PT.DHARMA POLIMETAL, Tbk
Dept. : PQE

QUALITY INSPECTION SHEET

PT DHARMA POLIMETAL Tbk ORIGINAL Engineering Data Management Registrasi Valid if Stamp is green

PAGE 1 of 2

CUSTOMER : PT. ASTRA HONDA MOTOR	DRAW. REVISION : A	MODEL : K3V	
PART NAME : STAY RR CUSHION	SEPPEN NO : M-23-F1580	QUANTITY : 5 Pcs	
PART NO. : 50193-K3V -N001-H1	REGISTRATION NO : 001/QIS/DPM-K3V/ENG-2W/I/2024	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	41.8	-0.7	+0.7	H.Gauge							
2	6.7	-0.5	+0.5	H.Gauge							
(3)	21	0	+0.5	H.Gauge							
	▽ Rz 100	Max Rz 100		Roughness Test							
4	46.4	-0.7	+0.7	H.Gauge							
5	44.3	-0.7	+0.7	H.Gauge							
6	11.7	-0.5	+0.5	H.Gauge							
7	9.4	-0.5	+0.5	H.Gauge							
8	38.7	-0.7	+0.7	H.Gauge							
9	27	-0.5	+0.5	Caliper							
10	20	-0.5	+0.5	H.Gauge							
(11)	32	0	+0.5	H.Gauge							
12	Ø10.5	0	+0.3	Caliper							
13	R15	-5.0	+5.0	Radius Gauge							
14	R3	-1.0	+1.0	Radius Gauge							
15	R3	-1.0	+1.0	Radius Gauge							
16	79°	-3.0°	+3.0°	Bevel Protector							
17	C0.5	0	+0.4	Chamfer Gauge							
	Point Welding										
18	L = 10	min 10		Stell Rules							
	Lebar Bead Weld Θ=180°	min 5mm		Stell Rules							
	Penetrasi Weld	min 10 %		Foto Makro							
	Kondisi welding : tidak spatter, keropos, jelaga, balance length dan cacat lainnya			Pengecekan Visual							
	L = 10	min 10		Stell Rules							
	Lebar Bead Weld Θ=180°	min 5mm		Stell Rules							
	Penetrasi Weld	min 10 %		Foto Makro							
	Kondisi welding : tidak spatter, keropos, jelaga, balance length dan cacat lainnya			Pengecekan Visual							
19	Position Weld PW	Min. 450kgf.cm2		Torquemeter							
	Kondisi spot : tidak spatter, pin hole, jelaga, meleset dan cacat lainnya			Pengecekan Visual							
	Position Weld PW	Min. 450kgf.cm2		Torquemeter							
	Kondisi spot : tidak spatter, pin hole, jelaga, meleset dan cacat lainnya			Pengecekan Visual							

Note :

	INSPECTED	CHECKED	APPROVED
DATE			
SIGN			
NAME			

0 = OK X = NG △ = TEMPORARY

	DATE	SIGN / NAME	No	REVISION	DATE	SIGN / NAME	RESULT
MADE BY	10 Jan 2024	Novi .K					OK / NG
CHECKED	12/01/2024	P. Mantauw					
APPROVED	12/1/24	M. Imran					

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PT.DHARMA POLIMETAL, Tbk
Dept. : PQE

QUALITY INSPECTION SHEET

CUSTOMER	: PT. ASTRA HONDA MOTOR	DRAW. REVISION : A	MODEL : K3V
PART NAME	: STAY RR CUSHION	SEPPEN NO : M-23-F1580	QUANTITY : 5 Pcs
PART NO.	: 50193-K3V -N001-H1	REGISTRATION NO 001/QIS/DPM-K3V/ENG-2W/I/2024	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
20	**STAY**										
	Materia Spec : JSH590R, t2.9			Mill. Cert. / Lab. Report							
	Material Actual : JSH590R, t2.9										
	t2.0	-0.17	+0.17	Caliper							
21	**NUT WEDING HEX 10MM**										
	Materia Spec : S10~20C or SWRCH10~15R			Mill. Cert. / Lab. Report							
	Material Actual : SWRCH10R										
22	Kondisi permukaan : tidak burry, karat, cacat dan kerusakan lainnya			Pengecekan Visual							
23	Pengecekan Jig Inspecion			Pengecekan Visual							

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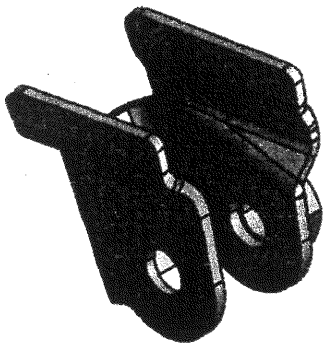
REVISION RECORD

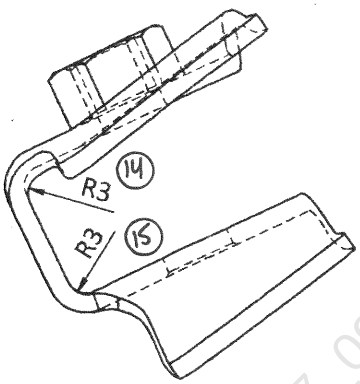
REV. LETTER	CHANGE NO.	DESCRIPTION	DATE	APPR.
A	M-23-F1580	DRAWING MASSPRO	15.11.23	

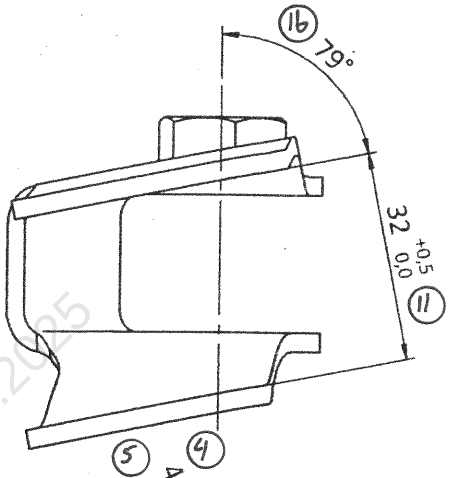
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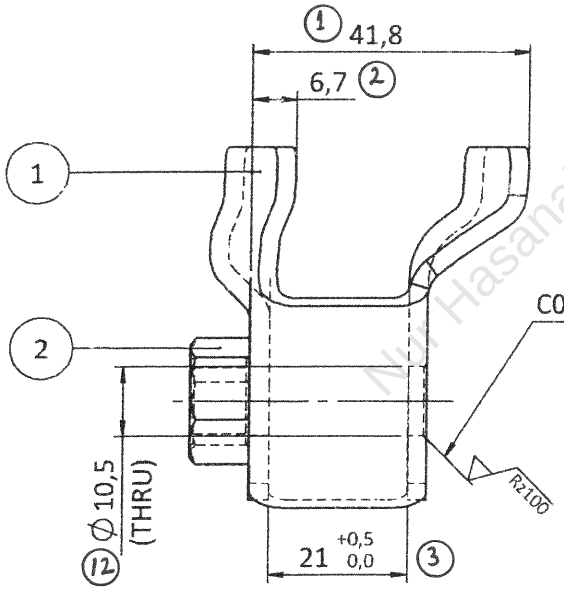
Rz 100 Rz 100 Rz 25 Rz 6.3 H K L

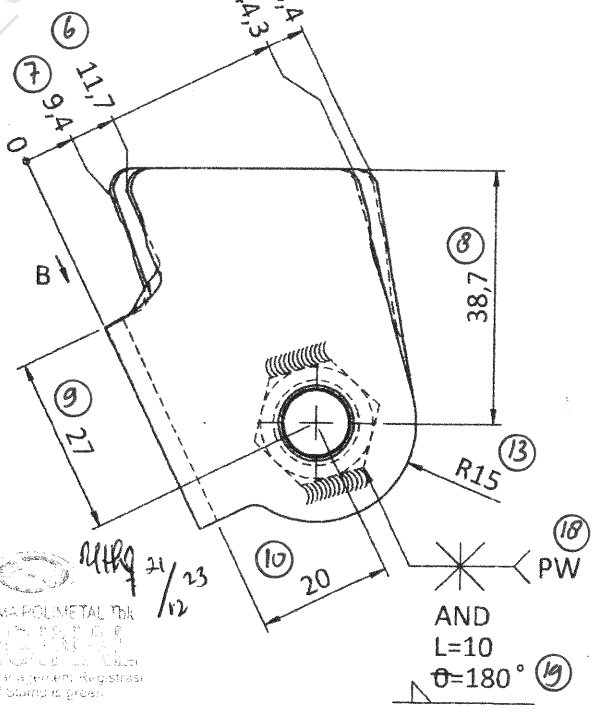
	NO	PART NO	PART NAME	QTY	MATERIAL	SIMPLIFICATION	DWG
20	1	50193-K3V -N000-20	STAY	1	JSH590R, t2.9	JSH590R, t2.9	X
21	2	94063-10000	NUT WELD HEX 10MM	1	S10~20C or SWRCH10~15R	SWRCH10R	X











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NOTE:
1) THIS PART IS PERMANENT PART OF BRKT COMP RR CROSS
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
6	50193-K3V -N000-H1	STAY RR CUSHION	1	NOTED	NOTED	116.4 gr

HA	DRAWN. BY: DWI R	08.12.23
	CHKD. BY: RYANTHA	11.12.23
AHM Q 0	APPD BY: ADVEN	11.12.23
	DEPT. ENG: IMRAN	15.12.23
DPM Q 0	FINISH: NO BURRY NO BURRS	
NF	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 NOTED

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

TITLE : STAY RR CUSHION (BRKT COMP RR CROSS)

ORIGINAL DWG :	CUSTOMER :
5019A-K3V -N000-DL	AHM

SIZE	DWG. No.	REV. LETTER
A4	50193-K3V -N001-H1	A

SCALE 1:1 SOLIDWORKS Sheet 1 of 1

DRAWING K3V
DRAWING MASSPRO
Printed: 07/12/2023