DEMO WORKSHOP

PRECISION MACHINING

CONTROL PLAN

UTILLATGE – 12x6

Ref. DMK-001 · Ed. A · Rev. 1

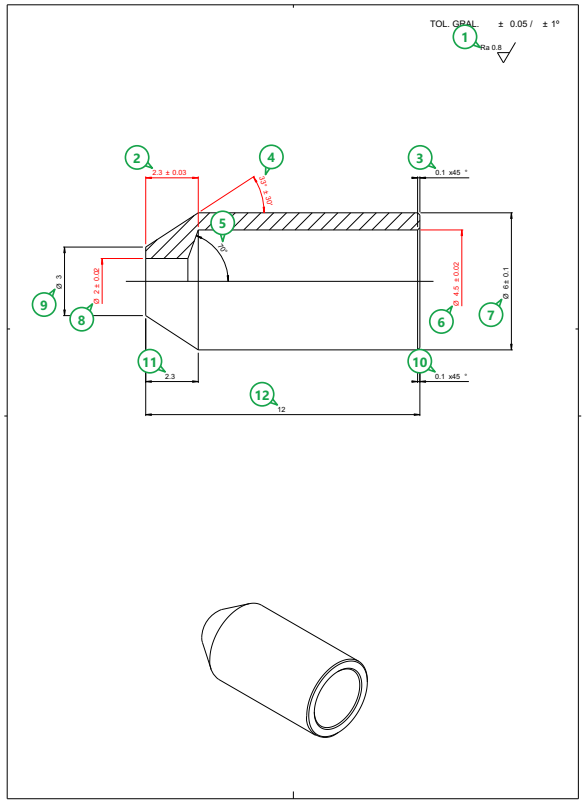
CUSTOMER	DECOMEETING
CUSTOMER NO.	10001
CUSTOMER REF.	DMK1001P
INTERNAL REF.	DMK-001
MATERIAL	ACER INOX. AISI-303 (AMS 5640) de Ø7h9
DRAWING ED.	A
PLAN REV.	1
W.O.	12001
QUANTITY	3500
HEAT NO.	C-1234
STUDY / MACH.	DECO/20-Nº104
MACHINE TIME	Objectiu 45 p/h.
DATE	03/11/2026
PREPARED BY	Demo
REVIEWED BY	Quality
DRAWING	DMK-001.DXF

DMK-001 ED A

CUSTOMER DECOMEETING | MATERIAL ACER INOX. AISI-303 (AMS 5640) de Ø7h9 | W.O. 12001 | QUANTITY 3500

DRAWING WITH BALLOONS

12 dimensions · Workbench numbering



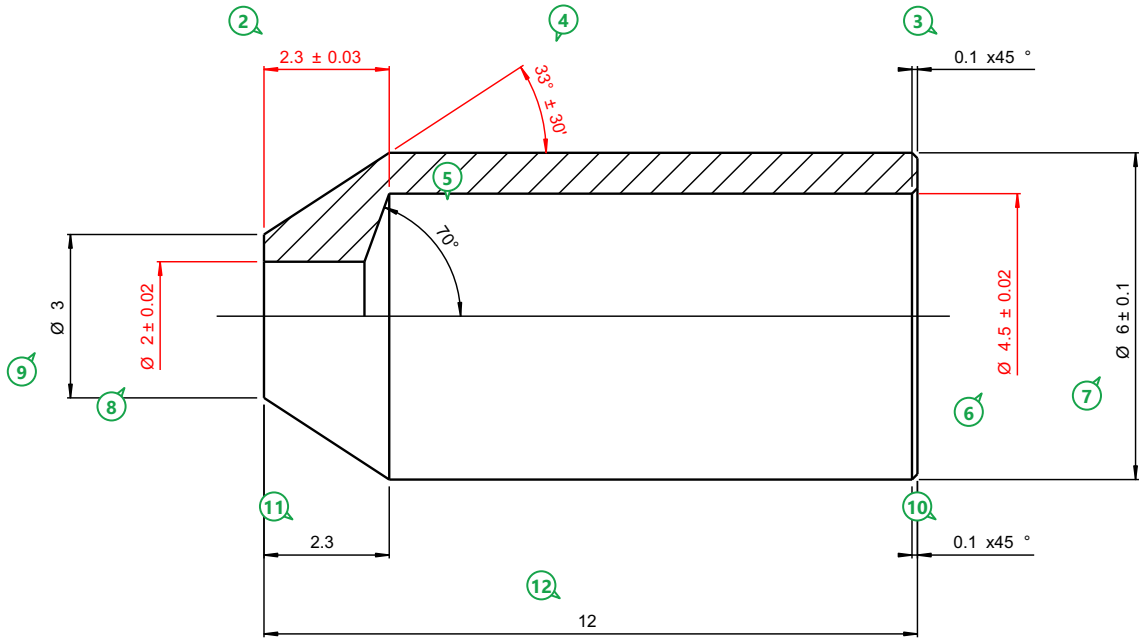
12	4	4	100 %	4	40 µm
DIMENSIONS	CRITICAL	IN RED on the drawing	VERIFIED 12 of 12	INSTRUMENTS	MIN. BAND dimension 6

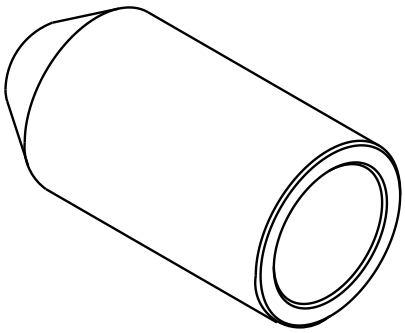
PROTOCOL · DIMENSION 0 · VIS · 1P/1H

Dimensions as per drawing. No burrs, marks or impurities OK / KO · Re= Record dimensions

TOL. GRAL. ± 0.05 / ± 1°

1 Ra 0.8





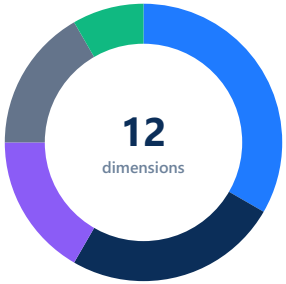
DIMENSIONS PER INSTRUMENT

Which instrument measures each dimension

PAL	Palmer	4
PYP	Profile projector	4
PDR	Caliper	3
RUG	Roughness tester	1

CHARACTERISTIC TYPES

What DIMETRIK recognises on the drawing



Ø	Diameter	4
L	Length	3
∠	Angle	2
C	Chamfer	2
Ra	Roughness	1

FREQUENCIES AND VERIFICATION

How often it is checked, and what is already verified

1P/1H	1 part / 1 hour	12

VERIFICATION IN THE WORKBENCH 100 %

12 of 12 dimensions verified

- 4 in red on the drawing

TIGHTEST TOLERANCE BANDS

Maximum – minimum, in microns: where most care is needed

6	Ø 4,5 ± 0,02	40 µm
8	Ø 2 ± 0,02	40 µm
2	2,3 ± 0,03	60 µm
10	0,1 x45 °	100 µm
11	2,3	100 µm
12	12	100 µm
3	0,1 x45 °	100 µm
9	Ø 3	100 µm

CONTROL EQUIPMENT

This part's instruments, with their numbers

PRY	Vernier caliper	P93
PAL	Palmer	M11

PROTOCOL AND NOTES

What every plan says, and what this one says

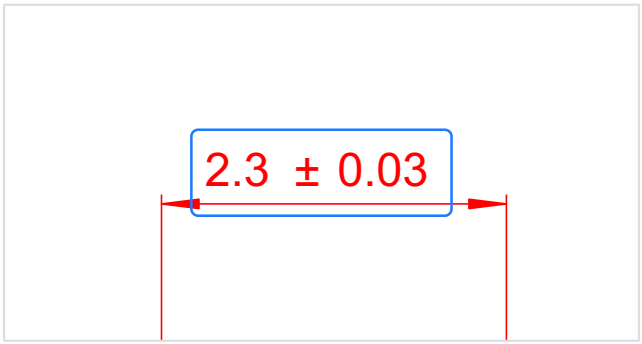
Dimensions as per drawing. No burrs, marks or impurities OK / KO

The setter will measure 100% of the dimensions and Quality, if it sees fit, will measure whatever is needed to give production the OK. If VICI malfunctions, measure manually with the equipment indicated in the plan.

Re= Record dimensions

No FUNC, COMP, change or remarks on the sheet.

No.	Type	Characteristic	Nominal	Tol. +	Tol. −	Min.	Max.	Tol. band	Equipment	Freq.	View	Status
2	L	2,3 ± 0,03	2,3	+0,03	-0,03	2,27	2,33	60 µm	PDR Caliper	1P/1H 1 pc / 1 h	—	✓
6	Ø	Ø 4,5 ± 0,02	4,5	+0,02	-0,02	4,48	4,52	40 µm	PAL Palmer	1P/1H 1 pc / 1 h	—	✓
8	Ø	Ø 2 ± 0,02	2	+0,02	-0,02	1,98	2,02	40 µm	PAL Palmer	1P/1H 1 pc / 1 h	—	✓
4	∠	33° ± 30'	33	+0,5	-0,5	32,5	33,5	1°	PYP Profile projector	1P/1H 1 pc / 1 h	—	✓
11	L	2,3	2,3	+0,05	-0,05	2,25	2,35	100 µm	PDR Caliper	1P/1H 1 pc / 1 h	—	✓
12	L	12	12	+0,05	-0,05	11,95	12,05	100 µm	PDR Caliper	1P/1H 1 pc / 1 h	—	✓
7	Ø	Ø 6 ± 0,1	6	+0,1	-0,1	5,9	6,1	200 µm	PAL Palmer	1P/1H 1 pc / 1 h	—	✓
9	Ø	Ø 3	3	+0,05	-0,05	2,95	3,05	100 µm	PAL Palmer	1P/1H 1 pc / 1 h	—	✓
5	∠	70°	70	+1	-1	69	71	2°	PYP Profile projector	1P/1H 1 pc / 1 h	—	✓
3	C	0,1 x45 °	0,1	+0,05	-0,05	0,05	0,15	100 µm	PYP Profile projector	1P/1H 1 pc / 1 h	—	✓
10	C	0,1 x45 °	0,1	+0,05	-0,05	0,05	0,15	100 µm	PYP Profile projector	1P/1H 1 pc / 1 h	—	✓
1	Ra	Ra 0,8	0,8	—	-0,8	0	0,8	0,8µm	RUG Roughness tester	1P/1H 1 pc / 1 h	—	✓

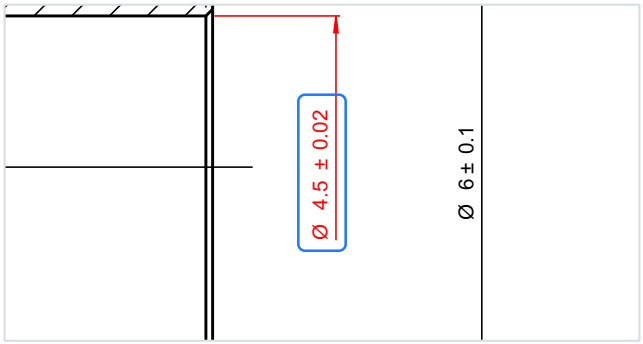


2 2,3 ± 0,03

NOMINAL	TOL.	MIN.	MAX.
2,3	+0,03 / -0,03	2,27	2,33

PDR · Caliper · 1 part / 1 hour

Tolerance band: 60 µm

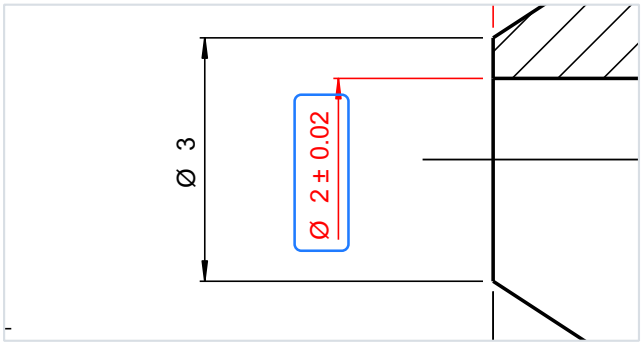


6 Ø 4,5 ± 0,02

NOMINAL	TOL.	MIN.	MAX.
4,5	+0,02 / -0,02	4,48	4,52

PAL · Palmer · 1 part / 1 hour

Tolerance band: 40 µm

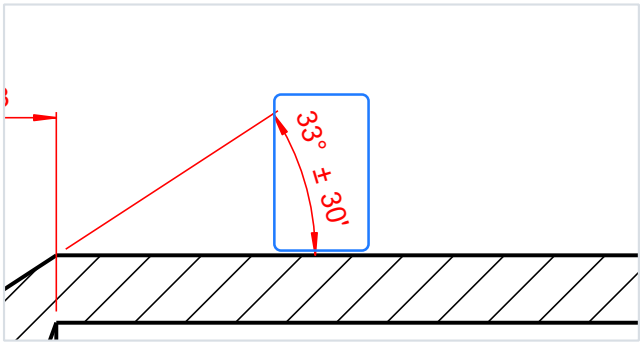


8 Ø 2 ± 0,02

NOMINAL	TOL.	MIN.	MAX.
2	+0,02 / -0,02	1,98	2,02

PAL · Palmer · 1 part / 1 hour

Tolerance band: 40 µm



4 33° ± 30'

NOMINAL	TOL.	MIN.	MAX.
33	+0,5 / -0,5	32,5	33,5

PYP · Profile projector · 1 part / 1 hour

Tolerance band: 1°

PART NAME	CUSTOMER REF.	INTERNAL REF.	DRAWING ED.	PLAN REV.
UTILLATGE – 12x6	DMK1001P	DMK-001	A	1

CUSTOMER	MATERIAL	W.O.	QUANTITY	HEAT NO.	STUDY / MACH.	DRAWING
DECOMEETING	ACER INOX. AISI-303 (AMS 5640) de Ø7h9	12001	3500	C-1234	DECO/20-Nº104	DMK-001.DXF

No.	Characteristic	Tolerance	Equipment	Freq.	DATE:	NAME:	TIME:
0	Dimensions as per drawing. No burrs, marks or impurities OK / KO	OK / KO	VIS	1P/1H			
0	Functionality	OK / KO	Funcional	1P/1H			
2	2,3 ± 0,03	2,27 ÷ 2,33	PDR	1P/1H			
6	Ø 4,5 ± 0,02	Ø 4,48 ÷ Ø 4,52	PAL	1P/1H			
8	Ø 2 ± 0,02	Ø 1,98 ÷ Ø 2,02	PAL	1P/1H			
4	33° ± 30'	32º30' ÷ 33º30'	PYP	1P/1H			
11	2,3	2,25 ÷ 2,35	PDR	1P/1H			
12	12	11,95 ÷ 12,05	PDR	1P/1H			
7	Ø 6 ± 0,1	Ø 5,9 ÷ Ø 6,1	PAL	1P/1H			
9	Ø 3	Ø 2,95 ÷ Ø 3,05	PAL	1P/1H			
5	70°	69º00' ÷ 71º00'	PYP	1P/1H			
3	0,1 x45 °	CH 0,05 ÷ CH 0,15 44º00' ÷ 46º00'	PYP	1P/1H			
10	0,1 x45 °	CH 0,05 ÷ CH 0,15 44º00' ÷ 46º00'	PYP	1P/1H			
1	Ra 0,8	Ra 0 ÷ Ra 0,8	RUG	1P/1H			
				Defect			
				NOK parts			

CONTROL EQUIPMENT

PRY Vernier caliper P93
PAL Palmer M11

REMARKS

FUNC
COMP
CHANGE
REMARKS

SIGNATURES

LEVEL	DATE	PREPARED BY	REVIEWED BY
1	03/11/2026	Demo	Quality

The setter will measure 100% of the dimensions and Quality, if it sees fit, will measure whatever is needed to give production the OK. If VICI malfunctions, measure manually with the equipment indicated in the plan.

Re= Record dimensions

PART NAME	CUSTOMER REF.	INTERNAL REF.	DRAWING ED.	PLAN REV.
UTILLATGE – 12x6	DMK1001P	DMK-001	A	1

CUSTOMER	MATERIAL	W.O.	QUANTITY	HEAT NO.	STUDY / MACH.	DRAWING
DECOMEETING	ACER INOX. AISI-303 (AMS 5640) de Ø7h9	12001	3500	C-1234	DECO/20-Nº104	DMK-001.DXF

ORDER OPERATIONS

1.
2.
3.
4.
5.
6.
7.
8.

Op.	Supplier dispatch date	End date	Good	Rejected	Defect	Responsible	Issues / returns

PART NAME	CUSTOMER REF.	INTERNAL REF.	DRAWING ED.	PLAN REV.
UTILLATGE – 12x6	DMK1001P	DMK-001	A	1

CUSTOMER	MATERIAL	W.O.	QUANTITY	HEAT NO.	STUDY / MACH.	DRAWING
DECOMEETING	ACER INOX. AISI-303 (AMS 5640) de Ø7h9	12001	3500	C-1234	DECO/20-Nº104	DMK-001.DXF

Op.	Supplier dispatch date	End date	Good	Rejected	Defect	Responsible	Issues / returns

REMARKS

CUSTOMER	INTERNAL REF.	CUSTOMER REF.
DECOMEETING	DMK-001	DMK1001P

PART NAME
UTILLATGE – 12x6

DRAWING ED.	HEAT NO.	QUANTITY	MATERIAL
A	C-1234	3500	ACER INOX. AISI-303 (AMS 5640) de Ø7h9

W.O.

12001

Op.	Description	Date	Approved

DMK-001 ED A

Shift	Date	Approved

REMARKS

PART NAME	CUSTOMER REF.	INTERNAL REF.	DRAWING ED.	PLAN REV.
UTILLATGE – 12x6	DMK1001P	DMK-001	A	1

CUSTOMER	MATERIAL	W.O.	QUANTITY	HEAT NO.	STUDY / MACH.	DRAWING
DECOMEETING	ACER INOX. AISI-303 (AMS 5640) de Ø7h9	12001	3500	C-1234	DECO/20-Nº104	DMK-001.DXF

Stop date and time	Restart date and time	Reason	Responsible

CONTROL EQUIPMENT

PRY Vernier caliper P93
PAL Palmer M11

PART NAME	CUSTOMER REF.	INTERNAL REF.	DRAWING ED.	PLAN REV.
UTILLATGE – 12x6	DMK1001P	DMK-001	A	1

CUSTOMER	MATERIAL	W.O.	QUANTITY	HEAT NO.	STUDY / MACH.	DRAWING
DECOMEETING	ACER INOX. AISI-303 (AMS 5640) de Ø7h9	12001	3500	C-1234	DECO/20-Nº104	DMK-001.DXF

Any change of lot or heat is checked before marking continues.

CHECKED BY THE SETTER · FIRST PART — DATE — SIGNATURE

No.	Type	Position	Marking description	Notes
Note 1				
Note 2				
Note 3				
Note 4				
Note 5				
Note 6				

CHECKED BY THE OPERATOR · FIRST PART — DATE — SIGNATURE

No.	Type	Position	Marking description	Notes
Note 1				
Note 2				
Note 3				
Note 4				
Note 5				
Note 6				

CHECKED BY THE OPERATOR · LAST PART — DATE — SIGNATURE

No.	Type	Position	Marking description	Notes
Note 1				
Note 2				
Note 3				
Note 4				
Note 5				
Note 6				

DMK-001 MACH.: DECO/20-N°104

Pin gauges						
Thread ring gauge						
Thread plug gauge						
Plain ring gauge						
Plain plug gauge						
Hex plug gauge						
Spline ring gauge						
Functional						
Instruments	PAL M11 PRY P93					
Vici gauge						

DMK-001 MACH.: DECO/20-N°104

Pin gauges						
Thread ring gauge						
Thread plug gauge						
Plain ring gauge						
Plain plug gauge						
Hex plug gauge						
Spline ring gauge						
Functional						
Instruments	PAL M11 PRY P93					
Vici gauge						

PART NAME	CUSTOMER REF.	INTERNAL REF.	DRAWING ED.	PLAN REV.
UTILLATGE – 12x6	DMK1001P	DMK-001	A	1

CUSTOMER	MATERIAL	W.O.	QUANTITY	HEAT NO.	STUDY / MACH.	DRAWING
DECOMEETING	ACER INOX. AISI-303 (AMS 5640) de Ø7h9	12001	3500	C-1234	DECO/20-Nº104	DMK-001.DXF

NOTES / ISSUES