PT.DHARMA POLIMETAL, Tbk.
Dept. : PQE

QUALITY INSPECTION SHEET

PAGE 1 of 1

CUSTOMER	: PT. ASTRA HONDA MOTOR	DRAW. REVISION	: C 2	MODEL	: K59
PART NAME	: STOPPER, HANDLE LOCK	SEPPEN NO	: M-18-F0213	QUANTITY	: 5 Pcs
PART NO.	: 53122-KZL -9300-H1	REGISTRATION NO	2c/QIS/ENG-2W/AHM-K59/I/2022	SAMPLE NO	:

CATEGORI		APPROVAL PART		VERIFICATION PART		OTHER	REMARK FOR OTHER CRITERIA	-	UNIT : mm

NO	CONTROL ITEM	TOLERANCE LOWER	TOLERANCE UPPER	INSPECTION METHOD / EQUIPMENT	SAMPLE 1	2	3	4	5	JUDGE	REMARKS
1	27	- 0.5	+ 0.5	H. Gauge							
2	27	- 0.5	+ 0.5	H. Gauge							
3	27	- 0.7	+ 0.7	H. Gauge							
4	32,5	- 0.5	+ 0.5	H. Gauge							
5	26	- 0.5	+ 0.5	H. Gauge							
(6)	34,4	-1,5	-1,0	Caliper							
(7)	Ø 32.3 2	0	+0.2	Caliper							
8	21,5	- 0.5	+ 0.5	H. Gauge							
(9)	9	-1,0	-0,5	H. Gauge							
10	6	- 0.5	+ 0.5	H. Gauge							
11	3,5	- 0.5	+ 0.5	H. Gauge							
12	0,5	-0,2	0,2	H. Gauge							
13	0,5	-0,2	0,2	H. Gauge							
(14)	0,5	0	+0.2	Profile Projector							
	Kondisi Marking			Terlihat Jelas							
15	R10	- 1.0	+1.0	Radius Gauge							
16	R27	-5,0	+5,0	Radius Gauge							
17	R10	- 1.0	+1.0	Radius Gauge							
(18)	R32,5	- -0,3	+0,3	Faro Arm							
19	R6	- 1.0	+1.0	Radius Gauge							
20	R3	- 1.0	+1.0	Radius Gauge							
21	64°	- 1°30'	+ 1°30'	Faro / Cimcore							
(22)	Press Drop Side			Pengecekan Visual							
(23)	Drawing : JSH270C			Mill. Cert. / Lab. Report							
	Simplifikasi : SPHC-P			Mill. Cert. / Lab. Report							
	t.3,2	-0,23	+ 0.23	Caliper							
(24)	Kondisi permukaan : Tidak burry, karat, cacat dan kerusakan lain.			Visual							
(25)	Pengecekan Jig Inspection			Visual							

Note :

	INSPECTED	CHECKED	APPROVED
DATE			
SIGN			
NAME			

0 = OK X = NG △ = TEMPORARY

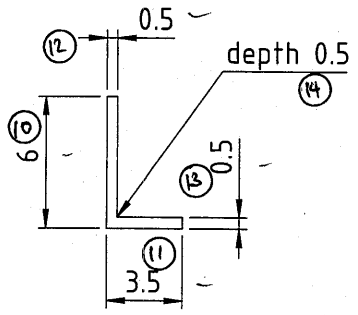
	DATE	SIGN / NAME	No	REVISION	DATE	SIGN / NAME	RESULT
MADE BY	17.01.2022	P. Mantauw					
CHECKED	17.01.2022	Slamet N	2	Revisi Drawing	25.01.2022	PMA SNG MMI	OK
APPROVED	17.01.2022	M. Imran	1	Revisi Drawing	25.01.2022	PMA SNG MMI	NG

Nur Rahmah_11:49:38_04-12-2024

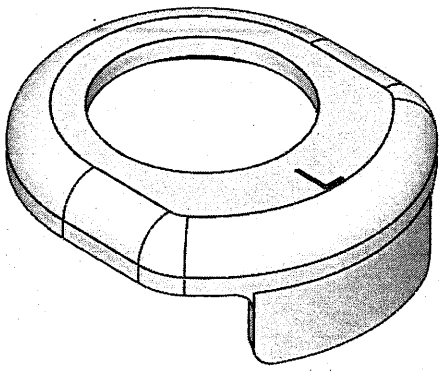
REVISION RECORD				
REV. LETTER	CHANGE NO.	DESCRIPTION	DATE	APPR.
A	M-18-F0213	DRAWING MASSPRO	14.01.22	
B	M-18-F0213	PERBAIKAN DETAIL MARKING	21.01.22	
C	M-18-F0213	PERUBAHAN TOLERANSI	23.02.22	

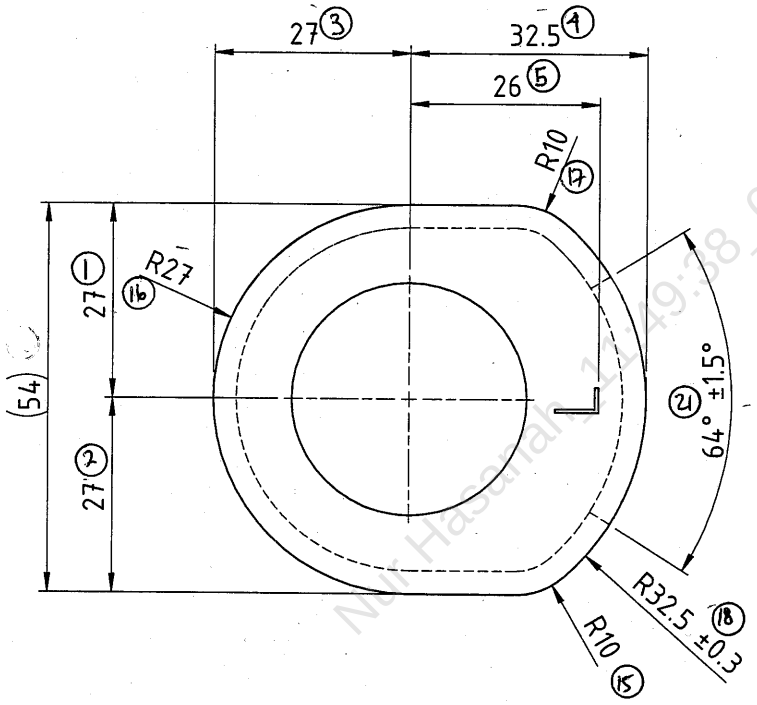
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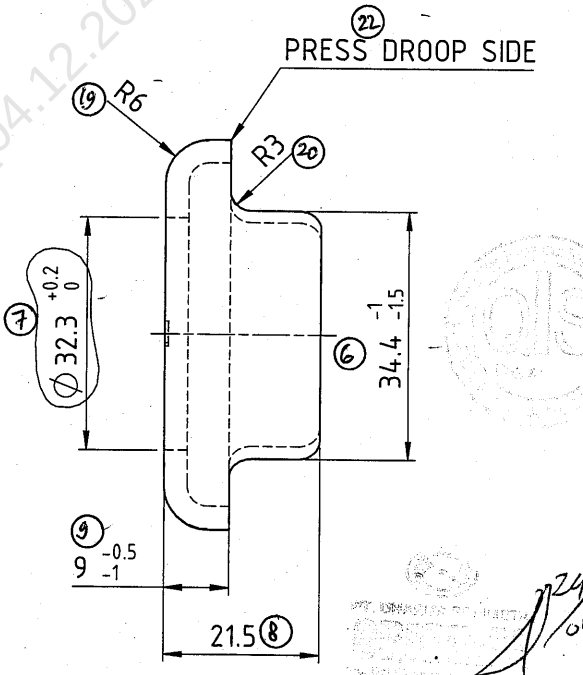
Rz 100 | Rz 100 | Rz 25 | Rz 6.3 | H K L



DETAIL MARKING







NOTE:
1) THIS PART IS PERMANENT PART OF PIPE COMP STRG HANDLE
2) NO HARMFUL BURRS AND EDGES ALLOWED
3) DIMENSION AND SHAPE NOT SPECIFIED SHALL FOLLOW 3D DATA

ITEM NO	PART NO	PART NAME	QTY	MATERIAL	MATERIAL SIMPLIFICATION	APPROX. MASS
4	53122-KZL -9301-H1	STOPPER HANDLE LOCK	1	JSH270C, t3.2	SPHC-P, t3.2	73.6 gr

HA | DRAWN. BY: DWI R 23.02.22 | CHKD. BY: BRILI 23.02.22 | APPD BY: SLAMET 23.02.22 | DEPT. ENG. IMRAN 24.02.22

AHM Q 0 | DPM Q 0 | NF

FINISH: NO BURRY, NO BURRS, BREAK ALL SHARP EDGES

DIMENSION IN INCHES

FRACTIONS	±	1/32
.000	±	.005
.00	±	.015
.0	±	.030
ANGLES	±	1/2°
HOLE DIA	+	.004
	-	.002

DIMENSION IN METRIC

GENERAL	±	JIS B 0405-M
ANGLES	±	1/2°
HOLE DIA	+	0.10
	-	0.05

DO NOT SCALE THIS DRAWING TOLERANCES
BREAK ALL SHARP EDGES FILLET .030 MAX
MACHINED SURFACES 125
UNLESS OTHERWISE SPECIFIED

PT. DHARMA POLIMETAL
JL. ANGSANA RAYA BLOK A9 NO. 8 DELTA SILIKON 1 CIKARANG 17550

TITLE: STOPPER HANDLE LOCK (PIPE COMP STRG HANDLE)

ORIGINAL DWG: 53100-K59 -A700 | CUSTOMER: AHM

SIZE A4 | DWG. No. 53122-KZL -9301-H1 | REV. LETTER C

SCALE 1:1 | SOLIDWORKS | Sheet 1 of 1

DRAWING K59
DRAWING MASSPRO
Printed 2/23/2022

Nur Hasanah 21:49:38 04.12.2024

File Name: D:\2. PROJECT\2021_KCVG\PIPE COMP STRG HANDLE\53122-KZL -9300-H1_STOPPER HANDLE LOCK