

Date:

Shift: | / || / |||

| Part No: 3235E3905 / C - 23.05.2023 Operation No/Name: 10 / ID Turning Part Name: CASE - DIF Machine Description/0 3 | | | | | | | | | | | eristics: I | | - | | | | | | Spec: 0 | .04 Max | | | | |
|---|----------------|----------|-----------|------------|------------|-----------|-----------|-----------------|-----------|-----------------|-------------------------------------|-------------|--|-----------|------------|----------------------|------------|-----------------------------|-----------|--------------|-------|-------|-------|--|
| - | n No/Nar | ne: 10 / | ID | Machin | e Descrip | tion/Cod | le: ACE - | 2 & 3 / / | ACE - 2 & | Measur | ing Fauir | ment: S | necial G | auge (var | riable) | | | Least Co | unt · 0.0 | 001 mm | | FI | J9 | |
| Turning | | | | 3 | | | | | | IVICUSUI. | 9 -4~ | | peciai ei | auge (va. | | | | | | | | | | |
| | | | | | | | | | | All | Dimension | ns are in m | m | | | | | | | | | | | |
| | 0.044 | | | | | | | | | | | | | | | | | | | | | | | |
| USL | 0.040 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.036 | | | | | | | | | | | | | | | | | | | | | | | |
| - | 0.032 0.028 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.028 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.024 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.016 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.012 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.008 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.004 | | | | | | | | | | | | | | | | | | | | | | | |
| 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 | ĮΑ | 1:30 | 2:00 | 2:30 | 3:00 | 3:30 | 4:00 | 4:30 | 5:00 | 5:30 | 6:00 | d | ĮΑ | 6:30 | | | | |
| | | CODE | | DE | TAIL | ' | CODE | | | DETAIL | • | | CODE | | • | DETAIL | 1 | 1 | CODE | | DE. | ΓAIL | ' | |
| | | Α | TOOL CH | ANGE / INS | SERT CHAN | IGE | D | POWER F | AILURE | G HARD MATERIAL | | | | | | | | | J | IDLE | | | | |
| PROCESS | LOG CODE | В | + | JUSTMENT | | | F | MACHINE | BREAK D | OWN | | | H WAITING FOR MATERIAL | | | | | | | NO PLAN | | | | |
| | | С | - | E VARIATIO | | | | | EED CHAN | | | | | | | | | | | NO MAN POWER | | | | |
| | | | IVIACHINI | EVANIATIO | JIN | | Г | SPEED / F | | | for use of Process Monitoring Chart | | | | | | | | | INO IVIAIN | POWER | | | |
| | | | | | | | | | Nuic | 101 use | - OI FIOCE | SS IVIOIII | toring Ci | lait | | | | | | | | | | |
| Start-up 8 | & Setting | | Five Con | secutive (| Componer | nt Green | | G | G | G | G | G | Stop | and Corre | ct the | Two Con | secutive I | Pieces are | Yellow | Y | Υ | | | |
| Continuo | the Bradue | rtion | Two Cor | secutive I | Pieces are | Green | | G | G | | | | | Productio | n | If two co one Red | nsecutive | Pieces, A | t least | Υ | R | G | R | |
| Continue the Production Two Consecutive Pieces Green & Yellow or Yellow & G | | | | | | | G | Υ | Υ | G | | Stop | and Corre | ct the | First Piec | e itself R | ed | | R | or | О | | | |
| Produced Qty: Rejection Qty: Rew | | | | | | | Rework (| Oty: Production | | | | | If two consecutive Pieces, At least one Orange | | | | Υ | O | G | o | | | | |
| Operator | : | | | | Prod. Su | pervisor: | | | | | Line Inspector: QA Supervisor: | | | | | | | | | | | | | |
| F/Q/010 R | ev: 0 | | | | 1 | | | | | | | | | | | | | DC 001 / 10/ PMC - Rev No:0 | | | | | | |



Date:

Shift: I / II / III

| | | | | | | | | | | | | | | | | | | | | | | • | |
|----------------------|---|----------|---------------------|---------------------|------------|-------------|-----------|-----------|-----------|-----------|-------------|----------------------|-----------|-------------------------|-----------|-----------------------------------|-------------|-----------|-----------|-----------|-------|-------|-------|
| Part No: 23.05.20 | 3235E390 23 | 05 / C - | | | | E - DIFF. I | | | I | | eristics: I | | | | | | | | Spec: 64 | .24 / 64. | 33 | | |
| Operation Turning | n No/Nar | me: 10 / | ' ID | Machine 3 | e Descrip | tion/Co | de: ACE - | 2 & 3 / / | ACE - 2 & | Measuri | ng Equip | ment: S _l | oecial G | auge (var | iable) | | | Least Co | unt : 0.0 | 01 mm | | EU | J6 |
| | | | | 1- | | | | | | | | ns are in m | | | | | | | | | | | |
| | 64.335 | | | | | | | | | | | | | | | | | | | | | | |
| USL | 64.330 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.326 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.321 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.317 | | | | | | | | | | | | | | | | | | | | | | |
| • | 64.312 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.308 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.303 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.299 | | | | | | | | | | | | | | | | | | | | | | |
| _ | 64.294 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.290 | | | | | | | | | | | | | | | | | | | | | | |
| MEAN | 64.285 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.281 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.276 | | | | | | | | | | | | | | | | | | | | | | |
| - | 64.272 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.267 | | | | | | | | | | | | | | | | | | | | | | |
| - | 64.263 64.258 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.254 | | | | | | | | | | | | | | | | | | | | | | |
| - | 64.234 | | | | | | | | | | | | | | | | | | | | | | |
| - | 64.245 | | | | | | | | | | | | | | | | | | | | | | |
| LSL | 64.240 | | | | | | | | | | | | | | | | | | | | | | |
| | 64.236 | | | | | | | | | | | | | | | | | | | | | | |
| | 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 |
| 3 | Ш | 11:30 | 12:00 | 12:30 | 1:00 | C | 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 | | DE | ΓAIL | • | CODE | | | DETAIL | | • | CODE | | • | DETAIL | | | CODE | | DET | AIL | |
| DDOCECC | LOG CODE | Α | TOOL CH | ANGE / INS | ERT CHAN | IGE | D | POWER FA | AILURE | | | | G | HARD MA | TERIAL | | | | J | IDLE | | | |
| PROCESS | LOG CODE | В | TOOL AD. | JUSTMENT | | | E | MACHINE | BREAK DC | OWN | | | Н | WAITING | FOR MAT | ERIAL | | | К | NO PLAN | | | |
| | | С | MACHINE | VARIATIO | N | | F | SPEED / F | EED CHAN | GE | | | ı | MANDRE | L PROBLEN | / | | | L | NO MAN | POWER | | |
| | | • | • | | | | • | • | Rules | s for use | of Proce | ess Moni | toring Cl | nart | | | | | | • | | | |
| Start-up 8 | t-up & Setting Five Consecutive Component Green | | | | | | | G | G | G | | | | | ct the | Two Consecutive Pieces are Yellow | | | | Υ | Υ | | |
| | Two Consecutive Pieces are Green | | | | | | | G | G | | | | | Productio | | If two cor one Red | nsecutive | Pieces, A | t least | Υ | R | G | R |
| Continue | the Produc | ction | Two Con Yellow & | secutive F Green | Pieces Gre | een & Yell | ow or | G | Υ | Y | G | | - | and Corre Production | | First Piec | e itself Re | ed | | R | or | 0 | |
| | Tellow & dicell | | | | | | | | | | | | | | | | | | | | | | |

| Produced Qty: | Rejection | Qty: | Rework Qty: Production If two consecutive Pieces, At least one Orange | | | | | | О | G | 0 |
|---------------|-----------|-------------------|--|-----------------|--|--|----------------|------|-------------|----------|------|
| Operator: | | Prod. Supervisor: | | Line Inspector: | | | QA Supervisor: | | | | |
| F/Q/010 Rev:0 | | | | | | | | DC (| 001 / 10/ P | MC - Rev | No:0 |



Date:

Shift: I / II / III

| Part No: 23.05.20 | 3235E390 23 |)5 / C - | | | | E - DIFF. I | | | | | eristics: | | _ | | | | | | Spec: 0.06 Max | | | | | |
|---|----------------|----------|-----------|------------|------------|-------------|-----------|---------------------------|-------------------------|-------------|---------------------------------------|----------------------|--------------------------|-------------------|------------|----------------------|------------|------------|-----------------------------|--------------|-------|-------|-------|--|
| - | on No/Nar | ne: 10 / | ID | Machin | e Descrip | tion/Co | le: ACE - | 2 & 3 / | ACE - 2 8 | Measui | ing Equip | oment: S | pecial Ga | auge (vai | riable) | | | Least Co | ount : 0.0 | 001 mm | | E | U6 | |
| Turning | | | | 3 | | | | | | ····cusu. | 9 -4~. | | peciai ei | auge (va. | | | | | | | | | | |
| | | | | | | | | | | All | Dimension | ns are in m | m | | | | | | | | | | | |
| | 0.066 | | | | | | | | | | | | | | | | | | | | | | | |
| USL | 0.060 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.054 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.048 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.042 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.030 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.024 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.018 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.012 | | | | | | | | | | | | | | | | | | | | | | | |
| | 0.006 | | | | | | | | | | | | | | | | | | | | | | | |
| 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 | a | A | 1:30 | 2:00 | 2:30 | 3:00 | 3:30 | 4:00 | 4:30 | 5:00 | 5:30 | 6:00 | q | ĮΑ | 6:30 | | | | |
| | | CODE | | DE | TAIL | • | CODE | | | DETAIL CODE | | | | | | DETAIL | 1 | | CODE | | DE | TAIL | 1 | |
| | | Α | TOOL CH | ANGE / IN: | SERT CHAN | IGE | D | POWER F | FAILURE G HARD MATERIAL | | | | | | | | J | | | | IDLE | | | |
| PROCESS | LOG CODE | В | TOOL AD | JUSTMENT | | | F | MACHIN | E BREAK D | OWN | | | H WAITING FOR MATERIAL K | | | | | | | NO PLAN | | | | |
| | | С | | E VARIATIO | | | | | FEED CHAN | | | | | MANDREL PROBLEM L | | | | | | NO MAN POWER | | | | |
| | | | Wincering | L VAINATIO | | | • | 31 220 / 1 | | | s for use of Process Monitoring Chart | | | | | | | | _ | INO IVIAIN | TOWER | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | |
| Start-up 8 | & Setting | | Five Con | secutive (| Compone | nt Green | | G | G | G | G | G | | and Corre | | Two Con | secutive F | Pieces are | Yellow | Υ | Υ | | | |
| Continuo | the Produc | ction | Two Cor | secutive | Pieces are | Green | | G | G | | | | | Productio | n | If two co one Red | nsecutive | Pieces, A | t least | Y | R | G | R | |
| Two Consecutive Pieces Green & Yellow or Yellow & Green | | | | | | | | Υ | Y | G | | Stop and Correct the | | | First Pied | ce itself Re | ed | | R | or | 0 | | | |
| Produced Qty: Rejection Qty: Rew | | | | | | | Rework | Qty: Production If two co | | | | | | | Pieces, A | t least | Y | 0 | G | 0 | | | | |
| Operator: Prod. Supervisor: | | | | | | | | | | Line Insp | ne Inspector: QA Supervisor: | | | | | | | | | | | | | |
| F/Q/010 R | ev: 0 | | | | 1 | | | | | | | | | | | | | | DC 001 / 10/ PMC - Rev No:0 | | | | | |



Date:

Shift : I / II / III

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|---|--|--|--|--|--|----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|--|--|---|---|-----------------------------|-----------------------------|-----------------------------|-----------------------------|--|---------------------|---|---|
| 3235E390)23 | 5 / C - | | | | | | | | | | - | | | | | | 1 | Spec: R | 82.57 / 8 | 32.63 | | |
| | ne: 10 / | ID | Machine | Descrip | tion/Coc | le: ACE - | - 2 & 3 / / | ACE - 2 & | Measur | ing Equir | ment: Sr | pecial Ga | uge (var | iable) | | | Least Cr | ر.o : 1.o | ე01 mm | | EI | :U7 |
| | | | <u> </u> | | | | | | | | | | | | | | | | | | | |
| 82 633 | | | | | | | | | - | JIII CIUS | , are in initial | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | |
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| 82.624 | | | | | | | | | | | | | | | | | | | | | | |
| 82.621 | | | | | | | | | | | | | | | | | | | | | | |
| 82.618 | | | | | | | | | | | | | | | | | | | | | | |
| 82.615 | | | | | | | | | | | | | | | | | | | | | | |
| 82.612 | | | | | | | | | | | | | | | | | | | | | | |
| 82.609 | | | | | | | | | | | | | | | | | | | | | | |
| 82.606 | | | | | | | | | | | | | | | | | | | | | | |
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| 82.573 | | | | | | | | | | | | | | | | | | | | | | <u> </u> |
| 82.570 | | | | | | | | | | | | | | | | | | | | | | |
| 82.567 | | | | | | | | | | | | | | | | | | | | | | |
| 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 | <u> </u> | | 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 | _ o | ĮΑ | 1:30 | 2:00 | 2:30 | 3:00 | 3:30 | 4:00 | 4:30 | 5:00 | 5:30 | 6:00 | 0 | ĮΑ | 6:30 | | 1 | |
| | CODE | L | DET | AIL | | CODE | | | DETAIL | | | CODE | L | | DETAIL | | | CODE | | DET | (AIL | |
| LOG CODE | Α | TOOL CHA | NGE / INS | ERT CHAN | .GE | D | POWER F | AILURE | | | | G I | HARD MA | TERIAL | | | | J | IDLE | | | |
| ROCESS LOG CODE B TOOL ADJUSTMENT | | | | | | E | MACHINE | BREAK DC | JWN | | | н | WAITING | FOR MATE | ÉRIAL | | | К | NO PLAN | | | |
| C MACHINE VARIATION | | | | | | F | SPEED / F | | | | | | | PROBLEM | л <u></u> | | | L | NO MAN | POWER | | |
| | | | | | | | | Rule | s for use | of Proce | ss Monit | .oring Ch | ıart | | | | | | | | | |
| Start-up & Setting Five Consecutive Compo | | | | .omponen | it Green | | G | G | G | G | G | - | | ect the | | | | | Y | Υ | | |
| the Produc | rtion | | | | | | G | G | | | | P | roduction | | If two con one Red | | Pieces, A | t least | Y | R | G | R |
| the Product | | | | ieces Gre | en & Yello | ow or | G | Υ | Υ | G | / | | | | First Piec | .e itself R€ | ed | | R | or | 0 | |
| 3 | 82.633 82.630 82.627 82.624 82.621 82.618 82.615 82.612 82.609 82.606 82.600 82.597 82.594 82.591 82.588 82.582 82.570 | 3235E3905 / C - 223 On No/Name: 10 / I 82.633 82.630 82.627 82.624 82.621 82.618 82.615 82.612 82.609 82.600 82.597 82.594 82.597 82.594 82.591 82.588 82.585 82.582 82.579 82.576 82.573 82.570 82. | 3235E3905 / C - 1023 Pon No/Name: 10 / ID 82.633 | Section Sect | Section Sect | Part Name: CASE - DIFF. F. | Part Name: CASE - DIFF. FIN Characteristics: Sign No/Name: 10 / ID Machine Description/Code: ACE - 2 & 3 / ACE - 2 & Measuring Equipmont | Part Name: CASE - DIFF. FIN Characteristics: Spherical I | Part Name: CASE - DIFF. FIN Characteristics: Spherical Radius Characteristics: Spherical Radius | Part Name: CASE - DIFF. FIN Characteristics: Spherical Radius Characteristics: Characte | Part Name: CASE - DIFF. FIN | Part Name: CASE - DIFF, FIN Characteristics: Spherical Radius Special Gauge (variable) Special | 3235E3905 / C - 233 | Part Name: CASE - DIFF. FIN Characteristics: Spherical Radius Spec: R 82.57 / 82.63 | Second |

| Produced Qty: | Rejection | Qty: | Rework Qty: Production If two consecutive Pieces, At least one Orange | | | | | | О | G | 0 |
|---------------|-----------|-------------------|---|-----------------|--|--|----------------|------|-------------|----------|------|
| Operator: | | Prod. Supervisor: | | Line Inspector: | | | QA Supervisor: | | | | |
| F/Q/010 Rev:0 | | | | | | | | DC (| 001 / 10/ P | MC - Rev | No:0 |