

**Process Quality Control Table - (II)**

No.	Quality Characteristic Control (Product) / Manufacturing Condition Control (Process)														
	Process	Machine, Device, Fixture, Tools for Mfg.	Failure	Critical	Item No.	Quality (Product) Characteristic Control Item	Specification	Manufacturing (Process) Characteristic Control Item	Control Standard	Resp. Person	Conf. Method	Conf. Freq.	Data Form	Report Freq. to Honda	Reaction Plan
10	Receiving Inspection				1	Steel guage	Correct Gauge			QA	Caliper	1 Per Lot	QC Check Sheet	N / A	Refer to QP 14
10	Receiving Inspection				2		No rust	Steel condition		QA	Visual	1 Per Lot	QC Check Sheet	N / A	Refer to QP 14
10	Receiving Inspection				3	Steel apperance	No visible defects			QA	Various	1 Per Lot	QC Check Sheet	N / A	Refer to QP 14
20	Receiving Inspection Purchased Parts		G		4		Per BOM	See Process Sheet	Sub-supplier PPAP package	QA	Per Quality Standard	Monthly	QC Check Sheet	N / A	Refer to QP 14
30	Stamp Parts		G		5	Material Thickness	5 mm ± 1 mm			Assoc	Micrometer	1st piece / 3X shift	QC Check Sheet	Retain on file	Refer to WP 4.13
30	Stamp Parts		G		6	Profile Height	50 mm ± 5 mm			Assoc	Caliper	1st piece / 3X shift	QC Check Sheet	Retain on file	Refer to WP 4.13
30	Stamp Parts		G		7	Parallelism	1 mm			Assoc	Test piece	1st piece / 3X shift	QC Check Sheet	Retain on file	Refer to WP 4.13
30	Stamp Parts		G		8	Inner Height	15 mm ± 2 mm			Assoc	Caliper	1st piece / 3X shift	QC Check Sheet	Retain on file	Refer to WP 4.13
30	Stamp Parts		G		9	Inside Diameter	80 mm ± 5 mm			Assoc	Dial indicator	1st piece / 3X shift	QC Check Sheet	Retain on file	Refer to QP 14
30	Stamp Parts		G		10	Inside Diameter	30 - 32 mm			Assoc	Caliper	1st piece / 3X shift	QC Check Sheet	Retain on file	Refer to IP 5.23
30	Stamp Parts		G		11	Perpendicularity	5 mm			Assoc	Test piece	1st piece / 3X shift	QC Check Sheet	Retain on file	Stop and call quality
30	Stamp Parts		G		12	Rail Centering	5 mm			Assoc	Test piece	1st piece / 3X shift	QC Check Sheet	Retain on file	Refer to QP 14
40	Final Inspection		G		8	Inner Height	15 mm ± 2 mm			Assoc	Caliper	1 Per Lot	QC Check Sheet	Retain on file	Stop and call quality
40	Final Inspection		G		9	Inside Diameter	80 mm ± 5 mm			Assoc	Caliper	1 Per Lot	QC Check Sheet	Retain on file	Stop and call quality
40	Final Inspection		G		10	Inside Diameter	30 - 32 mm			Assoc	Caliper	1 Per Lot	QC Check Sheet	Retain on file	Stop and call quality
40	Final Inspection		G		13	No missing bolts	All bolts must be present			Assoc.	Visual	100%	QC Check Sheet	Retain on file	Stop and call quality