



PRODUCT QUALITY INSTRUCTION

ADVANCEX DOC NUMBER AEU00418 PQI ISS DATE 11-May-17 PQI ISS 6
PART NO. COM_0022 & COM_0023 PART NAME TH SPRING MASTER / SLAVE DRW. NO. COM_0022 & COM_0023
DRW. ISS. MASTER- 01 / SLAVE- 01 MAT' SIZE 0.75mm ± 0.02
MAT' GRADE Stainless SUS 304WBP-HUB APPROVED MATERIAL SUPPLIER(S) KOS / DSR

MANUFACTURING INSTRUCTIONS

BATCH DEFINITION / SIZE 360,000
HEAT TREATMENT REQUIRED YES TEMP / DURATION 120PPM= 10mins(+15 -0sec)@250°C (±5°C)

OTHER TREATMENTS

APPROVED SUPPLIERS

Sieve for 5 minutes +5sec - 0 sec	NONE
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INSPECTION DATA REQUIRED

SPC REQ YES Full Dim' YES MEASURLINK PROGRAM COM-0022-01 & COM-0022-01 SPC
COM-0023-01 & COM-0023-01 SPC

FEATURES TO BE MEASURED	EQUIPMENT TO BE USED	SAMPLES REQUIRED	SAMPLE FREQ
Dimensional inspection of all critical characteristics	PROFILE PROJECTOR	5	min 59 results per 360,000
Dimensional inspection of all characteristics	PROFILE PROJECTOR	1	Once per shift
Visual inspection	UNAIDED EYE	315	Per 360,000 batch

PACKING & PACKAGING INSTRUCTIONS

QTY PER BAG 5,000 BAG TYPE / SIZE 500g. Inner-300x450 Outer-300x450 (mm) Food Grade
QTY PER BOX 360,000 BOX TYPE / SIZE Double walled pallet box ID=1150x755x710 (mm)

OTHER INSTRUCTIONS

Pallet boxes must be labelled. All parts must be double bagged with inner bag labelled. Bags must be sequentially numbered.

A sample bag of 180 parts taken throughout the batch to be labelled 'MUSTER FUR EINGANGSKONTOLLE / SAMPLES' and dispatched separate to the batch

PRODUCT RELEASE CRITERIA / REQUIREMENTS

MATERIAL CERT REQ YES PPAP REQ NO SPC REQ YES Min PPK/CPK 1.33
C OF C REQ YES FAIR REQ NO ATT DATA NO METHOD AIAG

OTHER INFORMATION

Hair nets must be worn whilst in the production cell. Plastic gloves must be worn whilst packing.

AUTHOR

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DATE 11 MAY 2017

CHECKED / APPROVED BY QA

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DATE 11 MAY 2017

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DATE 12 MAY 2017

DETAILS ADDED TO ROUTING

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DATE 12 MAY 2017