

J.C. SALES & MFG. CO.
3610 Camanche Pkwy. N.
Ione, CA 95640
(800) 527-6347

O.P.C. /SPC Document

SHEET 1 OF 1

Cust. Name J & W Scientific. Part# 810-0126 Rev-3 Operation # Machining
Heat/Lot # 456-27 Name Nut, Ferrule Frequency Every 25 pieces

Feature Stage #1	DATE													
	TIME													
	OPER.													
.1299 + .005 - .0005 x .24		MEASURE WITH PIN GAGES/CALIPERS												
	SAM 1													
Reverse Medium Diamond Knurl		MEASURE WITH OPTICAL COMPARATOR												
	SAM 1													
40 Deg. x .0465 Thru ± .005		MEASURE WITH PIN GAGES/OPTICAL COMPARATOR												
	SAM 1													
.39 ± .010 DIM.		MEASURE WITH CALIPERS												
	SAM 1													
	SAM 1													
Feature Stage #2	DATE													
	TIME													
	OPER.													
M4 x 7 Thread x .16 ± .010		MEASURE WITH THREAD PLUG GAGE/CALIPERS												
	SAM 1													
.094/.188 ± .005 DIM.		MEASURE WITH 0-1" MIC./CALIPERS												
	SAM 1													
	SAM 1													
	SAM 1													
	SAM 1													

NOTE: REPORT ANY OUT OF CONTROL OR OUT OF SPECIFIED CONDITIONS TO THE
MANUFACTURING SUPERVISOR OR Q.A. MANAGER IMMEDIATELY !! **STOP**