

# passage MAKER

手动油泵(无牙 10mm 油嘴)品质文件

Quality documents

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文件编号File No.

JSBG01

日期Date

制表Prepared by

姜新

2006.06.12

品名 Product name	手动油泵	品号Item No.	TP039.001	审核Audited by	
文件名称 File Name	BOM	版次Edition No.	A/2	批准Approved by	

序号 S-No.	名称 Material name	图号及规格 Drawing No. & Spec.	客户图号 Drawing No. of the client	单位用量 Unit quantity	材料Material	备注Remark
<b>手动油泵(Babyfoot) GP4634B</b>						
1	底座Base	TP039.001-1	697.62	1	尼龙(PA/Nylon)	外协 (80g)
2	塑胶盖Spring cap	TP039.001-2(SPFING COP)	697.07	1	尼龙(PA/Nylon)	外协(4g)
3	橡胶盖Diaphragm	TP039.001-3(DIAPHRAGM)	67.01	1	橡胶Rubber	外协(86g)
4	紧固扣Worm drive clip	TP039.001-4(S/ST WORM DRIVE CLIP)	697.	1	不锈钢Stainless steel	外协
5	螺丝Screw	TP039.001-5(S/ST SCREW PAN HD P S M3.5*6.5MM)	697.48	2	不锈钢	外协
6	橡胶阀Rubber valve	TP039.001-6(VALE)	753.34	2	橡胶Rubber	外协
7	弹簧Spring	TP039.001-7(STRATING SPRING)SPECIAL	697.37	1	不锈钢Stainless steel	外协
8	O形圈O-ring	TP039.001-8(O-RING 11.6*2.4)	742.22	4	橡胶Rubber	外协
9	油嘴Nipple	TP039.001-9.1(10MM NIPPLE)	697.45	2	赛钢POM	外协
10	纸箱Carton	57.5*44.5*40.5 cm		1 PC	A=B	外协
11	平卡Paper board	56.5*43.5cm		6 PCS/CTN	A=B	外协
12	横刀卡Paper board	43.5*7cm (三刀)		20 PCS/CTN	A=B	外协
13	竖刀卡Paper board	56.5*7cm (三刀)		20 PCS/CTN	A=B	外协
14	卡板Pallet	120*100*15cm				外协
15	PE袋PE bag					



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## 作业指导书Work instruction

版次Edition no.	A/0	适用产品及工序 Products and procedures	制订Prepared by	姜新 2006.06.20
执行Implement	装配部 Assembly dept.	手动油	审核Autited by	
文件编号File No.	JSBG08	TP039.001	批准Approved by	
目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;		工具/夹具Tools/Clamps	原/辅料Material	
适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.				
<p>产品工艺流程 Production procedure</p> <pre> graph TD     A[采购原料及配件 Material and parts purchasing] --&gt; B[尼龙料 Nylon 橡胶料 Rubber 螺丝 Screw O形圈 O-ring 弹簧 Spring 紧固扣 Worm gear clip]     B --&gt; C[啤产品Injection]     C --&gt; D[油嘴 Nipple 底座 Assy 塑胶盖 Spring cap 橡胶盖 Diaphragm 橡胶 Valve]     D --&gt; E[预装配-Subassembly]     E --&gt; F[油嘴套O形圈 O-ring sub assy 底座装橡胶阀上螺丝 Valve and Screw sub assy]     F --&gt; G[装配-Assmbly]     G --&gt; H[装油嘴 Nipple assembly 拧紧螺丝 Tighten the screw 装弹簧扣塑胶盖 Spring cap assembly]     H --&gt; I[紧固扣 Worm gear assembly 拧紧所有螺丝 Tighten all of screws 包装成品 Packing]     I --&gt; J[入库 Put into warehouse]     J --&gt; K[出货Shipping]     </pre>		作业方式 Working method	检 标准 Inspection standard	
		采购 Purchasing	依IQC质检标准、检验作业指导书 物料表执行 According to Inspection standard for IQC Work instructions and BOM	
		生产 Production	依IPQC检验标准、产品零件图及 半成品处理办法执行 According to Inspection standard for IPQC Work instruction, Drawing of the product and the other files	
		装配、测试、包装 Assembly, Test, Packing	依FQC检验标准、产品零件图及 半成品处理办法执行 According to Inspection standard for FQC Work instruction, Drawing of the product and the other files	
		仓储Warehouse	入库单、检验报告及成品管理办法 执行 According to the packing list, inspection report and the other files	

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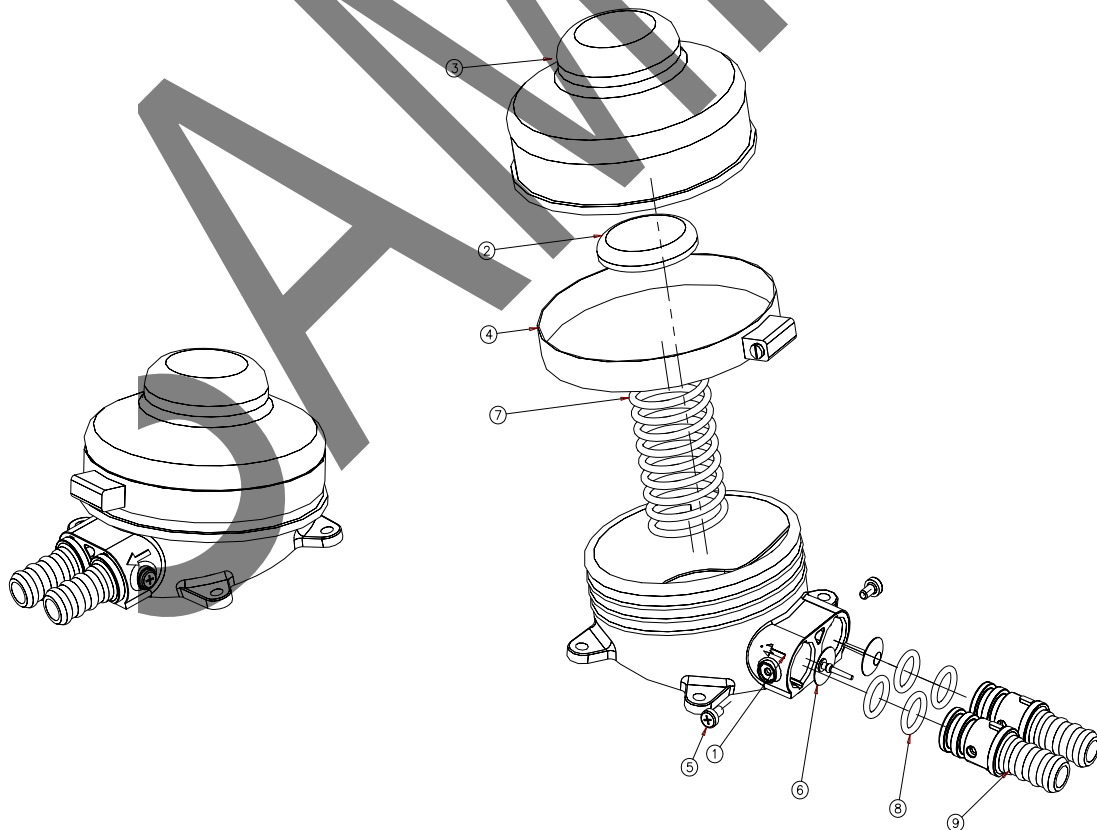
## 作业指导书Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版次 Edition no.	A/0	审核 Audited by	
适用工序 Apply procedure	装配Assembly	制定日期 Date	2006-4-26	批准 Approved by	

目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;	工具/夹具Tools/Clamps	原/辅料Material
适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.		
作业方法Methods	图示Pictures for reference	

产品零件名称Name of parts:  
1、底座Base(697.62); 2、塑胶盖Spring cap(697.07); 3、橡胶盖Diaphragm(697.01); 4、紧固扣Wedge drive clip(697.49);  
5、螺丝screw(697.48); 6、橡胶阀Rubber valve(753.4); 7、弹簧Spring(697.37); 8、O形圈O-ring(742.22);  
9、油嘴Nipple(697.45);

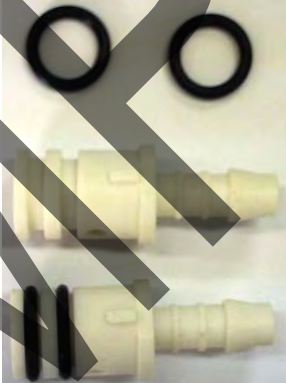
图示Illustration



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## 作业指导书 Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版次 Edition no.	A/0	审核 Audited by	
适用工序 Apply procedure	装配 Assembly	制定日期 Date	2006-4-26	批准 Approved by	

目的(Purpose):	工具/夹具 Tools/Clamps	原/辅料 Material
<p>为正确指导作业员操作，提高工作效率，加强产品品质，规范现场管理； To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;</p>		油嘴 Nipple (697. 5) O型圈 O-ring(742.22)
<p>适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.</p>		
作业方法 Methods	图示 Pictures for reference	
<p>1、油嘴套O形圈 把O形圈套在油嘴的凹槽内；每个油嘴有两个凹槽，都要套O形圈； 注意：不可漏装！</p> <p>1、 Assemble the O-ring to the nipple Set the O-ring into the groove of the nipple; There are two grooves per nipple and be sure set O-ring for both; Notice: Be sure set O-ring for both nipples</p>	 <p>O形圈 O-ring</p> <p>油嘴 Nipple (697. 45)</p> <p>装配好的油嘴 The nipple with O-ring</p>	

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## 作业指导书 Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版次 Edition no.	A/0	审核 Audited by	
适用工序 Apply procedure	装配 Assembly	制定日期 Date	2006-4-26	批准 Approved by	

目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;	工具/夹具 Tools/Clamps	原/辅料 Material
	螺丝刀 Screwdriver 小尖嘴钳 Pliers	底座 Base (6 7 62) 橡胶阀 Rubber valve (753.34) 不锈钢螺丝 Stainless steel screw
适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.		

作业方法 Methods	图示 Pictures for reference
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2、底座装橡胶阀和螺丝  
Rubber valve and screw assembly

(1)、装左边橡胶阀  
底座面向上平放, 油嘴口面向自己;  
橡胶阀从底座里面尖端向外放入左边油嘴孔内, 用尖嘴钳伸入孔内, 夹住尾端向外拉, 使橡胶阀卡在孔内;  
Assemble the left valve  
Push the tail of the umbrella valve through the centre section of the inlet port and gently pull stem through with pliers;

(2)、装右边橡胶阀  
底座面向上平放, 油嘴口面向自己;  
橡胶阀从底座外面尖端向内放入右边油嘴孔内, 用尖嘴钳从底座内, 夹住尾端向外拉, 使橡胶阀卡在孔内;  
Assemble the right valve  
Grip valve with pliers, push stem end of umbrella valve through the centre section, inside the outlet port;  
Gently pull stem through until it snaps into place;

(3)、上螺丝  
底座油嘴出口外有两个上螺丝位, 用螺丝刀拧上螺丝; 螺丝的前端不要在孔内露出来 (1.4Nm);  
Set a screw into the hole of the nipple and tighten it, be sure the front end should not appear from the hole;

橡胶阀

不锈钢螺丝



Tighten to a torque of 1.4 Nm.

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## 作业指导书 Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版次 Edition no.	A/0	审核 Audited by	
适用工序 Apply procedure	装配Assembly	制定日期Date	2006-6-20	批准 Approved by	

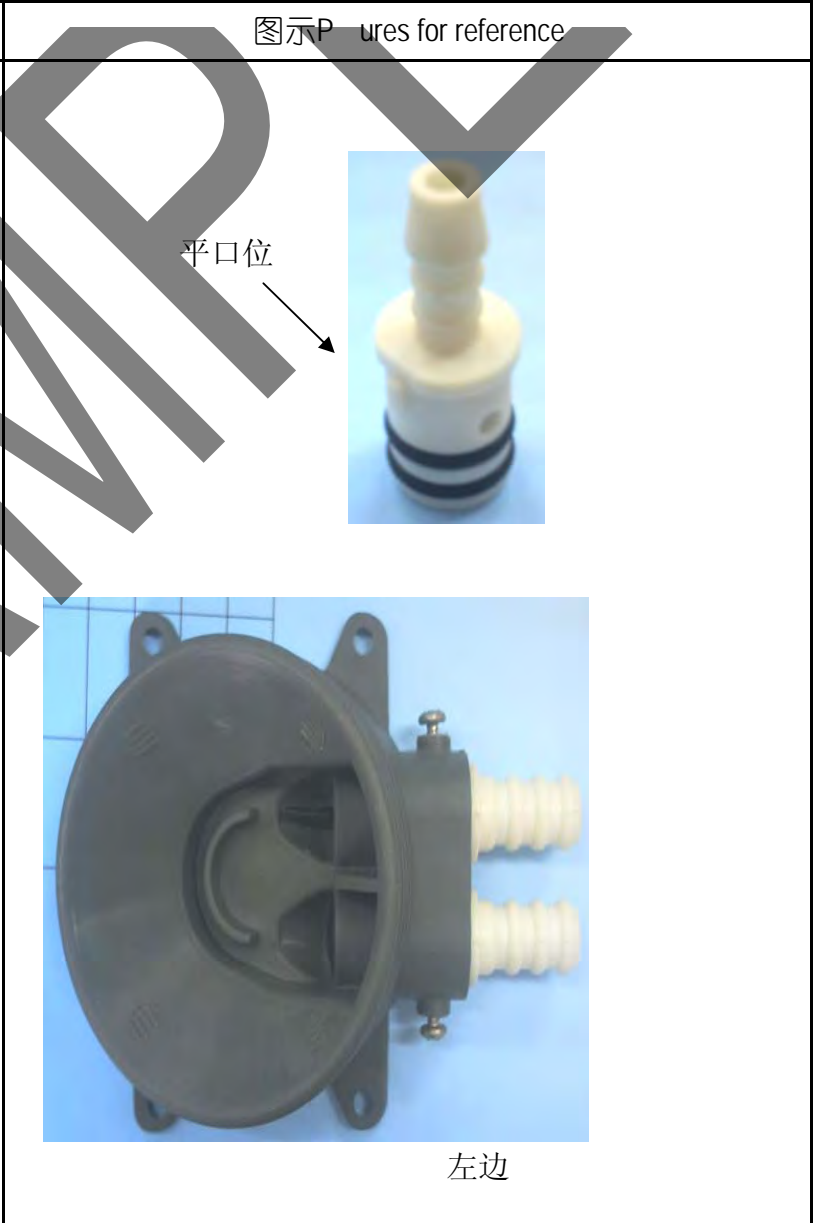
目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;	工具/夹具Tools/Clamps	原/辅料Material
		装好橡胶阀的螺丝的底座 Base with rubber valve and screw 装好O型圈的油嘴 Nipple with O-ring
适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.		

作业方法Methods	图示Pictures for reference
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3、装油嘴Nipples assembly

(1)、装左边油嘴Assemble the left nipple  
底座面向上平放, 油嘴口面向自己;  
检查底座是否有橡胶阀, 方向正确,  
把套好O形圈的油嘴装入底座左孔,  
注意有平口的面向下; 要压到底;  
装油嘴时看油嘴上的O形圈是否漏装  
Place body with valves as shown, the nipple  
face yourself, be sure there are two valves  
in the inlet and outlet and pay attention to  
the direction of the valve, then set the nipple  
with O-ring into the inlet, press it home and  
be sure there are two O-rings in each nipple

(2)、装右边油嘴Assemble the right nipple  
底座面向上平放, 油嘴口面向自己;  
检查底座是否有橡胶阀, 方向正确,  
把套好O形圈的油嘴装入底座右孔,  
注意有平口的面向下; 要压到底;  
装油嘴时看油嘴上的O形圈是否漏装  
Place body with valves as shown, the nipple  
face yourself, be sure there are two valves  
in the inlet and outlet and pay attention to  
the direction of the valve, then set the nipple  
with O-ring into the inlet, press it home, and  
be sure there are two O-rings in each nipple.

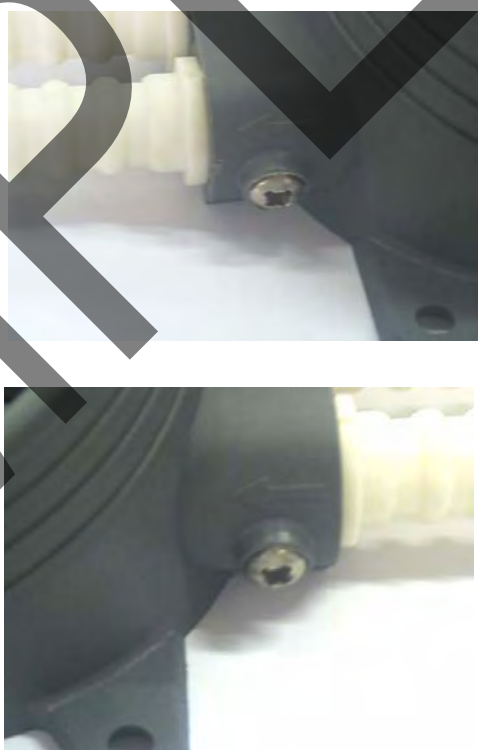


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## 作业指导书 Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版 次 Edition no.	A/0	审核 Audited by	
适用工序 Apply procedure	装配Assembly	制定日期Date	2006-6-20	批准 Approved by	

目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;	工具/夹具Tools/Clamps	原/辅料Material
	电动十字批Screwdriver	上工序半成品 Semi-manufactured products
适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.		

作业方法Methods	图示Pictures for reference
<p>4、拧紧螺丝Tighten the screws 检查底座里是否有橡胶阀, 方向是否正确, 油嘴方向是否正确, 检查OK后, 拧紧油嘴口处的两个螺丝(1.4Nm); Be sure there are valves in the base hole and pay attention to the direction of the valve; tighten the screws at the side of the nipples;</p> <p style="background-color: yellow;">Tighten screws to 1.4 Nm.</p>	

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## 作业指导书 Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版次 Edition no.	A/0	审核 Audited by	
适用工序 Apply procedure	装配 Assembly	制定日期 Date	2006-6-20	批准 Approved by	

目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;	工具/夹具 Tools/Clamps	原/辅料 Material
	电动十字批 Screwdriver	上工序半成品 Semi-manufactured products
适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.		

作业方法 Methods	图示 Pictures for reference
<p>5、装弹簧和扣橡胶盖 Spring and diaphragm assembly</p> <p>(1)、把塑胶盖放入橡胶盖, 注意方向; 如图示 Place the diaphragm (697.01) on the table open end uppermost and fit the spring cap (697.07) with the recessed end side facing up the centre of the diaphragm;</p> <p>(2)、把弹簧放到橡胶盖里; 如图示 Fit the spring into the recess in the spring cap according to the picture;</p> <p>(3)、把底座扣在橡胶盖里; 如图示 Hold the body upside down locate into diaphragm and push fully home;</p>	<p>橡胶盖 697.01</p> <p>塑胶盖 697.07</p> <p>装好</p>

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## 作业指导书 Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版次 Edition no.	A/0	审核 Audited by	
适用工序 Apply procedure	装配Assembly	制定日期Date	2006-6-20	批准 Approved by	

目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;	工具/夹具Tools/Clamps	原/辅料Material
	电动十字批Screwdriver	上工序半成品 Semi-manufactured products
适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.		

作业方法Methods	图示 Pictures for reference
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6、上紧固扣Warm drive clip assembly  
把紧固扣套在橡胶盖上且拧紧螺丝;  
检查其它螺丝是否拧紧 (3.5Nm), 送检测  
中心进行气密性检验; (全检)  
Open worm drive clip and place over the  
diaphragm, locate the screw of the worm  
drive directly above the two nipples on  
the body, place into fixture and tighten  
the worm drive clip with the gun provided;  
\*\*\* Recheck the other screws and send to  
the test center if it is all OK;

Tighten worm gear  
3.5 Nm.

紧固扣697.9



注意螺丝方向



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## 作业指导书 Work instruction

项目编号 Item no.		文件编号 File no.	JSBG08	制定 Prepared by	姜新
品名 Product name		版次 Edition no.	A/1	审核 Audited by	
适用工序 Apply procedure	包装Packing	制定日期Date	2006-6-16	批准 Approved by	

目的(Purpose): 为正确指导作业员操作, 提高工作效率, 加强产品品质, 规范现场管理; To guide the operators for correct operation, product quality, work efficiency, and management of the workshops;	工具/夹具Tools/Clamps	原/辅料Material
		纸箱Carton 57.5*44.5*40 平卡Paper board 56.5 43.5cm 卡板Pallet 胶 E bag 油泵Babyfoot

适用范围(Apply scope): 装配部所有管理人员及操作员; All managements and operators of the assembly dept.	变更日期及其内容 Date and content changed
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### 作业方法Methods 图示 Illustration

1、装箱Putting into the carton

(1)、封好纸箱, 底部先放一平卡, 再放入刀卡;

(2)、把检验好的油泵装入胶袋, 用透胶纸贴好;

(3)、把装好胶袋的油泵装入纸箱;

(4)、每装一层, 上面放一平卡和刀卡; 最上一层在放一块平卡后封箱;

(5)、每层16个, 装5层, 每箱80个油泵;

Seal the bottom of the carton, a paper board on the bottom of the carton and then put the cross paper board into the carton.

Put into PE bag and sticked with tape;

Put the products into the carton;

Set a paper board and cross paper board after each layer and a paper board on the top of the carton, then seal the carton;

16PCS per layer, set 5 layers and 80PCS/CTN;

装箱示意图

Red Whale pump label on the side of the carton with correct model #.

卡板摆放

Currently cust only packs 60 to a box.

2、装卡板Put on the pallet

把封好的纸箱摆在卡板上, 如图;

每个卡板摆4层; 用缠绕膜缠绕紧;

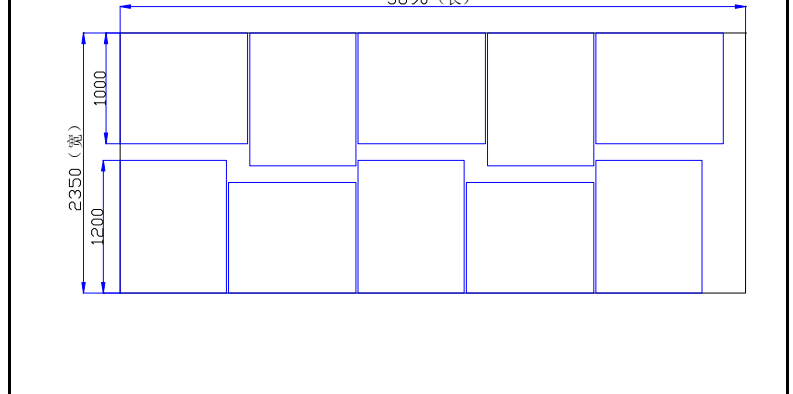
放入待出货区;

Put the products on the pallet as shown;

4 layers per pallet and wrapped with film;

Prepare for shipping;

3、装柜Loading according to the drawing;



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## 产品质量检验规范 (Inspection standard of product quality)

产品名称		
产品编号		
产品类别	IQC	
文件编号	JSBG04	附档数量
版次	A/0	

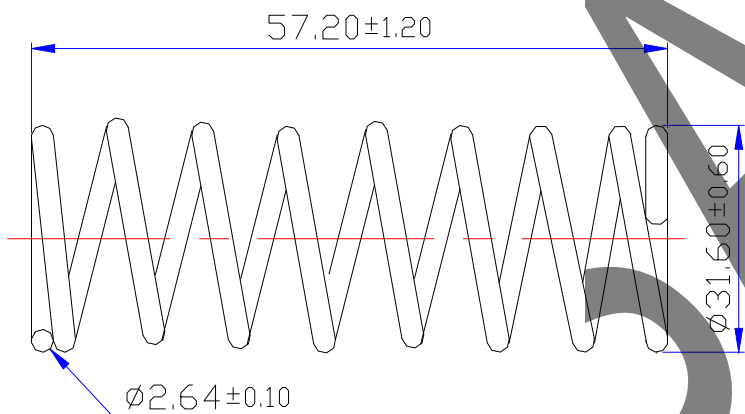
制定日期	2006-6-23	发布日期	
变更日期 及其内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and Methods	备注 Remark
长度 Length	57.2 mm	±1.2	卡尺 Callipers	
外径 Outer Dia.	31.6 mm	±0.6	卡尺 Calliper	
线径 Cross Section Diameter	2.64 mm	±0.1	卡尺 Callipers	
材料 Material	#316 不锈钢 Stainless steel	无 N/A	供应商证书 Certificate supplied by the supplier	参照下面的检测方法和标准 See method and standard below
弹簧圈数 Quantity of coils	7圈活动共9圈 Totally 9 coils and 7 of it is active	无 N/A	目测, 中间7圈, 两端各一圈 Visually inspect, 7 coils center and ends each	
外观 Appearance		无 N/A	目测 Visually inspect	
功能 Function		无 N/A	用手压 Test by hand	

适用范围(Apply scope): 弹簧 Spring (697.37)

外观检测方法和标准(Appearance inspection method and standard):



- 外观检验: 正视力, 在亮度相当于40W日光灯1米高的环境下距产品30CM左右, 成45°角度进行检验 (具体检验标准参照相关文件);  
Normal eyesight, under the brightness condition it equal about 40W day light lamp over 1 meter height, keep a distance of about 30cm from the product with about a 45 degree point of view to inspect the product (Refer the related document for detail)
- 可活动圈数为7圈, 共9圈 Totally 9 coils and 7 of it is active;
- 表面不可有伤痕 Be free of scratches on the surface;  
压紧弹簧, 三秒后松开, 连续五次总长不可改变;  
Press the spring and hold it for 3 seconds, do this 5 times and the length of the spring should not change.

制表(Prepared by):

审核(Audited by):

批准(Approved by):

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

产品名称		
产品编号		
产品类别	IOC	
文件编号	JSBG04	附档数量
版次	A/0	

制定日期	2006-6-23	发布日期	
变更日期及其内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and Methods	备注 Remark
牙长 Length of the thread	6.5 mm	±0.5 mm	卡尺 Calliper	
牙径 Dia. of the thread	3.5 mm	±0.2 mm	卡尺 Callipers	
材料 Material	#304 不锈钢 Stainless steel	无 N/A	供应商证书 Certificate supplied by the supplier	参照下面的检测方法和标准 See method and standard below
外观 Appearance		无 N	目测 Visually inspect	

适用范围 (Apply scope): 螺丝 Screw

外观检测方法和标准 (Appearance inspection method and standard):



- 外观检验: 正常视力, 在亮度相当于40W日光灯1米高的环境下距产品30CM左右, 成45度角进行检验 (具体检验标准参照相关文件);  
Normal eye sight, under the brightness condition it equal about 40W day light lamp over 1 meter height, keep a distance of about 30cm from the product with about a 45 degree point of view to inspect the product
- 规格: M3.5\* 6.5mm; Specification: M3.5\*6.5mm;
- 牙径3.5±0.2mm, 牙长6.5±0.5mm; Dia. of the screw is 3.5±0.2mm and the length is 6.5±0.5mm;
- 试配: 螺丝头部不可大于塑胶件的内圆 The top of the screw should not bigger than the hole;
- 材料为不锈钢 #304 (供应商证书, Stainless steel #304) according to the certificate
- 表面无伤痕, 牙纹清晰无断头, 十字头用十字螺丝刀试转动OK;

制表 (Prepared by):

Be free of damages on the surface, the thread should be clear and test with shape screw drive;  
审核 (Audited by): 批准 (Approved by):

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

产品名称		
产品编号		
产品类别	IQC	
文件编号	JSBG04	附档数量
版次	A/0	

制定日期	2006-6-23	发布日期	
变更日期 其内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准

Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and thods	备注 Remark
内径 inner Dia.	11.6 mm	±0.2	卡尺 Callipers	
线径 Cross Section Diameter	2.4 mm	±0.05	卡尺 Calliper	
材料 Material	弹性橡胶 Rubber	无 N/A	供应商证书明 Certificate applied by the sipplier	参照下面的检测方法和标准 See mthod and standard below
外观 Appearance		无 N/A	目测 Visually inspect	

适用范围 (Apply scope): O型圈 O-ring

外观检测方法和标准 (Appearance inspection method and standard):

- 外观检验: 正常视力, 在亮度相当于40W日光灯1米高的环境下距产品30CM左右, 成45°角度进行检验 (具体检验标准参照相关文件);  
Normal eyesight under the brightness condition it equal about 40W day light lamp over 1 meter height, keep 45 degree point of view to inspect the product with about a 45 degree point of view to inspect the product
- 材料 Material: 弹性橡胶 Rubber;
- 规格 Specification: 11.6\*2.4mm;
- 颜色 Color: 黑色 Black;
- 硬度 Hardness: 750;
- 表面光洁无毛刺、披锋 Be free of burrs and flash on the surface;



制表 (Prepared by):

审核 (Audited by):

批准 (Approved by):

产品名称		
产品编号		
产品类别	IQC	
文件编号	JSBG04	档数
版次	A/0	

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

制定日期	2006-6-23	发布日期	
变更日期及内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and Methods	备注 Remark
内径 inner Dia.	80-100 mm		卡尺 Calliper	
宽度 Width	12 mm	±0.02	卡尺 Calliper	
材料 Material	#304 不锈钢 Stainless steel	无 N/A	供应商证书 Certificate supplied by the supplier	参照下面的检测方法和标准 See method and standard below
外观 Appearance		无 N/A	目测 Visually inspect	

适用范围(Apply scope): 紧固扣 Worm drive clip

外观检测方法和标准(Appearance inspection method and standard):



外观检验 正常视力, 在亮度相当于40W日光灯1米高的环境下距产品30CM左右, 成 5°角度进行检验 (具体检验标准参照相关文件);

Normal eyesight, under the brightness condition it equal about 40W day light lamp over 1 meter height, keep distance about 30cm from the product with about a 45 degree point of view to inspect the product

材料为不锈钢材 (#304), 本色 Stainless steel(#304) with the color of the material;

3 规格 Specification: 80-100mm;

4、表面无伤痕、折印、裂纹等不良 Be free of damages, bend mark and crack, etc.;

5、螺钉开口位可使一字螺丝批下到底, 深度不小于2mm, 在拧紧的状态下螺纹不滑丝;  
—shape screwdriver, the depth is not less than 2mm

Be sure the groove of the screw could be fit with  
and be free of slide while tighten the screw;

制表(Prepared by):

审核(Audited by):

批准(Approved by):

产品名称		
产品编号		
产品类别	IOC	
文件编号	JSBG04	附档数量
版次	A/0	

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

制定日期	2006-6-23	发布日期	
变更日期 及其内容			

目的：为正确指导检测及操作人员提高工作效率，加强产品品质，规范检验标准

Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and Methods	备注 Remark
材料 Material	赛钢和尼龙 POM & NYLON	无 /A	供应商证书 Certificate supplied by the supplier	

### 1、赛钢料 POM:

、用火点燃会有蓝色火焰;

(1) 、燃烧时伴甲醛味, 无烟, 速度慢;

(2) 以上两项用已确认的赛钢料对比;

There will be blue blaze while emblazing;

Smells like formaldehyde, no smoke, with slow speed while emblazing;

Compared with the material which confirmed with the two ways above;

### 2、尼龙料 A:

、用火点燃会有蓝色火焰, 顶端外焰成黄色;

(1) 燃烧时伴毛发焦味, 起泡, 速度慢;

(2) 以上两项用已确认的赛钢料对比;

The small blue blaze and the top of the outer side will be yellow while emblazing;

Compared with the material which confirmed with the two ways above;

制表(Prepared by):

审核(Audited by):

批准(Approved by):

产品名称		
产品编号		
产品类别	IQC	
文件编号	JSBG04	附档数量
版次	A/0	

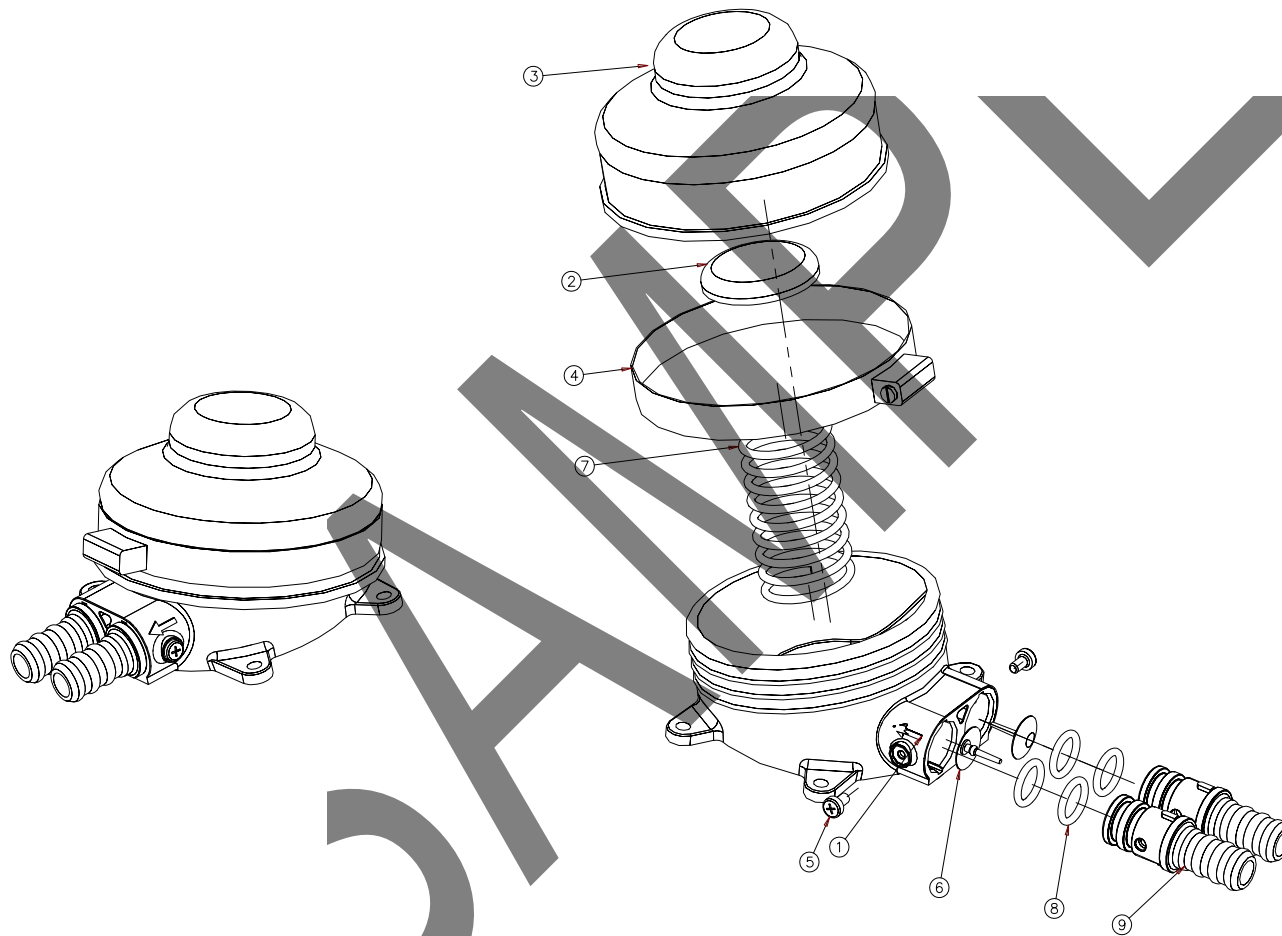
# passage MAKER

产品质量检验规范  
(Inspection standard of product quality)

制定日期	2006-6-23	发布日期	
变更日期 及其内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

适用范围(Apply scope): 图示Illustration



制表(Prepared by):

审核(Audited by):  
Page: 19

批准(Approved by):

产品名称		
产品编号		
产品类别	IPOC	
文件编号	JSBG04	附档数量
版 次	A/0	

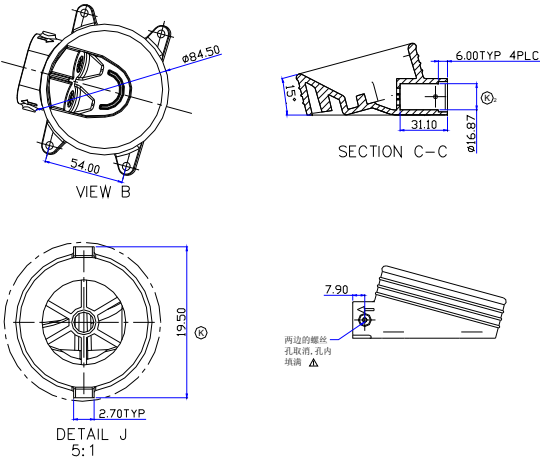
# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

制定日期	2006-6-23	发布日期	
变更 期 及其内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Toler	检验 具和方法 Tools and Methods	备注 Remark
外观 Appearance	参照样品 According to the sample	无 N/A	目测 Visually inspect	
装配 Assembly	参照样品 According to the sample	无 N/A	目测 Visually inspect	

适用范围 (Apply scope): 底座 Base (697.62)	检测方法和标准 (Inspection method and standard):
 <p>VIEW B: Dimensions include 54.00, 19.50, and 2.70 TYP.</p> <p>SECTION C-C: Dimensions include 6.00 TYP 4PLCS, 31.10, and 16.87.</p> <p>DETAIL J: Magnification 5:1, dimension 2.70 TYP.</p> <p>Additional note: 两端的螺丝孔取稍, 孔内填满 (Screw holes at both ends, fill the holes).</p>	<p>目测 (Visually inspect)</p> <p>外观检验 正常视力, 在亮度相当于40W日光灯1米高的环境下距产品30CM左右, 成45°角度进行检验 (具体检验标准参照相关文件);</p> <p>Normal eyesight and in the brightness condition it equal about 40W day light lamp over 1 meter height, keep a distance of about 30cm from the product with about a 45 degree point of view to inspect the product (Refer to the related document for detail);</p> <ol style="list-style-type: none"> <li>零件成形后的尺寸、垂直度和平面度 Pay attention to the size, uprightness and flatness of the body;</li> <li>表面无明显示刮伤、气泡、开裂、穿孔等不良 Be free of scratches, bubbles, cracks and perforation;</li> <li>相关定位尺寸参考工程图纸 Special size of the body according to the drawing;</li> <li>用客供一规检验泵体进出气口 Inspect the inlet and outlet with the gauge that supplied by client;</li> <li>油嘴装上O型圈后与底座配合要紧, 可卡入及拿出;</li> </ol> <p>The nipple should fit the body well and it's easy to enclose and pull out;</p>

制表 (Prepared by)

审核 (Audited by):

批准 (Approved by):

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

产品名称		
产品编号		
产品类别	IQC	
文件编号	JSBG04	附档数量
版 次	A/0	

制定日期	2006-6-23	发布日期	
变更日期 及其内容			

目的：为正确指导检测及操作人员提高工作效率，加强产品品质，规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tol	检验工具和方法 Tools and Methods	备注 Remark
内径 Inner diameter	φ 33.0	±0.50	卡尺 Callipers	
外径 Outer diameter	φ 39.2	±0.50	卡尺 Callipers	
Dimension C	6.3	± .25	卡尺 Callipers	
Dimension D	3.2	±0.2	卡尺 Callipers	

适用范围 (Apply scope): 塑胶盖 Spring cap

外观 测方法和标准 (Appearance inspection method and standard):

目测 (Visually inspect)

1 外观检验：正常视力，在亮度相当于40W日光灯1米高的环境下距产品30CM左右，成45°角度进行检验 (具体检验标准参照相关文件)。

Normal eyesight under the brightness condition it equal about 40W day light lamp over 1 meter height, keep a 45 degree point of view to inspect the product with about a 45 degree point of view to inspect the product (Refer to the related document for the detail)

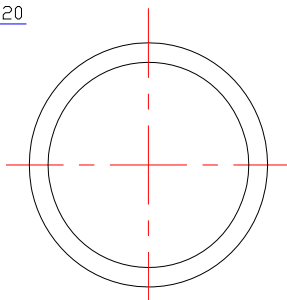
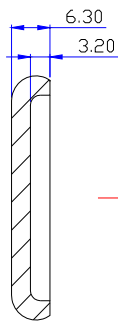
2、零件成形后的尺寸、圆度和平面度 Pay attention to the size, roundness and flatness of the body;

3 表面无明显刮伤、气泡、开裂、穿孔等不良 Be free of scratches, bubbles, cracks and perforation;

4、需 配合，不能过松、过紧，要好拿好放；

Be sure to fit well with the diaphragm and spring and be free of too tight or too loose;

The surface of the body should be smooth and the mould line should not be too obvious;



制表 (Prepared by)

审核 (Audited by):

批准 (Approved by):

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

产品名称		
产品编号		
产品类别	IPQC	
文件编号	JSBG04	附档数量
版次	A/0	

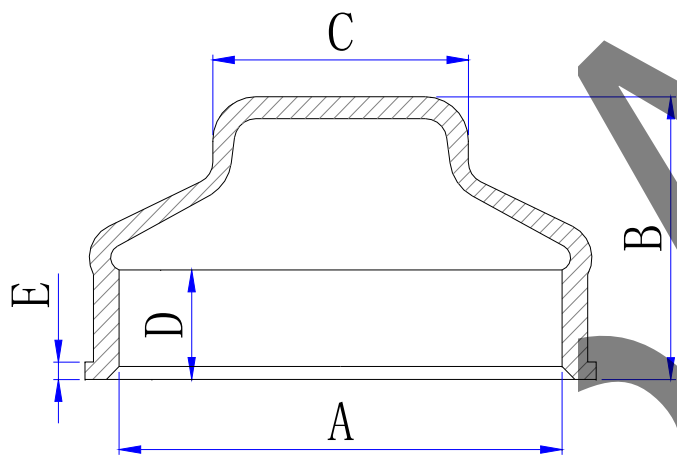
制定日期	2006-6-23	发布日期	
变更日期及其内容			

目的：为正确指导检测及操作人员提高工作效率，加强产品品质，规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and Methods	备注 Remark
A 内径 Inner diameter	φ 82.54	±0.25	卡尺 Callipers	
B 高度 Height	51.6	±0.25	卡尺 Callipers	
C	φ 47.62	±0.25	卡尺 Calliper	
D	20	±0.25	卡尺 Callipers	
E	3.18	0.10	卡尺 Callipers	
外观 Appearance	参照样品 According to the sample	无 N/A	目测 Visually inspect	
口字内容及其位置 Content and position of the mark	参照样品 According to the sample	无 N/A	目测 Visually inspect	
软硬度 Hardness	55°	5°	硬度计 Sclerometer	

适用范围 (Apply scope): 橡胶盖 Diaphragm

检测方法和标准 (Inspection method and standard):



- 目测 (Visually inspect)
- 外观检验 正常视力 在亮度相当于40W日光灯1米高的环境下距产品30CM左右，成45°角度进行检验 (具体检验标准参照相关文件)；  
Normal eyesight, under the brightness condition it equal about 40W day light lamp over 1 meter height, keep distance the related product with about a 45 degree point of view to inspect the product
  - 零件成型后的尺寸、圆度和平面度 Pay attention to the size, roundness and flatness of the body;
  - 表面无明显刮伤、气泡、开裂、穿孔等不良 Be free of scratches, bubbles, cracks and perforation;
  - 需试配合，不能过松、过紧，要好拿好放；  
Be sure to fit well with the body and be free of too tight or too loose;
- 外表面的字母印的位置要与客户确认样板一致；

制表 (Prepared by):

The letter mark 'Whale' should be same with the sample per content and position.

审核 (Audited by):

批准 (Approved by):

产品名称		
产品编号		
产品类别	IPOC	
文件编号	JSBG04	附档数量
版 次	A/0	

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

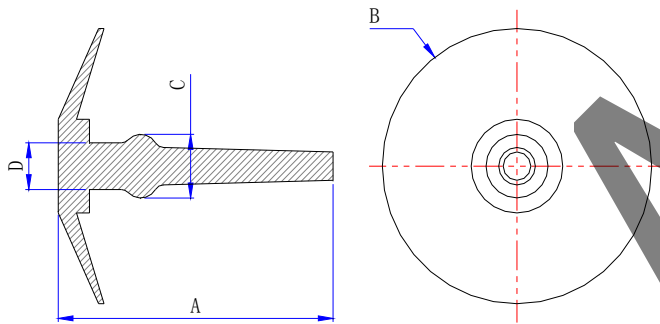
制定日期	2006-6-23	发布日期	
变更日期 及其内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and Methods	备注 Remark
A 内径 Inner diameter	15	±0.25	卡尺 Callipers	
B 高度 Height	φ 14.7	±0.10	卡尺 Calliper	
C Dimension C	φ 3.4	±0.10	卡尺 Callipers	
D Dimension D	2.5	±0.10	卡尺 Callipers	
外观 Appearance	参照样品 According to the sample	无 A	目测 Visually inspect	
软硬度 Hardness	50°	±5°	硬度计 Sclerometer	

适用范围 (Apply scope): 橡胶阀 Rubber valve

检测方法和标准 (Inspection method and standard):



- 目测 (Visually inspect)
- 外观检验: 正视力, 在亮度相当于40W日光灯1米高的环境下距产品30CM左右, 成 5°角度进行检验 (具体检验标准参照相关文件)。  
Normal eyesight, under the brightness condition it equal about 40W day light lamp over 1 meter height, keep a distance of about 30cm from the product with about a 45 degree point of view to inspect the product (Refer to the related document for details).
  - 零件成形后的尺寸、圆度和平面度 Pay attention to the size, roundness and flatness of the body;
  - 表面无明显刮伤、气泡、开裂、穿孔等不良 Be free of scratches, bubbles, cracks and perforation;
  - 需试配合, 不能过松、过紧, 要好拿好放;  
Be sure to fit well with the body (inlet and outlet) and be free of too tight or too loose;
  - 不能有裂纹和崩角等不良;  
Be free of split mark and break and the other damages;

制表 (Prepared by):

审核 (Audited by):

批准 (Approved by):

产品名称		
产品编号		
产品类别	IPQC	
文件编号	JSBG04	附档数量
版次	A/0	

# passage MAKER

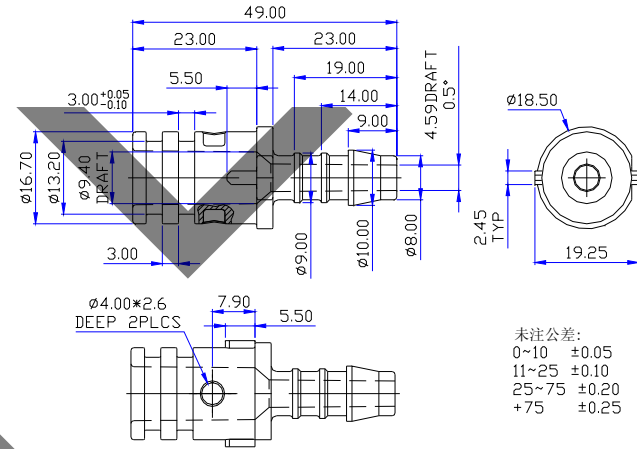
## 产品质量检验规范 (Inspection standard of product quality)

制定日期	2006-6-23	发布日期	
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目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

适用范围(Apply scope): 嘴 (10mm) 0mm Nipple

寸法(Inch)	检测项目 Test item	标准公差 Tolerance	检验工具Tools	备注Remark
1	A	φ 16.7	±0.10	卡尺Callipers
2	B	49.00	±1.00	卡尺Callipers
3	C	φ 13.2	+0.05/-0.10	卡尺Callipers
4	D	φ 8.00	±0.25	卡尺Callipers
5	E	φ 9.00	±0.25	卡尺Callipers
6	F	19.25	±0.10	卡尺Callipers
7	G	φ 18.5	±0.25	卡尺Callipers
8	H	φ 10.00	±0.25	卡尺Callip
9	I	2.45	±0.10	卡尺Callipers



客户特别关注(The special concern of customer):  
1、表面无色差、起泡、开裂及穿孔等现象;  
2、色模线不可太明显, 表面要光滑;  
The surface of the body should be smooth and the mould lines should not be too obvious;  
According to the approved counter sample:  
Need to check dia (3) with ring gauge hourly  
13.2mm 2 places  
12.7mm

外观检测方法和标准(Appearance inspection method and standard):  
目测(Visually inspect)  
1、外观检验: 正视力, 在亮度相当于40W日光灯1米高的环境下距产品30CM左右, 成45°角度进行检验(具体检验标准参照相关文件)。  
Normal eyesight under the brightness condition it equal about 40W day light lamp over 1 meter height, keep a distance of about 30cm from the product with about a 45 degree point of view to inspect the product (Refer the related document for detail)  
2、零件成形后的尺寸、圆度和平面度Pay attention to the size, roundness and flatness of the body;  
3、表面无明显刮伤、气泡、开裂、穿孔等不良Be free of scratches, bubbles, cracks and perforation;  
4 装上O型圈后与底座需试配合, 不能过松、过紧, 要好拿好放;  
Be sure it's fit well with the body when it's assembled the O-ring and be free of too tight or too loose;

制表(Prepared by):

审核(Audited by):

批准(Approved by):

产品名称		
产品编号		
产品类别	FOC	
文件编号	JSBG04	附档数量
版次	A/0	

# passage MAKER

## 产品质量检验规范 (Inspection standard of product quality)

制定日期	2006-6-23	发布日期	
变更日期 及其内容			

目的: 为正确指导检测及操作人员提高工作效率, 加强产品品质, 规范检验标准  
Purpose: Instruct the inspector and operator for product quality, work efficiency, and inspection standard

检测项目 Test item	检测标准 Standard	标准公差 Tolerance	检验工具和方法 Tools and Methods	备注 Remark
正、侧唛 Shipping mark and side mark	依照订单 According to the PO.	N/A	目测 Visually inspect	
装箱数量 Quantity	依照订单 According to the PO.	N/A	目测 Visually inspect	
产品外观 Appearance	依照样品 According to the sample	N/A	目测 Visually inspect	清洁、无披锋 Clean and be free of flash
气密性测试 Dunk test	气压 0.8bar (14.5PSI)	N/A	气压表、水箱等 Barometer, Water box, etc.	不漏气 No leak occur
模刻 Mark	依照样品 According to the sample	N/A	目测 Visually inspect	字体内容及大小 Content and size of the font
组装 Assembly	依照样品 According to the sample	N/A	目测 Visually inspect	注意橡胶阀方向、O型圈 Pay attention to the direction of the valve and the way the assembly of O-ring
组件尺寸 Size of the parts	依照图纸 According to the drawing	See inspection standard for IQC and IPQC		

- 1、表面不可有气泡、刮伤、开裂、穿孔等不良, 不可有大披锋; 橡胶盖上凸字印要清晰, 查对客户资料, 内容不可错;
- 2、油嘴装上O形圈后与底座试配要紧, 拧开螺丝可用手装入、拔出, 上紧螺丝不可拔出;
- 3、压橡胶盖, 重复三次, 确保弹簧快速回复其原始位置;
- 4、各部位配件尺寸在公差范围内;
- 5、保证进油口和出油口内橡胶阀、油嘴安装正确, 不可装反, 油嘴缺口位向下;
- 6、所有螺丝是否拧紧, 配合到位;
- 7、所有螺丝拧紧后加0.8bar (约合14.5PSI)气, 密封不漏气;
- 8、外箱上的印刷内容是否正确, 迹清楚、无错印、漏印, 正唛和侧唛要区分开;
- 9、装箱数量及放法是否正确;

- 1、Be free bubbles, scratches, cracks, perforation, flash on the surface;
- 2、Be sure the shipping mark is clearly and pay attention to the content of the mark easy to enclose and assemble with the carton;
- 3、pull the rubber cover several times should not pull it when the screw is tightened;
- 4、Pay attention to the size of each parts according to the IPQC file;
- 5、Be sure the rubber valve and the nipple is set well and the gap of the nipple should be facing down;
- 6、Be sure that all the screw tightened and fit well;
- 7、Test the babyfoot with 0.8 bar pressure and it should not leak;
- 8、Be sure the printing on the carton is correct and the letters should be clear and be free of misprint; pay attention to the shipping mark and side mark on the carton correctly;

制表(Prepared by):

审核(Audited by):

批准(Approved by):

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## 成品出货检验报告Final Inspection Report

编号: JSBQ03

产品名称 Product name		订单号 PO No.	批量 Quantity	抽检数量 Inspection quantity		
检验日期 Date		验货抽样标准: MIL-STD-105E General Inspection Level: II				
序号 Serial No.	检验项目 Inspection item	检验结果 Inspection result	数量Quantity 不良描述Desc ption of defect			
			致命Critical	严重Major	轻微Minor	
1	外观 Appearance	清洁度Clearness				
		模刻Mark				
		组装Assembly				
		破损Damages				
2	尺寸规格检查 Size/Specification					
3	包装 检查 Packing	正唛核对 Shipping mark				
		侧唛核对 Side mark				
		包装内容 Content				
		包装方式 Manner				
		包装数量 Quantity				
4	功能 Function	弹簧Spring				
		气密性测试 Dunk Test				
备注Remark: 1、具体检测标准参照FQC 文件; According to the inspection standard for FQC to inspect the items list above; 2、各组件尺寸检测数据见另表; Size of the parts please see attached files;						
摘要Summary: 致命Critical=0 重要Major=1.0 轻微Minor=2.5			致命Critical: Accept=( ) Reject=( 1 ) 发现数Defect quantity=( )			
结果判定 Disposal opinion <input type="checkbox"/> 合格(Passed) <input type="checkbox"/> 不合格(Rejected) <input type="checkbox"/> 条件接受(Accept on Deviation) <input type="checkbox"/> 待定(Pending)			严重Major: Accept=( ) Reject=( ) 发现数Defect quantity=( )			
			轻微Minor: Accept=( ) Reject=( ) 发现数Defect quantity=( )			

核准  
Approved by:

审核  
Audited by:

检验  
Inspected by: