

PROCESS SHEET

Job No. _____

Date: Dec-11

P.O. Number: _____

Form # MAPS001-1098

in excel: ProcessSheet

Project Name: Protractor Compass

Part No. 7050

Part Name: Destinate D3-T

Quantity: _____

Oper. Num.	Rate	Description of Operation	B/P Dim.	Range of Actual Values	Insp. Lev.	AQL	Acc./Rj. Levels	Qty. Insp.	No. Rj.	Inspctr./Date	
		Note: All components are pre-inspected before Assembly									
10		Install Tritium (Small) into Baseplate									
		Inspect Vial Size			S-3	4	0 1				
		Inspect Adhesion: Resistance Test			S-3	4	0 1				
20		Prime Bezel, Install Clear Lens									
		Inspect for Alignment			S-3	4	0 1				
		Inspect Adhesion			S-3	4	0 1				
30		Install Tritium (1 small) into Bezel/Lens assembly									
		Inspect Vial Size			S-3	4	0 1				
		Inspect Adhesion: Resistance Test			S-3	4	0 1				
40		Assemble Dial and Magnet to Hub									
		Inspect Dial for Printing			S-3	4	0 1				
		Inspect Magnet for Cracking			S-3	4	0 1				
		Inspect Jewel for Missing			S-3	4	0 1				
50		Install Tritiums (2-Medium, 1-Small) into Dial Assembly									
		Inspect Vial Sizes			S-3	4	0 1				
		Inspect Adhesion: Resistance Test			S-3	4	0 1				
		Inspect Dial for Balance			S-3	4	0 1				
60		Install Tritium (1-Large Vial) into Shell Damping									
		Inspect White Paint Coverage			S-3	4	0 1				
		Inspect Vial Size			S-3	4	0 1				
		Inspect Adhesion: Resistance Test			S-3	4	0 1				
70		Install Shell Damping into Baseplate									
		Inspect Alignment			S-3	4	0 1				
80		Install Dial Assembly into Baseplate									
90		Install Detent into Lens Cap									
100		Install O-Ring Seal onto Baseplate									
110		Install Lens Cap onto Baseplate									
		Inspect Dial for Freedom of Movement			S-3	4	0 1				
		Rotate 360 degrees c-wise and cc-wise at 8 degree angle									
		Inspect Contamination			S-3	4	0 1				
120		Install Bezel onto Lens Cap									
		Diffusion Testing		3700 dpm							
120		Contamination Test, wipe surface of compass		900 dpm							

RATE = Estimated or Actual time per piece or operation.

B/P DIM. = Blue Print Dimensions

RANGE = Min. and Max. dimensions of checked pieces

INSP. LEV. = Level of inspection (from military tables - 105E)

AQL = Acceptable Quality Level

ACC / RJ. LEVELS = Level lot is still accepted vs. level that lot is rejected.

QTY. INSP. = Quantity inspected.

NO. OF REJECTS = Rejects quantity total.

INSPCTR. = Inspector's initials and date

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