

PART NAME - REBOUND SPRING		PROCESS QUALITY CONTROL TABLE ( 3 )										PAGE : 2/2									
PART NO - 520KH02402		QUALITY CHARACTERISTICS										PRODUCTION CONDITION CONTROL									
PROCESS NO.	PROCESS NAME EQUIPMENT	F.M. - FAILURE MODE	C.I. - CRITICAL ITEM	CONTROL ITEM	STD.	CHK BY	CHECK METHOD	FREQUENCY	DATA TYPE	DATA FILING FREQ.	CRITICAL ITEM	[ EQUIPMENT, DIE, FAIL SAFE DEVICE, OIL PRESSURE, VOLTAGE, TEMPERATURE, etc. ]					ILLUSTRATION				
											CONTROL ITEM	CONTROL VALUE	CHK BY	CHECK METHOD	FREQUENCY	DATA TYPE					
											SHOT VOLUME	MAINTAIN LEVEL	OPTR	SIEVE ANALYSIS	AS PER QWI HS 10 QWI 44(II)	SIEVE ANALYSIS REPORT					
50	SHOT PEENING	④	④	PEENING TIME	10-15 MIN.	OPERATOR	TIMER	EVERY LOADING	.....	.....	0.80 mm steel cut wire	400 kg									
				PEENING COVERAGE	90 % MIN.	OPERATOR	VISUAL	EVERY LOADING	.....	DAILY CHECK SHEET								EVERY LOT			
				ALMIN ARC. HT.	0.30-0.40	OPERATOR	DIAL INDICATOR	EVERY LOADING													
60	STRAIN-AGING			TEMP	250±10 °	OPERATOR	TEMP CONTROLLER	EVERY LOT	DATA SHEET	EVERY LOT	HEATER CONDITION	BAL CURRENT	OPERATOR	VISUAL	HOURLY	.....					
				TIME	15-20 MIN.	OPERATOR	TIMER					BELT CONDITION	NO SCRATCH MARKS, NO DAMAGE	OPERATOR	VISUAL	ONCE IN SHIFT	.....				
70	SCRAGGING			SCRAGGING DEFLECTION	10.40 MM	OPERATOR	STOPPER	DURRING SETTING			MACHINE CONDITION	WEAR OUT	OPERATOR	VISUAL	HOURLY						
				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	15.60 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	5 PCS /LOT	INSPECTION REPORT	5 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													

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 NOT RUN (2) DOES NOT TURN (3) : APPEARANCE (4) PERFORMANCE (5) NOISE K=CRITICAL/ RECORDING S= SAFETY/ Cp,Cpk