

PART NAME - REBOUND SPRING		PROCESS QUALITY CONTROL TABLE (3)										PAGE : 2/2														
PART NO - 520KH02402		QUALITY CHARACTERISTICS										CRITICAL ITEM		PRODUCTION CONDITION CONTROL												
PROCESS NO		F.M. - FAILURE MODE		[EQUIPMENT, DIE, FAIL SAFE DEVICE, OIL PRESSURE, VOLTAGE, TEMPERATURE, etc.]										DATA FILING FREQ.												
PROCESS NAME EQUIPMENT		C.I. - CRITICAL ITEM		CONTROL ITEM										CONTROL VALUE		CHK BY		CHECK METHOD		FREQUENCY		DATA TYPE		ILLUSTRATION		
				STD.		CHK BY		CHECK METHOD		FREQUENCY		DATA TYPE														
50	SHOT PEENING	(4)		PEENING TIME	10-15 MIN.	OPERATOR	TIMER	EVERY LOADING																
		(4)		PEENING COVERAGE	90 % MIN.	OPERATOR	VISUAL	EVERY LOADING																
		(4)		ALMIN ARC. HT.	0.30-0.40	OPERATOR	DIAL INDICATOR	EVERY LOADING	DAILY CHECK SHEET	EVERY LOT																
60	STRAIN-AGING			TEMP	250±10 °	OPERATOR	TEMP CONTROLLER	EVERY LOT	DATA SHEET	EVERY LOT																
				TIME	15-20 MIN.	OPERATOR	TIMER																			
70	SCRAGGING			SCRAGGING DEFLECTION	10.40 MM	OPERATOR	STOPPER	DURRING SETTING																		
				CYCLES	03 TIME	OPERATOR	COUNTING																			
80	SURFACE FINISH- ANTI RUST OIL			SURFACE FINISH	ANTI RUST OIL	OPERATOR	100%																			
90	FINAL INSPECTION/ PDI	K		WIRE DIA	ø3.80 ±0.03	INSPECTOR	MM	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				INSIDE DIA	ø19.40	INSPECTOR	VC	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				COIL OUTSIDE DIA	ø31.0	INSPECTOR	VC	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				FREE LENGTH	26.00±1.00	INSPECTOR	VC	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				SQUARENESS (e1)	0.80 MAX	INSPECTOR	RIGHT ANGLE	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				PARALLELISM (e2)	1.00 MM MAX	INSPECTOR	DG	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				SOLID LENGTH	15.80 Max.	INSPECTOR	LTM	1 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				NO. OF ACTIVE COILS	2.60 Ref.	INSPECTOR	COUNTING	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				NO. OF TOTAL COILS	4.60 Ref.	INSPECTOR	COUNTING	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				DIRECTION OF WINDING	RH	INSPECTOR	VISUAL	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				LOAD AT 10.40 MM DEF	546 ± 5% N	INSPECTOR	LTM	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				SPRING RATE	51 N/MM	INSPECTOR	LTM	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				SURFACE FINISH	ANTI RUST OIL	INSPECTOR	VISUAL	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																
				APPEARANCE	FREE FROM VISUAL DEFECTS, OTHER DEFECTS	INSPECTOR	VISUAL	20 PCS /LOT	INSPECTION REPORT	20 PCS/ LOT																
				SCRAGGING	10.40mm DEFLECTION	INSPECTOR	LTM	DURING LAYOUT	LAYOUT INSP. REPORT	1 PCS																
	END CONDITION	CLOSED & GROUND	INSPECTOR	VISUAL/ TP	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																			
	MATERIAL	Grade-3	INSPECTOR	RMTC	EVERY LOT	INSPECTION REPORT	----																			
	SHOT PEENING	90% COVERAGE MIN.	INSPECTOR	VISUAL	5PCS/ LOT	INSPECTION REPORT	5 PCS/ LOT																			
	ALMEN ARC HT.	0.30-0.40	INSPECTOR	GAUGE	5 PCS /LOT	INSPECTION REPORT	5 PCS/ LOT																			
100 & 110	PACKING & DESPATCH			QUANTITY PER BOX	AS PER PACKING STD.	OPERATOR	COUNTING	EVERY LOT																		
				Dock Audit	As per Check sheet	Inspector	Visual	EVERY LOT																		

FOR S.I(SETTING INSPECTION)-n=5/C=0, L.I(LINE INSPECTION)-n=5/C=0, L.I WILL BE ON 2 HOURLY BASIS. IN L.I - II CHECK, III- CHECK, IV- FINAL CHECK

< CLASSIFICATION OF FAILURE MODE > (1) DOES NOTB RUN (2) DOES NOT TURN (3) : APPEARANCE (4) PERFORMANCE (5) NOISE K=CRITICAL/ RECORDING S= SAFETY/ Cp,Cpk