

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			

MASTER 22/08/2025 12:03

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			

<div><div><div><div></div><div>MEI</div></div></div></div>																			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

[illegible]

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:						If two consecutive Pieces, At least one Orange	Y	O	G	O

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

MASTER 22/08/2025 12:03

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																			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			
Produced Qty:			Rejection Qty:				Rework Qty:						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					