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					QUALITY SHEET			
PH-PVT				PRODUCT PN: A17724Q				
				PID: 88				
				OPERATOR: sang				
				SUPPLIER:				
MACHINE: TMC 1 / 2 NO : M21001N2 / M21002N2								
NO		Description of control, Freq, tool and dimensions.						
Control		G ^{al} aspect		CMM	Ã~ ODs			
Every dimension to be inspected in shift first part								
Tool		Visual			Marphoss Gauge			
Tol.Max					Heat Code No		67.623 mm	75.023 mm
Nom							67.600 mm	75.000 mm
Tol.Min							67.590 mm	74.990 mm
Freq	-100%	CMM	Heat Code No	Pos1	Pos2	Pos1	Pos2	

Close

It should remain together at the Workstation

	DESIGNATION: ME-GLACE-MSO2-1C-CAST-NG
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SHIFT: **A**

Machine Name: **1**

TOTAL QUANTITY:	0
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0

	OD Roughness	$\tilde{A} \sim$ ODs	$\tilde{A} \sim$ Distri hole
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	Roughness tester		Vernier			Go/NoGo
	Ra	Rp				
81.727 mm	1.6 Âµm	3.2 Âµm	68.50 mm	75.90 mm	82.60 mm	8.150 mm
81.700 mm	-	-	68.40 mm	75.80 mm	82.50 mm	8.000 mm
81.690 mm	0.0Âµm	0.0Âµm	68.30 mm	75.70 mm	82.40 mm	7.950 mm
Pos1	Pos2	(1/10 parts)	(1/10 parts)	(1/10 parts)	(1/10 parts)	(1/10 parts)

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REJECTED QUANTITY:				
Ã~ Face OD	Ã~ Face ID	Ã~ Face roughness	Ã~ Part height from back face	
Vernier caliper 1	Vernier caliper 2	Roughness tester		Height gauge
		Ra	Rp	
71.100 mm	48.100 mm	1.6 Âµm	6.3 Âµm	46.0 mm
71.000 mm	48.000 mm	-	-	45.50 mm
70.900 mm	47.900 mm	0.0Âµm	0.0Âµm	45.00 mm
(1/5 parts)	(1/5 parts)	(1/5 parts)	(1/10 parts)	(1/10 parts)
