

Date:

Shift : I / II / III

																				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	Α	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			
100 005	В	TOOL ADJ	USTMENT		, 	E	MACHINE	BREAK DC	JWN			н	WAITING	FOR MATE	ĒRIAL			К	NO PLAN			
C MACHINE VARIATION F						F	SPEED / F							L PROBLEN	л			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							Y	Υ				
				wo Consecutive Pieces are Green				G			_	Production			If two consecutive Pieces, At least one Red			t least	Y	R	G	R
Two Consecutive Pieces Green & Yellow & Green				en & Yello	ow or	G Y Y 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 / 25 153.249 153.240 153.231 153.212 153.202 153.193 153.184 153.174 153.165 153.155 153.146 153.177 153.118 153.127 153.118 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.090 153.000 150.000 150.0000 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 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052 153.052			

Produced Qty:	Rejection	Qty:	Rework Qty:		If two cor	nsecutive Pieces, At least ge	Υ	O	G	0
Operator:		Prod. Supervisor:		Line Inspector:		QA Supervisor:				
F/Q/010 Rev:0							ADR	008 / 10/ F	PMC - Rev	No:0



Date:

Shift : I / II / III

																				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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ı	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	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 ⁷	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			
C MACHINE VARIATION F						F	SPEED / F							L PROBLEM	.vI			L	NO MAN	POWER		
								Rule	s for use	a of Proce	ess Monit	coring Ch	ıart									'
Start-up & Setting Five Consecutive Component Green						G	G	G	G	G				secutive F	Pieces are	Yellow	Y	Υ	'			
the Brodu		Two Cons	secutive P	Pieces are	Green		G	G				Production			If two consecutive Pieces, At least			t least	Y	R	G	R
				ieces Gre	en & Yello	ow or	G	Υ	Υ	G		Stop and Correct the Production							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:	Rejection	Qty:	Rework Qty:		If two cor	nsecutive Pieces, At least ge	Υ	O	G	0
Operator:		Prod. Supervisor:		Line Inspector:		QA Supervisor:				
F/Q/010 Rev:0							ADR	008 / 10/ F	PMC - Rev	No:0



Date:

Shift: I / II / III

Part No: 2214G1125 / K - 02.01.2019 Part Name: RING - BRG ADJ. FIN. Machine Description/Code: DOOSAN / D - 2,3,								Charact	eristics:	Thread t	rue Posi	tion wrt 2	ΧY				Spec: 1.8 Max						
Operation Machini	on No/Nai	ne: 10 /		Machin 9	e Descrip	otion/Cod	de: DOO	SAN / D	- 2,3,4 &	Measur	ing Equip	ment: V	ernier					Least Co	ount : 0.0	001 mm		QC	C - 2
	6									All	Dimension	ns are in m	ım									1	
	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																						
	ı	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
	III	11:30	12:00	12:30	1:00	q	ĮΑ	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	(QΑ	6:30			
		CODE		DE	TAIL	•	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	JUSTMEN ⁻	г		E	MACHINI	E BREAK D	OWN			н	WAITING FOR MATERIAL					К	NO PLAN			
		С	MACHINI	VARIATIO	ON		F	SPEED / I	EED CHAN	IGE			ı	MANDRE	L PROBLEI	M			L	NO MAN	POWER		
							l				of Proce	ess Moni	toring C	hart					1	1			
Start-up 8	& 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		
Cambin	Two Consecutive Pieces are Green							G	G		Production If two consecutive P					e Pieces, A	t least	Y	R	G	R		
Continue the Production Two Consecutive Pic Yellow &Green				Pieces Gre	een & Yell	ow or	G	Y	Υ	G		Stop	and Corre	ect the	First Pied	ce itself R	ed		R	or	О		
Produced Qty: Rejection Qty:						Rework (Qty:		-		Productio	n	If two co		e Pieces, A	t least	Y	o	G	О			
Operator: Prod. Supervisor:				•		Line Insp	ector:					QA Supe	ervisor:										
F/Q/010 R	F/Q/010 Rev: 0															1			ADR	008 / 10/	PMC - Rev	/ No:0	



Date:

Shift: I / II / III

Part No 02.01.2	: 2214G11 019	25 / K -		Part Na	Part Name: RING - BRG ADJ. FIN. Machine Description/Code: DOOSAN / D - 2,3,4 &							Characteristics: Runout wrt A									Spec: 0.16 Max			
Operati Machin	on No/Nai ing	me: 10 /	,	Machin 9	e Descri _l	otion/Co	de: DOO	SAN / D	- 2,3,4 &	Measur	ing Equi	oment: S	pecial G	auge + D	ial			Least Co	ount : 0.0	001 mm		QC	C - 3	
	6									All	Dimension	ns are in m	ım					l				1		
	0.176																							
USL	0.160																							
	0.144																							
	0.128																							
	0.112																							
	0.096																							
	0.080																							
	0.064 0.048																							
	0.048																							
	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 shift	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	C	QΑ	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	C	QΑ	6:30				
		CODE		DE	TAIL		CODE	DETAIL CODE								DETAIL			CODE		DE	ΓAIL		
DD CCCC	100 000	Α	TOOL CH	ANGE / IN:	SERT CHAI	NGE	D	POWER F	AILURE				G HARD MATERIAL						J	J IDLE				
PROCESS	LOG CODE	В	TOOL AD	JUSTMENT	Г		E	MACHINE	BREAK D	OWN			Н	WAITING	FOR MAT	ERIAL			К	NO PLAN				
		С	MACHINI	E VARIATIO	ON		F	SPEED / F	EED CHAN	IGE			ı	I MANDREL PROBLEM					L	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			Pieces are		Y	Y			
Two Consecutive Pieces are Green Continue the Production						G	G				Production If two consecutions one Red				nsecutive	Pieces, A	t least	Y	R	G	R			
Continue	the Produc	LUII		o Consecutive Pieces Green & Yellow or ow &Green					Υ	Υ	G		Stop	and Corre	ct the	First Pied	e itself R	ed		R	or	0		
Produced Qty: Rejection Qty:					n Qty:	: Rework Qty:								Productio	n	If two co		Pieces, A	t least	Υ	О	G	О	
Operator: Prod. Supervisor:						Line Inspector: QA Sup					QA Supe	rvisor:	risor:											
F/Q/010	F/Q/010 Rev: 0										1						1			ADR	008 / 10/	PMC - Rev	/ No:0	



Date:

Shift: I / II / III

Part No 02.01.20	: 2214G11; 019	25 / K -		Part Na	Part Name: RING - BRG ADJ. FIN. 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 _l	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	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	
Snirt	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	J IDLE				
PROCESS	LOG CODE	В	TOOL AD	JUSTMENT	Γ		Е	MACHINE	BREAK D	OWN			H WAITING FOR MATERIAL						К	K NO PLAN				
		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				nsecutive	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: Reject					Rejection Qty: Rework Q					Qty:				Productio	n	If two co		e Pieces, A	t least	Y	o	G	0	
Operator: Prod. Supervisor:							Line Insp	ector:					QA Supe	ervisor:	visor:									
F/Q/010 F	F/Q/010 Rev: 0										1									ADR	008 / 10/	PMC - Rev	No:0	