

Smith Manufacturing
Unit 12
Tenbury Industrial Estate
Tenbury Wells
Worcs
WR15 6QW

© Retriever Technology

INSPECTION CONTROL CARD

Plan Number: CP000007 / Issue: 4

Customer : TOYOTA GB

Part Number : 00251-02077

Description : RX300 PLATE

Process No. 1 Process Name : Issue Material
Process Description : Purchase and Issue Raw material

Drawing Number : 00251-02077/2
Drawing Issue : 15/09/2005 - 2

Characteristic 1	Raw material Specification CR4 Pt 1 BS1449 / Units: (none)
Frequency & Sample Size Checking Method	Sample every delivery / Sample or strip Supplier material test certificate
Characteristic 2	Material thickness 2.5mm Nominal: 2.5000 / Lower: 2.4700 / Upper: 2.5300 / Units: millimetres
Frequency & Sample Size Checking Method	First off / 5 Micrometer
Characteristic 3	General Condition No spec. / Units: (none)
Frequency & Sample Size Checking Method	Sample every delivery / Sample or strip Visual

THE OPERATOR MUST RETAIN PARTS CHECKED IN BOX PROVIDED
FOR THE QUALITY CONTROL DEPARTMENT TO VERIFY.

IF THIS CARD BECOMES DAMAGED OR IS UNREADABLE, PLEASE CONTACT
A MEMBER OF THE QUALITY CONTROL DEPARTMENT FOR A REPLACEMENT

INSPECTION CONTROL CARD

Plan Number: CP000007 / Issue: 4

Customer : TOYOTA GB

Part Number : 00251-02077

Description : RX300 PLATE

Process No. 2 Process Name : Issue Foam
 Process Description : Purchase and Issue Foam

Drawing Number : 00251-02077/2
 Drawing Issue : 15/09/2005 - 2

Characteristic 1	Foam Width 12.0mm Nominal: 12.0000 / Lower: 11.9700 / Upper: 12.0300 / Units: millimetres
Frequency & Sample Size Checking Method	Sample every delivery / Sample or strip Vernier Rule
Characteristic 2	Foam length 60.0mm Nominal: 60.0000 / Lower: 59.9700 / Upper: 60.0300 / Units: millimetres
Frequency & Sample Size Checking Method	Sample every delivery / Sample or strip Vernier Rule
Characteristic 3	General condition No damage / Units: (none)
Frequency & Sample Size Checking Method	Sample every delivery / Sample or strip Visual

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Plan Number: CP000007 / Issue: 4

Customer : TOYOTA GB

Part Number : 00251-02077

Description : RX300 PLATE

Process No. 3 Process Name : Guillotine
 Process Description : Guillotine

Drawing Number : 00251-02077/2
 Drawing Issue : 15/09/2005 - 2

Characteristic 1	Strip width 106.0mm x 85 pitch Nominal: 106.0000 / Lower: 105.9700 / Upper: 106.0300 / Units: millimetres
Frequency & Sample Size Checking Method	Operator checks every 20 mins / Minimum 2 consecutive parts Vernier Rule
Characteristic 2	Gauge 2.50mm Nominal: 2.5000 / Lower: 2.4700 / Upper: 2.5300 / Units: millimetres
Frequency & Sample Size Checking Method	Operator checks every 20 mins / Minimum 2 consecutive parts Micrometer
Characteristic 3	General Condition No spec. / Units: (none)
Frequency & Sample Size Checking Method	Operator checks every 20 mins / Minimum 2 consecutive parts Visual

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Plan Number: CP000007 / Issue: 4

Customer : TOYOTA GB

Part Number : 00251-02077

Description : RX300 PLATE

Process No. 4 Process Name : Blank and Pierce
 Process Description : Blank and pierce

Drawing Number : 00251-02077/2
 Drawing Issue : 15/09/2005 - 2

Characteristic 1	Blank & pierce As stage sample / Units: (none)
Frequency & Sample Size Checking Method	2 parts initial set-up / Minimum 2 consecutive parts Visual to Master sample
Frequency & Sample Size Checking Method	minimum 2 consecutive parts / N/A N/A
Frequency & Sample Size Checking Method	Operator checks each hour / N/A N/A
Characteristic 2	Hole diameter 6.0mm Nominal: 6.0000 / Lower: 5.9700 / Upper: 6.0300 / Units: millimetres
Frequency & Sample Size Checking Method	2 parts initial set-up / Minimum 2 consecutive parts Vernier
Frequency & Sample Size Checking Method	Operator checks each hour / N/A N/A
Characteristic 3	Slot size A 8.0mm Nominal: 8.0000 / Lower: 7.9700 / Upper: 8.0300 / Units: millimetres
Frequency & Sample Size Checking Method	Operator checks each hour / Minimum 2 consecutive parts Vernier
Characteristic 4	Slot Size 2 6.0mm Nominal: 6.0000 / Lower: 5.9700 / Upper: 6.0300 / Units: millimetres
Frequency & Sample Size Checking Method	Operator checks each hour / Minimum 2 consecutive parts Vernier
Characteristic 5	General condition No damage No burr. / Units: (none)
Frequency & Sample Size Checking Method	Operator checks each hour / Minimum 2 consecutive parts Visual to First off sample

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Plan Number: CP000007 / Issue: 4

Customer : TOYOTA GB

Part Number : 00251-02077

Description : RX300 PLATE

Process No. 5 Process Name : Raise
 Process Description : Raise/ Form complete

Drawing Number : 00251-02077/2
 Drawing Issue : 15/09/2005 - 2

Characteristic 1	Raised height Nominal: 10.0000 / Lower: 9.9700 / Upper: 10.0300 / Units: millimetres
Frequency & Sample Size Checking Method	First off / Minimum 2 consecutive parts Height Gauge
Frequency & Sample Size Checking Method	Operator checks each hour / N/A N/A
Frequency & Sample Size Checking Method	Last off inspection / N/A N/A
Characteristic 2	Raised width Nominal: 60.0000 / Lower: 59.9700 / Upper: 60.0300 / Units: millimetres
Frequency & Sample Size Checking Method	First off / Minimum 2 consecutive parts Height Gauge
Frequency & Sample Size Checking Method	N/A / N/A N/A
Characteristic 3	Raised width 2 Nominal: 8.0000 / Lower: 7.9700 / Upper: 8.0300 / Units: millimetres
Frequency & Sample Size Checking Method	First off / Minimum 2 consecutive parts Height Gauge
Characteristic 4	General condition No damage No scores / Units: (none)
Frequency & Sample Size Checking Method	First off / Minimum 2 consecutive parts Height Gauge

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Plan Number: CP000007 / Issue: 4

Customer : TOYOTA GB

Part Number : 00251-02077

Description : RX300 PLATE

Process No. 6 Process Name : Finish
 Process Description : finish

Drawing Number : 00251-02077/2
 Drawing Issue : 15/09/2005 - 2

Characteristic 1	Finish Quality / Units: (none)	No degradation	No blemishes	No paint runs	no water marks
Frequency & Sample Size Checking Method	Sample every delivery / 100% Visual to Master sample				

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