

Date:

																				311111.17	,	
2214G112 019	.5 / K -		Part Nar	ne: RING	BRG A - ز	DJ. FIN.			Charact	eristics:	ſhread - !	Pitch Dia	meter					Spec: Ø	153.052	/ 153.24	,0	
	ne: 10 /	1		Descrip	tion/Coc	le: DOO	SAN / D -	2,3,4 &	Measur	ing Equir	ment: Lر	ever type	auto th	read ring	g gauge	-	Least Cr	ount : 0.ſ	J01 mm		QC	CC - 1
118			<u> </u>						All	Dimension	ns are in m										<u> </u>	
153,249																						
																						1
153.221																						
153.212																						
153.202																						
153.193																						
153.184																						
153.174																						4
																					4	
																						4
153.052																						
153.043																						
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	0	А	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	0	ĮΑ	6:30	'	<u></u> '	
	CODE		DET	AIL		CODE			DETAIL			CODE			DETAIL		!	CODE		DET	ſAIL	
LOG CODE	Α	TOOL CHA	NGE / INS	ERT CHAN	،GE	D	POWER F	AILURE			J	G	HARD MA	TERIAL				J	IDLE			
PROCESS LOG CODE  B TOOL ADJUSTMENT						E	MACHINE	BREAK DC	JWN			н	WAITING	FOR MATE	ĒRIAL			К	NO PLAN			
C MACHINE VARIATION F						F	SPEED / F							L PROBLEN	<u>л</u>			L	NO MAN	POWER		
								Rule	s for use	of Proce	ess Monit	oring Ch	art									
Start-up & Setting Five Consecutive Component Green						G	G	G	G	G					itive Pieces are Yellow		Y	Υ				
Two Consecutive Pieces are Green				Green		G	G			_	Production If two consecution one Red					Pieces, Af	t least	Y	R	G	R	
Two Consecutive Pieces Green & Yellow or Yellow &Green				ow or	G	Υ	Υ	G					First Piec	e itself Re	ed		R	or	О			
	2214G112 019 on No/Naming 153.249 153.240 153.231 153.221 153.212 153.202 153.193 153.184 153.174 153.165 153.155 153.146 153.137 153.127 153.118 153.108 153.099 153.090 153.091 153.061 153.071 153.061 153.071 153.061	2214G1125 / K - 219 On No/Name: 10 / 2153.249 153.240 153.231 153.221 153.202 153.193 153.184 153.174 153.165 153.155 153.146 153.137 153.127 153.118 153.108 153.090 153.090 153.090 153.090 153.080 153.071 153.061 153.052 153.043 I 6:30 II 3:00 III 11:30 CODE A B C  & Setting	2214G1125 / K - 219  On No/Name: 10 / 25  153.249 153.240 153.231 153.212 153.202 153.193 153.184 153.174 153.165 153.155 153.146 153.177 153.118 153.127 153.118 153.090 153.000 150.000 150.0000 150.0000 150.00000 150.00000 150.0000000000	Part Name	Dark Name: RING   Part Name:	Part Name: RING - BRG AI	Part Name: RING - BRG ADJ. FIN.   Character	Part Name: RING - BRG ADJ. FIN.   Characteristics: Ton No/Name: 10 /    Machine Description/Code: DOOSAN / D - 2,3,4 &    Measuring Equip	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Part Name: 10 / ng   Machine Description/Code: DOOSAN / D - 2,3,4 & Measuring Equipment: Let	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diamon No/Name: 10 / g   Stops	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diameter	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diameter	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diameter   Pitch Diamet	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diameter   Machine Description/Code: DOOSAN / D - 2,3,4 & Measuring Equipment: Lever type auto thread ring gauge   Measuring Equipment: Lever type auto th	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diameter   Machine Description/Code   DOOSAN / D - 2,3,4 &	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diameter   Special	2214G1125 / K - 19 19 10	2214G1125 / K - 19 19 20	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Pitch Diameter   Speciely 153.052   153.052			

Produced Qty:	Rejectio	n Qty:	Rework Qty:		If two co one Orar	nsecutive Pieces, At least	Υ	0	G	0
Operator:		Prod. Supervisor:		Line Inspector:		QA Supervisor:				
F/Q/010 Rev:0							ADR	008 / 10/	PMC - Rev	No:0



Date:

																				Silit:1/		
: 2214G112 019	.5 / K -		Part Nar	me: RINC	3 - BRG A	لم, DJ. FIN.	1		Charact	eristics:	Γhread - '	Major Di	ameter				1	Spec: Ø	154.311	/ 154.53	i5	
	ne: 10 /			e Descrip	tion/Coc	le: DOO	SAN / D -	- 2,3,4 &	Measur	ing Equir	pment: S၊	pecial Ga	uge + Di	al (Min	/ Max)	-	Least Cr	ount : 0./	001 mm		QC/	CC - 1
<u>'8</u>			<u> </u>						All	Dimensio	ns are in m						1				<u> </u>	
154.546																						
154.513																						
154.501																						
154.490																						
154.479																						
154.468																						
154.457																						
154.445								4														
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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	0	ĮΑ	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	C	ĄA	6:30	'	'	
	CODE		DET	ΓAIL		CODE			DETAIL		!	CODE	Ē		DETAIL			CODE		DE <sup>7</sup>	ΓAIL	
LOG CODE	Α	TOOL CHA	NGE / INS	SERT CHAN	1GE	D	POWER F	AILURE				G	HARD MA	TERIAL				J	IDLE			
100 005	В	TOOL ADJ	USTMENT			E	MACHINE	É BREAK DC	OWN			Н	H WAITING FOR MATERIAL					К	NO PLAN	NO PLAN		
C MACHINE VARIATION F						F	SPEED / F							L PROBLEM	.vI			L	NO MAN	POWER		
								Rule	s for use	of Proce	ess Monit	coring Ch	art									'
Start-up & Setting Five Consecutive Component Green						G	G	G	G	G				secutive F	utive Pieces are Yellow		Y	Υ	'			
				Green		G	G				_		n	If two cor one Red		Pieces, A	t least	Y	R	G	R	
				ow or	G	Υ	Υ	G			Stop and Correct the First Piece itself Red R or				ed		R	or	o			
8 - 8	2214G112: 019 on No/Naming  154.546 154.535 154.524 154.513 154.501 154.490 154.479 154.468 154.457 154.445 154.443 154.423 154.412 154.401 154.389 154.378 154.367 154.367 154.333 154.322 154.311 154.300 I II III III  S LOG CODE	2214G1125 / K - 019 On No/Name: 10 / ng  154.546 154.535 154.524 154.513 154.4501 154.490 154.479 154.468 154.457 154.445 154.434 154.423 154.412 154.401 154.389 154.378 154.367 154.356 154.345 154.333 154.322 154.311 154.300 I	2214G1125 / K - 219  20	Part Name: 10 / Machine 9  154.546	154.546	Part Name: RING - BRG AI	Part Name: RING - BRG ADJ. FIN.  Machine Description/Code: DOO! 9    154.546	Part Name: RING - BRG ADJ. FIN.	Part Name: RING - BRG ADJ. FIN.	Part Name: RING - BRG ADJ. FIN.   Character	Part Name: RING - BRG ADJ. FIN.   Characteristics: Ton No/Name: 10 / ng	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Non No/Name: 10 / ng   Machine Description/Code: DOOSAN / D - 2,3,4 & Measuring Equipment: Sp	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diagon No/Name: 10 / g   Machine Description/Code: DOOSAN / D - 2,3,4 & Measuring Equipment: Special Gal Files	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter   Machine Description/Code: DOOSAN / D - 2,3,4 & Measuring Equipment: Special Gauge + Dial (Min / Max)	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter   Special Gauge + Dial (Min / Max)   Least Count : 0.0	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter   Specie   154.311.	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter   Special Gauge + Dial (Min / Max)   Least Count : 0.001 mm	Part Name: RING - BRG ADJ. FIN.   Characteristics: Thread - Major Diameter   Speci: Ø 154.311 / 154.535

Produced Qty:	Rejectio	n Qty:	Rework Qty:		If two co one Orar	nsecutive Pieces, At least	Υ	0	G	0
Operator:		Prod. Supervisor:		Line Inspector:		QA Supervisor:				
F/Q/010 Rev:0							ADR	008 / 10/	PMC - Rev	No:0



Date:

Part No: 2214G1125 / K - 02.01.2019  Part Name: RING - BRG ADJ. FIN.  Operation No/Name: 10 /  Machine Description/Code: DOOSAN / D - 2,3,4								Charact	eristics:	Thread ti	rue Posi	tion wrt )	ΧY			Spec: 1.8 Max							
Operation Machini	-	ne: 10 /		Machin 9	e Descrip	otion/Cod	le: DOO	SAN / D	- 2,3,4 &	Measur	ing Equip	oment: V	ernier					Least Co	unt : 0.0	001 mm		QC	C - 2
										All	Dimension	ns are in m	m									1	
	1.980																						
USL	1.800																						
	1.620																						
	1.440																						
	1.260																						
	1.080																			-			
	0.900 0.720																						
	0.720																						
	0.340																						
	0.180																						
LSL	0.000																						
	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
Time and shift	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
	Ш	11:30	12:00	12:30	1:00	q	A	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	Q	A	6:30			
		CODE		DETAIL CODE						DETAIL	•	•	CODE		•	DETAIL	•		CODE		DE	TAIL	•
		Α	TOOL CH	ANGE / IN:	SERT CHAI	NGE	D	POWER F	AILURE				G HARD MATERIAL						J	IDLE			
PROCESS	LOG CODE	В	TOOL AD	JUSTMENT	Γ		E	MACHIN	E BREAK D	OWN			н	WAITING	FOR MAT	ERIAL			К	NO PLAN			
		С	MACHINI	E VARIATIO	ON		F	SPEED / I	FEED CHAN	IGE			ı	MANDRE	L PROBLEI	М			L	NO MAN POWER			
			1						Rule	s for use	of Proce	ess Moni	toring C	hart									
Start-up 8	& Setting		Five Con	secutive (	Compone	nt Green		G	G	G	G	G	Stop	and Corre	ect the	Two Con	secutive I	Pieces are	Yellow	Y	Y		
Continuo	Two Consecutive Pieces are Green G					G					Productio	n	If two co	nsecutive	Pieces, A	t least	Υ	R	G	R			
Continue	the Produc	Two Con Yellow 8		Pieces Gre	een & Yello	ow or	G	Υ	Υ	G		Stop	and Corre	ct the	First Pied	e itself R	ed		R	or	0		
Produced Qty: Rejection Qty: Rework				Rework (	work Qty:					If two consecutive Pieces, At least one Orange				Y	О	G	0						
Operator: Prod. Supervisor:						Line Inspector: QA Su					QA Supe	rvisor:	or:										
F/Q/010 Rev: 0																			ADR	008 / 10/	PMC - Rev	/ No:0	



Date:

Part No: 2214G1125 / K - 02.01.2019  Part Name: RING - BRG ADJ. FIN.  Operation No/Name: 10 /  Machine Description/Code: DOOSAN / D - 2,3,4							Charact	eristics: I	Runout v	vrt A				Spec: 0.16 Max										
Operation Machinic	on No/Nar ng	me: 10 /	,	Machin 9	e Descrip	otion/Co	de: DOO	SAN / D	- 2,3,4 &	Measur	ing Equip	oment: S	pecial G	auge + Di	ial			Least Co	ount : 0.0	001 mm		QC	C - 3	
										All	Dimension	ns are in m	ım											
	0.176																							
USL	0.160																							
	0.144																							
-	0.128																							
-	0.112																							
-	0.080																							
	0.064																							
	0.048																							
	0.032																							
	0.016																							
LSL	0.000																							
	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	
Time and	II	3:00	3:30	4:00	4:30			5:00	5:30	6:00	6:30	7:00	7:30	7:30 8:00 8:30 9:00 9:30					10:00	10:30	11:00	11:30		
shift		11:30	12:00	12:30	1:00	C	QA .	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	C	ĮΑ	6:30				
		CODE		DE	TAIL		CODE	DETAIL					CODE			DETAIL			CODE		DETAIL			
		Α	TOOL CH	ANGE / IN:	SERT CHAN	IGE	D	POWER F	AILURE				G	G HARD MATERIAL					J	IDLE				
PROCESS	LOG CODE	В	TOOL AD	JUSTMENT	٢		E	MACHINE	BREAK DO	OWN			н	WAITING	FOR MAT	ERIAL			К	NO PLAN				
		С	MACHIN	E VARIATIO	ON		F	SPEED / F	EED CHAN	GE			ı	I MANDREL PROBLEM					L	NO MAN	POWER			
									Rule	s for use	of Proce	ess Moni	toring C	hart					1					
Start-up &	& Setting		Five Con	secutive (	Compone	nt Green		G	G	G	G	G	Stop	and Corre	ct the	Two Con	secutive	Pieces are	Yellow	Y	Υ			
Two (				secutive	Pieces are	Green		G	G			•		Productio	n	If two co one Red	nsecutive	Pieces, A	t least	Y	R	G	R	
			Two Cor Yellow 8	nsecutive kGreen	Pieces Gre	een & Yell	ow or	G	Υ	Υ	G		Stop	and Corre	ct the	First Pied	e itself R	ed		R	or	О		
Produced Qty: Rejection Qty:					Rework Qty:										ive Pieces, At least		Υ	0	G	0				
Operator: Prod. Supervisor:					Line Inspector: QA				QA Supe	rvisor:														
F/O/010 Rev: 0														1			ADR	008 / 10/	PMC - Rev	/ No:0				



Date:

Part No 02.01.20	: 2214G11; 019	25 / K -		Part Na	Part Name: RING - BRG ADJ. FIN.  Chara  Machine Description/Code: DOOSAN / D - 2,3,4 &							Characteristics: Flatness								Spec: 0.10 Max			
Operati Machini	on No/Nar	me: 10 /		Machin 9	e Descri <sub>l</sub>	otion/Co	de: DOO	SAN / D	- 2,3,4 &	Measur	ring Equip	oment: S	pecial G	auge + Di	ial			Least Co	ount : 0.0	001 mm		QC	C - 4
ivia ciiiii	''Ь									All	Dimensio	ns are in m	ım					1				ı	
	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																						
LJL	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
Time and	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	1		10:00	10:30	11:00	11:30
shift	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			
		CODE		DE	TAIL		CODE			DETAIL			CODE		I	DETAIL		1	CODE		DE	ΓAIL	
		Α	TOOL CH	ANGE / IN:	SERT CHAI	NGE	D	POWER F	AILURE				G HARD MATERIAL						J	IDLE			
PROCESS	LOG CODE	В	TOOL AD	JUSTMENT	Γ		Е	MACHINE	BREAK D	OWN			H WAITING FOR MATERIAL						К				
		С	MACHINI	E VARIATIO	ON		F	SPEED / F	EED CHAN	NGE			ı	MANDRE	L PROBLE	vi			L	NO MAN	POWER		
									Rule	es for use	e of Proc	ess Moni	toring C	hart									
Start-up	& Setting		Five Con	secutive (	Compone	nt Green		G	G	G	G	G	Stop	and Corre	ect the	Two Con	secutive	Pieces are	Yellow	Y	Υ		
Two Consecutive Pieces are Green							G	G					Stop and Correct the Production If two consecution one Red				Pieces, A	t least	Y	R	G	R	
				Consecutive Pieces Green & Yellow or					Υ	Υ	G		Stop	and Corre	ct the	First Pied	ce itself R	ed		R	or	o	
Produced Qty:				Rejection Qty: Rework 0					Qty:				Productio	n	If two co		e Pieces, A	t least	Y	О	G	0	
Operator: Prod. Supervisor:							Line Insp	ector:					QA Supe	ervisor:	visor:								
F/Q/010 F	Rev: 0										1									ADR	008 / 10/	PMC - Rev	No:0