AJT301597(1/2)

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CTQ Table

No.	CTQ Item	Unit	Value & Tolerance			Z-Value	
			Target	LSL	USL	Zst	Zit
1							
2							
3							
4							

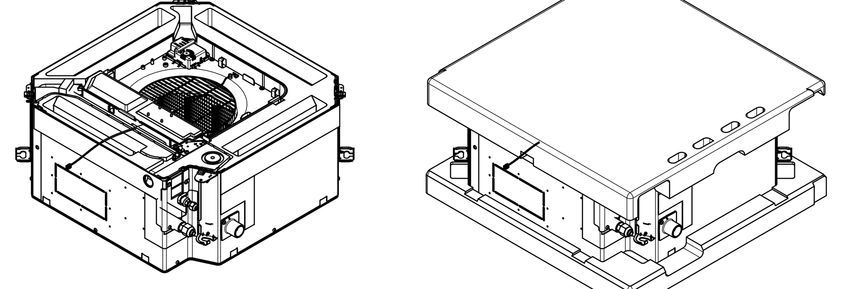
Dimension		Definition	Mark	Inspection Mass Prod.	Inspection 1st Part
관리치수 (Working Dimension)	CTQ/CTP 치수 (CTQ/CTP Dimension)	제품 성능 및 안전성 등의 중요 품질에 영향을 주는 핵심 특성치(Core characteristic value which can make a serious effect to function or safety of the product)	CTQ	√	√
	양산관리 치수 (Mass production management dimension)	양산 부품의 중심치 변동 확인을 위한 치수로, 입고 또는 협력회사 출하검사 시 관리되어야 할 항목(Dimension for the specification deviation management of the mass production part, it should be checked with incoming inspection by LG-IQC or outgoing inspection by supplier)	⬭	√	√
제작치수 (Design Dimension)	개발관리치수 (Development management dimension)	설비의 올바른 제작 여부 확인을 위한 치수로, 제작된 금형/Jig 품에 대한 초품검사 대상 항목(Dimension for new equipment's approval, all that dimension should be checked at FPA-stage for approval)	⊕	-	√
	참고치수 (Reference Dimension)	설계 사상 반영 또는 금형/Jig 제작을 위한 치수 (실제 측정 불가항목 또는 비중요 치수)(Dimension for the design concept application or Mold/Jig making, or another reference)	-	-	-

General Tolerance

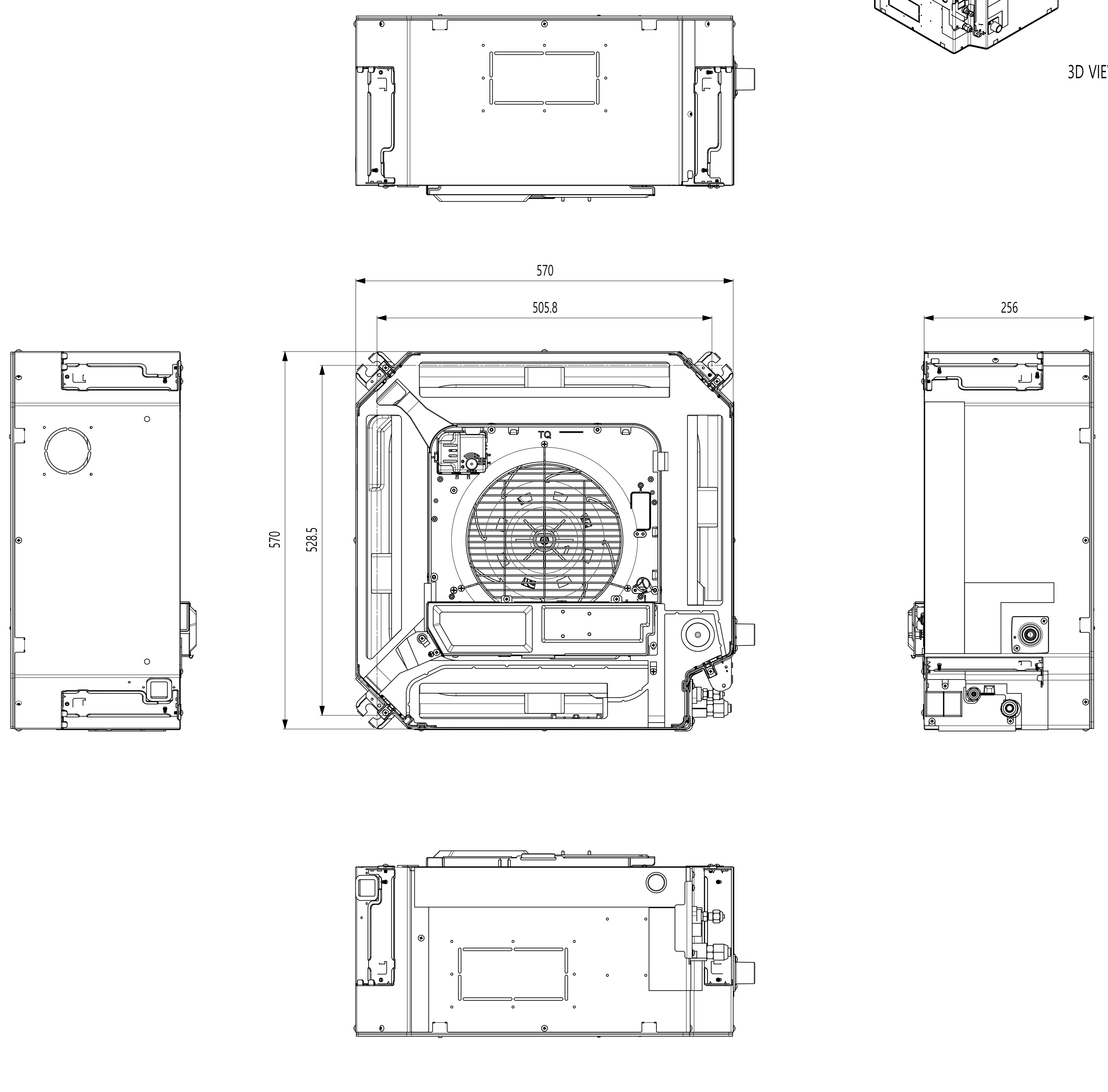
Tolerance Grade		Length(±mm)							
Mark	Classification(a < L≤b)	0.5~3	3~6	6~30	30~120	120~400	400~1000	1000~2000	2000~4000
F	Fine (≒J-Grade)	0.05	0.05	0.1	0.15	0.2	0.3	0.5	-
M	Medium (≒K-Grade)	0.1	0.1	0.2	0.3	0.5	0.8	1.2	2.0
(C)	Coarse (≒L-Grade)	0.2	0.3	0.5	0.8	1.2	2.0	3.0	4.0
V	Very Coarse (≒M-Grade)	-	0.5	1.0	1.5	2.5	4.0	6.0	8.0

Tolerance Grade		Round/Chamfer(±mm)			Angle (±Degree° Minute′ Second″)				
Mark	Classification(a < L≤b)	0.5~3	3~6	6 < L	L≤10	10~50	50~120	120~400	400 < L
F	Fine (≒J-Grade)	0.2	0.5	1.0	1°	30'	20'	10'	5'
M	Medium (≒K-Grade)	0.2	0.5	1.0	1°	30'	20'	10'	5'
(C)	Coarse (≒L-Grade)	0.4	1.0	2.0	1°30'	1°	30'	15'	10'
V	Very Coarse (≒M-Grade)	0.4	1.0	2.0	3°	2°	1°	30'	20'

02 ZRNU153TQAA Qty	01 ZRNU183TQAA Qty	WORK APPLICATION NO	P/NO	DESCRIPTION	SPEC
1	1	1	AJF77087804	Structure Assembly,Module(Indoor)	- EAU32165801 AHA75113305 ZRNU183TQAA.ANWALUS TR 2024 NEW
-	1	2	ACT30060401	Cycle Assembly,Module(Indoor)	- ADL55996001 ZRNU183TQAA TQ MultiV R32 M-4Way for USA
1	-	2	ACT30060402	Cycle Assembly,Module(Indoor)	- ADL55996001 ZRNU153TQAA TQ MultiV R32 M-4Way for USA
-	1	3	ABQ30315905	Case Assembly,Control Module(Indoor)	ZRNU183TQAA TQ 2024 NEW
1	-	3	ABQ30315906	Case Assembly,Control Module(Indoor)	ZRNU153TQAA TQ 2024 NEW
1	1	4	AMA30003401	Interface Assembly,Module	ZRNU183TQAA TQ Multi V R32 for USA
-	1	5	AAA31473901	Accessory Assembly,Module(Indoor)	ZRNU183TQAA TQ Multi V R32 for USA
1	-	5	AAA31473902	Accessory Assembly,Module(Indoor)	ZRNU153TQAA TQ Multi V R32 for USA
1	1	6	AGF76713303	Package Assembly,Indoor	TQ TQ GLOBAL 12 NEW (LAP+ASA+LUS+LAR)



3D VIEW



재질주기(MATERIAL)
1. 각 재질 및 부품 Spec.은 단품 도면을 참조할 것.
2. 본 부품은 LG전자의 Level A-1 유해물질 관리기준을 철저히 준수하고, 상세 내용은 LG전자 유해물질 관리기준 LG(10)-A-9023 및 협력사 제품 유해물질 관리 운용 가이드를 참조할 것. HBCDD, TCEP, TDCPP 등의 사용금지 Level A-II 물질은 사업부별 유해물질 검사 기준을 참조할 것.

3. 기타 재료의 상세내용은 원재료 Maker의 승인원에 준할 것.

생산주기(PRODUCTION)
1. 도면 치수 이외 형합성 및 조립성 검토를 위한 치수는 3D Data 참조할 것.
2. 운송, 취급시 찍힘, 변형, 흠이 발생하지 않도록하며, 내부에 이물질의 침투가 없도록 할 것.

3. 작업시 외관상 흠이나 유해한 결함이 발생하지 않도록 할 것.
4. 조립 방법 및 순서는 WISS의 작업 지도서를 따를 것.

검사주기(INSPECTION)
1. "⊕" 표시 부위는 개발 관리 치수로 관리할 것.
" ⬭ " 표시 부위는 양산 관리 치수로 관리할 것.

신뢰성주기(RELIABILITY)
해당없음.

MATERIAL SPECIFICATIONS
1. Refer to the single item drawing for each material and part spec.
2. This part should comply with the criteria of Level A-I restricted hazardous substances which refers to LGE standard LG(10)-A-9023 and the hazardous substance management manual for the supplier. Level A-II restricted substances such as HBCDD, TCEP, TDCPP should comply with hazardous substances inspection standard by each division.
3. Details of other materials should be in accordance with the approval of raw material maker.

PRODUCTION SPECIFICATIONS
1. Refer to 3D Data for dimension for assembly review, excluding drawing dimensions
2. When transporting, do not get any marks, deformations or scratches, and do not allow foreign matter to penetrate inside.
3. The surface should be no harmful defects or scratching in operation.
4. The assembly method and procedure should follow the WISS.(Work Instruction Support System)

INSPECTION SPECIFICATIONS
1. "⊕" marked dimensions are development management dimension and should be controlled.
" ⬭ " marked dimensions are mass production management dimension and should be controlled.

RELIABILITY SPECIFICAITONS
N/A

WORK	Spec	Net Weight(kg)	Gross Weight(kg)
02	ZRNU153TQAA ANWALUS TQ Multi V R32 for USA	14.2	16.7
01	ZRNU183TQAA ANWALUS TQ Multi V R32 for USA	14.2	16.7

SYM.	REVISION	ECO NO.	DATE	PREPARED

DIE/MOLD TYPE		UNIT	mm	SCALE	1/4	TITLE	Unit Assembly,Indoor TQ Chassis
필수입력 Essential input		DESIGNED	REVIEWED	CHECKED	APPROVED		
DIE MAKER	MANUFACTURER	작성일자 작성자	검도일자 검도자	심사일자 심사자	승인일자 승인자		
필수입력 Essential input	필수입력 Essential input	LG Electronics			SHEET NO. 1 OF 1	DWG. NO.	AJT301597(1/2)

AJT301597(1/2)

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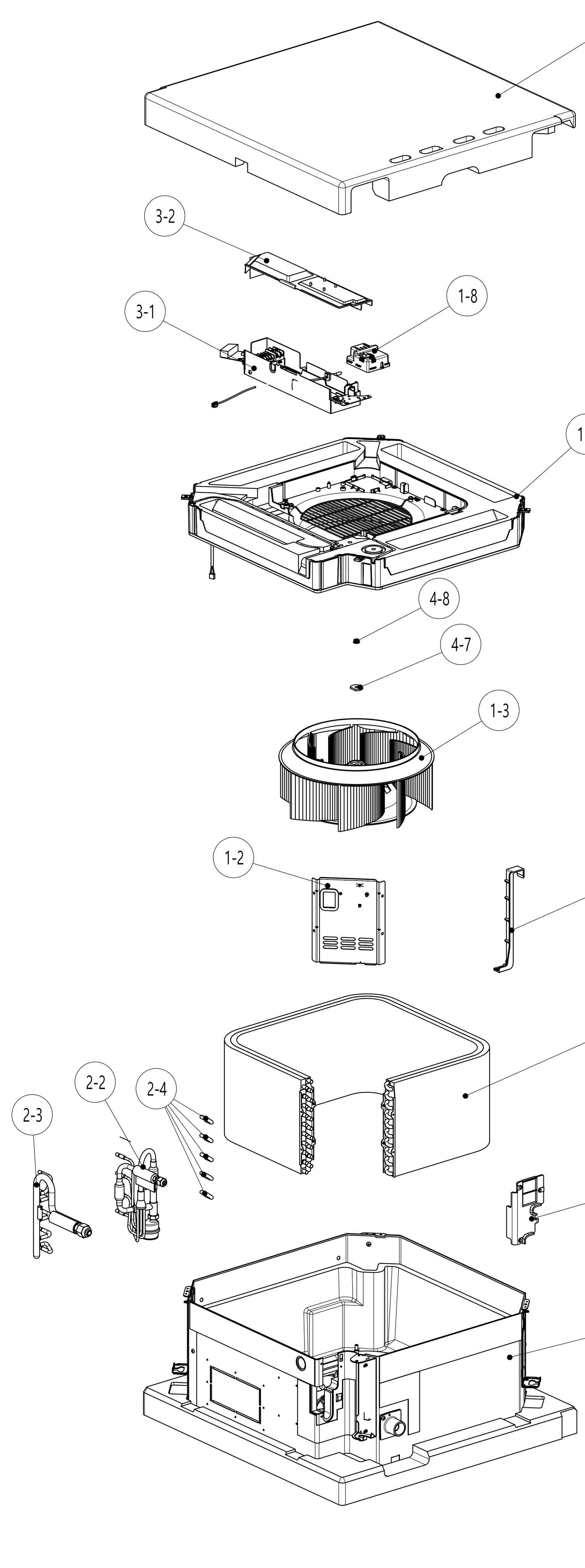
CTQ Table



EXPLODED VIEW

SYM.	REVISION	ECO NO.	DATE	PREPARED

DIE/MOLD TYPE		UNIT	mm	SCALE	1/4	TITLE	Unit Assembly,Indoor TQ Chassis
필수입력 Essential input		DESIGNED	REVIEWED	CHECKED	APPROVED		
DIE MAKER	MANUFACTURER	작성일자 작성자	검도일자 검도자	심사일자 심사자	승인일자 승인자		
필수입력 Essential input	필수입력 Essential input	LG Electronics			SHEET NO. 1 OF 1	DWG. NO.	AJT301597(2/2)