green	G	G					If two consecutive Pieces, At least one Red	Y	R	G	R
	Two Consecutive Pieces Green & Yellow or Yellow &Green	G	Y	Y	G		Stop and Correct the Production	First Piece itself Red	R	or	O	

Produced Qty:	Rejection Qty:	Rework Qty:	**Production**	If two consecutive Pieces, At least one Orange	**Y**	**O**	**G**	**O**

Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**

F/Q/010 Rev:0	ADR 008 / 10/ PMC - Rev No:0

PROCESS MONITORING CHART

Date :	
Shift : I / II / III	

Part No: 2214G1125 / K - 02.01.2019	Part Name: RING - BRG ADJ. FIN.	Characteristics: Thread - Major Diameter	Spec: Ø 154.311 / 154.535
Operation No/Name: 10 / Machining	Machine Description/Code: DOOSAN / D - 2,3,4 & 9	Measuring Equipment: Special Gauge + Dial (Min / Max)	Least Count : 0.001 mm / QCC - 1

All Dimensions are in mm

	154.546																					
USL	154.535																					
	154.524																					
	154.513																					
	154.501																					
	154.490																					
	154.479																					
	154.468																					
	154.457																					
	154.445																					
	154.434																					
MEAN	154.423																					
	154.412																					
	154.401																					
	154.389																					
	154.378																					
	154.367																					
	154.356																					
	154.345																					
	154.333																					
	154.322																					
LSL	154.311																					
	154.300																					

Time and shift	I	6:30	7:00	7:30	8:00		8:30	9:00	9:30	10:00	10:30	11:00	11:30	12:00	12:30	1:00		1:30	2:00	2:30	3:00	
	II	3:00	3:30	4:00	4:30		5:00	5:30	6:00	6:30	7:00	7:30	8:00	8:30	9:00	9:30		10:00	10:30	11:00	11:30	
	III	11:30	12:00	12:30	1:00	QA	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	QA	6:30				

PROCESS LOG CODE	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL
	A	TOOL CHANGE / INSERT CHANGE	D	POWER FAILURE	G	HARD MATERIAL	J	IDLE
	B	TOOL ADJUSTMENT	E	MACHINE BREAK DOWN	H	WAITING FOR MATERIAL	K	NO PLAN
	C	MACHINE VARIATION	F	SPEED / FEED CHANGE	I	MANDREL PROBLEM	L	NO MAN POWER

Rules for use of Process Monitoring Chart

Start-up & Setting	Five Consecutive Component Green	G	G	G	G	G	Stop and Correct the Production	Two Consecutive Pieces are Yellow	Y	Y		
Continue the Production	Two Consecutive Pieces are Green	G	G					If two consecutive Pieces, At least one Red	Y	R	G	R
	Two Consecutive Pieces Green & Yellow or Yellow &Green	G	Y	Y	G		Stop and Correct the Production	First Piece itself Red	R	or	O	

Produced Qty:	Rejection Qty:	Rework Qty:	**Production**	If two consecutive Pieces, At least one Orange	**Y**	**O**	**G**	**O**

Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**

F/Q/010 Rev:0	ADR 008 / 10/ PMC - Rev No:0

PROCESS MONITORING CHART

Date :

Shift : I / II / III

Part No: 2214G1125 / K - 02.01.2019	Part Name: RING - BRG ADJ. FIN.	Characteristics: Thread true Position wrt X Y	Spec: 1.8 Max
Operation No/Name: 10 / Machining	Machine Description/Code: DOOSAN / D - 2,3,4 & 9	Measuring Equipment: Vernier	Least Count : 0.001 mm — QCC - 2

All Dimensions are in mm

	1.980																					
USL	1.800																					
	1.620																					
	1.440																					
	1.260																					
	1.080																					
	0.900																					
	0.720																					
	0.540																					
	0.360																					
	0.180																					
LSL	0.000																					

Time and shift																						
	I	6:30	7:00	7:30	8:00		8:30	9:00	9:30	10:00	10:30	11:00	11:30	12:00	12:30	1:00		1:30	2:00	2:30	3:00
	II	3:00	3:30	4:00	4:30		5:00	5:30	6:00	6:30	7:00	7:30	8:00	8:30	9:00	9:30		10:00	10:30	11:00	11:30
	III	11:30	12:00	12:30	1:00	QA	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	QA	6:30			

PROCESS LOG CODE	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL
	A	TOOL CHANGE / INSERT CHANGE	D	POWER FAILURE	G	HARD MATERIAL	J	IDLE
	B	TOOL ADJUSTMENT	E	MACHINE BREAK DOWN	H	WAITING FOR MATERIAL	K	NO PLAN
	C	MACHINE VARIATION	F	SPEED / FEED CHANGE	I	MANDREL PROBLEM	L	NO MAN POWER

Rules for use of Process Monitoring Chart

Start-up & Setting	Five Consecutive Component Green	G	G	G	G	G	Stop and Correct the Production	Two Consecutive Pieces are Yellow	Y	Y	
Continue the Production	Two Consecutive Pieces are Green	G	G					If two consecutive Pieces, At least one Red	Y	R	G	R
	Two Consecutive Pieces Green & Yellow or Yellow &Green	G	Y	Y	G		Stop and Correct the Production	First Piece itself Red	R	or	O	
								If two consecutive Pieces, At least one Orange	Y	O	G	O

Produced Qty:	Rejection Qty:	Rework Qty:	
Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**

PROCESS MONITORING CHART

Date :

Shift : I / II / III

Part No: 2214G1125 / K - 02.01.2019	Part Name: RING - BRG ADJ. FIN.	Characteristics: Runout wrt A	Spec: 0.16 Max
Operation No/Name: 10 / Machining	Machine Description/Code: DOOSAN / D - 2,3,4 & 9	Measuring Equipment: Special Gauge + Dial	Least Count : 0.001 mm / QCC - 3

All Dimensions are in mm

	0.176																					
USL	0.160																					
	0.144																					
	0.128																					
	0.112																					
	0.096																					
	0.080																					
	0.064																					
	0.048																					
	0.032																					
	0.016																					
LSL	0.000																					
Time and shift	I	6:30	7:00	7:30	8:00		8:30	9:00	9:30	10:00	10:30	11:00	11:30	12:00	12:30	1:00		1:30	2:00	2:30	3:00	
	II	3:00	3:30	4:00	4:30		5:00	5:30	6:00	6:30	7:00	7:30	8:00	8:30	9:00	9:30		10:00	10:30	11:00	11:30	
	III	11:30	12:00	12:30	1:00	QA	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	QA	6:30				

PROCESS LOG CODE	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL
	A	TOOL CHANGE / INSERT CHANGE	D	POWER FAILURE	G	HARD MATERIAL	J	IDLE
	B	TOOL ADJUSTMENT	E	MACHINE BREAK DOWN	H	WAITING FOR MATERIAL	K	NO PLAN
	C	MACHINE VARIATION	F	SPEED / FEED CHANGE	I	MANDREL PROBLEM	L	NO MAN POWER

Rules for use of Process Monitoring Chart

Start-up & Setting	Five Consecutive Component Green	G	G	G	G	G	Stop and Correct the Production	Two Consecutive Pieces are Yellow	Y	Y	
Continue the Production	Two Consecutive Pieces are Green	G	G					If two consecutive Pieces, At least one Red	Y	R	G	R
	Two Consecutive Pieces Green & Yellow or Yellow &Green	G	Y	Y	G		Stop and Correct the Production	First Piece itself Red	R	or	O	
								If two consecutive Pieces, At least one Orange	Y	O	G	O

Produced Qty:	Rejection Qty:	Rework Qty:	
Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**

PROCESS MONITORING CHART

Date :

Shift : I / II / III

Part No: 2214G1125 / K - 02.01.2019	Part Name: RING - BRG ADJ. FIN.	Characteristics: Flatness	Spec: 0.10 Max
Operation No/Name: 10 / Machining	Machine Description/Code: DOOSAN / D - 2,3,4 & 9	Measuring Equipment: Special Gauge + Dial	Least Count : 0.001 mm / QCC - 4

All Dimensions are in mm

	0.110																				
USL	0.100																				
	0.090																				
	0.080																				
	0.070																				
	0.060																				
	0.050																				
	0.040																				
	0.030																				
	0.020																				
	0.010																				
LSL	0.000																				
Time and shift	I	6:30	7:00	7:30	8:00		8:30	9:00	9:30	10:00	10:30	11:00	11:30	12:00	12:30	1:00		1:30	2:00	2:30	3:00
	II	3:00	3:30	4:00	4:30		5:00	5:30	6:00	6:30	7:00	7:30	8:00	8:30	9:00	9:30		10:00	10:30	11:00	11:30
	III	11:30	12:00	12:30	1:00	QA	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	QA	6:30			

PROCESS LOG CODE	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL	CODE	DETAIL
	A	TOOL CHANGE / INSERT CHANGE	D	POWER FAILURE	G	HARD MATERIAL	J	IDLE
	B	TOOL ADJUSTMENT	E	MACHINE BREAK DOWN	H	WAITING FOR MATERIAL	K	NO PLAN
	C	MACHINE VARIATION	F	SPEED / FEED CHANGE	I	MANDREL PROBLEM	L	NO MAN POWER

Rules for use of Process Monitoring Chart

Start-up & Setting	Five Consecutive Component Green	G	G	G	G	G	Stop and Correct the Production	Two Consecutive Pieces are Yellow	Y	Y	
Continue the Production	Two Consecutive Pieces are Green	G	G					If two consecutive Pieces, At least one Red	Y	R	G / R
	Two Consecutive Pieces Green & Yellow or Yellow &Green	G	Y	Y	G		Stop and Correct the Production	First Piece itself Red	R	or	O
								If two consecutive Pieces, At least one Orange	Y	O	G / O

Produced Qty:	Rejection Qty:	Rework Qty:	

Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**