


Bicycle Inspection Report 自行车成品检验记录表

Customer 客户	Global	Order 订单	HQ-XDS-14021	Spec 车架规格	700C	Color 颜色	Follow Order	Date 日期	2014-08-14
Factory 制造工厂	XDS	Batch Qty	285 sets	assembly 装配级别	85%	Model 车种	STELLA INTERNAL 3-SP	AQL	MIL-STD-105E AQL=1.5
NO.	Inspection item 检验项目		Australian Standard Clause	Inspection standard 检验标准				Judge 判定	
1	Packing 包装检验	1.1		Carton correspond with products,the packing position correct 纸箱与产品内容须相符,成车装箱位置正确				✓	
		1.2		Firmly lashed down,No bruising collapse after the drop test 捆绑牢固,落地试验后车架及各料件不得有碰伤挤坏等情形				✓	
		1.3		Small materials box included 小包料件依小包明细,料件不可漏放、错放。				✓	
2	Bikes 成车	2.1	2.2	Bicycles shall have no unfinished sheared metal edges or other sharp parts that are exposed to hands or legs. The following parts shall not have edges as well: at each end of the front mudguard, at the rear end of the rear mudguard, at each end of the chainguard, at the end of the kickstand. 任何手与腿可触及部分不能有尖点以及锐边,下列部位也不得有任何尖点锐边: 前泥板两端, 后泥板后端, 链罩末端以及支架末端				✓	
		2.2	2.3	No fastener shall fracture, loosen, or otherwise fail its function during test. Screw lengths shall be fully engaged, or for a distance greater than one nominal screw diameter. 紧固件测试后不能有任何裂纹, 松脱以及功能失效。螺帽应能完全旋入螺丝, 或者旋入至少1倍螺丝直径的长度。				✓	
		2.3	2.4	 There shall be no projections in the area bounded as shown in the figure above. 上图所示的阴影区域内不能有任何突出物				✓	
		2.4	2.5.1	1. The ends of the inner control cables shall be provided with end protectors to prevent unravelling. The end shall withstand a removal force on 20N 所有控制线尾端应装配有保护帽防止松散,保护帽拉脱力为20N。				✓	
		2.5	2.5.2	Control cables shall be fitted in such a way as will ensure the effects of abrasion are minimal. 控制线的装配应尽量使磨损的影响减小到最低限度				✓	
3	Marks on frame 车架标记	3.1	1.5.(b)	The identification number shall be permanently and legibly stamped or engraved on the frame. (Serial number) 车架上应清晰标有永久性不可磨灭之车架标记(流水号)				✓	
		3.2	1.5.(a)	The name and address in Australia of the manufacturer, importer or other supplier shall be permanently and legibly marked on the frame. 应清晰标有在澳大利亚的自行车制造商, 进口商或供应商的名称和地址。				✓	
4	Labelling and Manuals 标签和说明书	4.1	1.6.2 Fully assembled bicycles with handlebars misaligned 完全组装车把未调整	A label with following warning statement shall be attached to the handlebar. 需在车把上贴上印有如下警告语句的标签 CAUTION: Before riding align the handlebars correctly with the forks, adjust the seat height, and tighten in accordance with instructions in the manual.					
		4.2	1.6.3 Partially assembled bicycles with handlebars misaligned and only pedals detached from the frame. 车把未调整脚踏未组装	A label with following warning statement shall be attached to the handlebar. 需在车把上贴上印有如下警告语句的标签: CAUTION: Before riding attach pedals and align the handlebars correctly with the forks, adjust the seat height, and tighten in accordance with the instructions in the manual.					
		4.3	1.6.4 (a) All other partially assembled bicycles 所有其它部分组装成车	Following warning shall printed on the outside of carton (In bold capital letters at least 15 mm in height) 如下所示的警告语句需印刷在包装外箱上 (大写字母至少15MM高) CAUTION: THIS IS A PARTIALLY ASSEMBLED BICYCLE REQUIRING THE ATTACHMENT OF THE FOLLOWING PARTS IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS				✓	
		4.4	1.6.4 (b) All other partially assembled bicycles	A list of the components needing assembly, the tools to use (recommendation on torque wrench) shall also printed on the carton. (In medium width capital letters at least 10 mm in height) 需要装配的部件, 需要使用的工具(推荐使用扭力扳手)等信息需印刷于外包装箱上, 中等宽度的大写字体最少10mm高度				✓	
		4.5	1.6.4 (b) All other partially assembled bicycles	Following warning message shall be printed on outer carton. (The word 'warning' shall be in capitals at least 20 mm in height and remainder of the message in capital letters at least 10 mm in height.) 如下警告语句需标注于包装箱上 (WARNING单词大写字母至少20MM高其它的至少10MM高) WARNING: IN THE INTERESTS OF SAFETY IT IS RECOMMENDED THAT YOU HAVE THE BICYCLE ASSEMBLED BY A SKILLED BICYCLE MECHANIC.				✓	
		4.6	1.7	Confirm current manual is included (BIA copyright 2010) 确认产品包含最新版的说明书(BIA copyright 2010)				✓	
		4.7	1.7 & 3.1	Confirm clear and adequate instructions for the completion of the assembly of the bike are included in the manual. 确认说明书中包含清晰、完整的组装成车的指引内容。				✓	
5	Fork assembly 车架前叉组立	5.1		The ball bearings are full with grease, it can move flexibly after assembly. 组件钢珠应上足黄油,前叉组立后应转动灵活				✓	
		5.2		Head tube 1# cup locking torque: 300 ~ 350kgf.cm 车头1#碗锁紧扭力:300~350kgf.cm				✓	
6	BB assembly 五通组.组立	6.1		BB parts should with full grease, so it can move flexibly after assembly. 五通组件钢珠应上足黄油,组立后中轴转动顺畅,松紧适度				✓	
		6.2		BB lock ring locking force is 300 ~ 500kgf.cm 五通紧固圈锁紧力为300~500kgf.cm				✓	
7	Chainwheel assembly 大齿盘组立	7.1		Chain ring running smoothly 齿盘运转顺畅,不掉链,不挂齿				✓	
		7.2		Chainwheel runout ≤ 1mm ,pulse volume≤ 1mm, 齿盘偏摆≤1mm,跳动量≤1mm				✓	
		7.3		clearance ≥3mm 组装后与车架间隙须≥3mm				✓	
		7.4		Locking torque: Nut Type:380~450kgf.cm; Bolt Type:420~500kgf.cm 齿盘锁紧扭力				✓	
8	Shifter assembly 变速器组立	8.1		FD position correct, the clearance between outer guide and biggest chainring is 1 ~ 3mm 前变速器组装位置须正确,外导片距大齿盘最大片间隙为1~3mm					
		8.2		变速器锁紧力为Locking force:前变 FD: M5: 40~60kgf.cm; 后变 RD: 间接式Indirect: 40~60kgf.cm; 直接式direct: 80~110kgf.cm					
9	Chain 链条	9.1	2.10	Proper length , the chain pin ends protruding length less than 0.2mm 长度适当,链条销子两端突出长度差<0.2mm				✓	
		9.2	2.10	Do not have dead section, the rotation should be smooth. 不可有死节,转动应顺畅				✓	
		9.3		Single speed chain tightness: 5 ~ 20mm 单速车链条松紧度为:5~20mm				✓	
10	The brake assembly 夹器组立	10.1		Adjustable brake shoes,upper and lower margin of 2mm. 刹车块应为可调式,上下裕度2mm				✓	
		10.2		Caliper to locking screw, locking torque of 60 ~ 90kgf.cm 夹器锁紧螺丝锁紧扭力60~90kgf.cm				✓	

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					√	X
11	Tyre 轮胎	11.1	2.8.3	Tyre should have the mark of pressure, font height $\geq 3\text{mm}$ 外胎须有压力标示, 字体高度 $\geq 3\text{mm}$	✓	
		11.2		Assembly of the tyre per the direction of tyre or tread on tyre. 须依轮胎箭头方向或胎纹方向组装	✓	
		11.3		After assembly, the cable out uniformity, inflation of 50% ~ 75% 组装后安全线均匀浮出, 轮胎充气至轮胎建议胎压的50%~75%	✓	
12	Hub 花古	12.1		Axle length same as show in spec, running flexibly. 轴心长度依规格表, 转动要灵活不可有松动现象	✓	
13	Rim 轮圈	13.1		After assembly, the deflection should be not too large. 组装后偏摆不可过大: 铝圈 alloy rim: 轴向偏摆 axial $\leq 0.8\text{mm}$ 纵向偏摆 direction $\leq 0.8\text{mm}$ 铁圈 steel rim: 轴向偏摆 axial $\leq 2\text{mm}$ 纵向偏摆 direction $\leq 2\text{mm}$	✓	
14	Spoke 钢丝	14.1		After assembly, spoke not exceed nipple, exposing the thread $\leq 1\text{mm}$ 组装后钢丝不得超过铜头, 露出牙纹 $\leq 1\text{mm}$ 。	✓	
		14.2		钢丝张力须均匀, 钢丝张力 tension: 前轮 F.tyre: 110~130kgf.cm; 后轮 R.tyre: 110~130kgf.cm 后偏心轮 rear eccentric wheel : 左 Left 90~110kgf.cm; 右 Right 110~130kgf.cm	✓	
	Spoke Protection	14.3	2.9.2	The rear wheel of bicycles with derailleur gears must be fitted with a spoke protector. 带后拨的飞轮必须安装辐条保护盘。	✓	
15	F.R wheel assembly 前后轮组立	15.1	2.8.2	The wheel assembly shall be aligned so that the clearances between the rim and the frame and the tyre and the frame are respectively not less than 5 mm and not less than 3 mm when the wheel is rotated to any position. 车轮应装正, 轮圈与车架、轮胎与车架之间的间隙分别不少于 5MM、3MM。	✓	
		15.2		Locking torque: 300 ~ 350kgf.cm 前后轮组立后锁紧扭力: 300~350kgf.cm	✓	
		15.3		QR pull-off force $\geq 13\text{kgf.cm}$ 快拆型轴心锁紧后快拆拉力 $\geq 13\text{kgf.cm}$	✓	
	Locking device (锁定机构)	15.4	2.8.1 (a)	Front and rear wheels shall be secured locked to the frame. The minimal removal torque $\geq 80\%$ * recommend torque. 前后轮应安全锁定。松脱扭矩需大于推荐锁紧扭矩值的80%	✓	
	Wheels retention 车轮保持力	15.5	2.8.1 (b)	A removal force of 2300N, 30s. Front wheel and Rear wheel No relative movement 一大小为2300 N的拉力保持30秒, 前后轮不能脱落。	✓	
	Quick-release devices 快拆装置	15.6	2.8.1 (c)	Quick-release devices form and marking shall clearly indicate whether the mechanism is in the open or locked position. The force required to close a properly set lever shall not exceed 200 N. The releasing force of the clamping mechanism when closed shall not be less than 50 N. 快拆上应有 OPEN/CLOSE 标识, 锁紧的扭力不超过 200N, 松开的扭力不少于 50N.	✓	
	Wheels positive retention 正向保持	15.7	2.8.1 (d)	Positive retention function, not loosen when tested as defined in the standard 需具有正向保持功能, 在测试时不能松脱。	✓	
16	Handlebar 车把	16.1	2.12.1	• Comfort control 舒适控制 • Max. width 最大宽度: 700 mm	✓	
		16.2	2.12.2	• Ends shall be capped 车把把末端应被保护 • Ends protection shall withstand a removal force of 70 N 末端保护机构应能承受一70N的拉脱力	✓	
		16.3		It can running flexible in the area of front 60° 车手正确组立后应在正前方位置左右60°范围内转向灵活	✓	
17	Stem 立杆	17.1	2.12.3 (a)	Must have a minimum insertion mark, the mark from the bottom of stem should be at least 2.5 times of dia of stem 须有最低插入标记, 插入标记距离立杆下端至少应为立杆直径的2.5倍	✓	
		17.2		The leading stem with grease. 锌棒与钨丝配合处须加黄油	✓	
		17.3	2.12.3 (b)	The vertical clearance between the top of steerer tube and the top face of the handlebar stem with associated spacers in place, shall be 2.5 mm minimum. The maximum clearance shall be 15% of the height of the handlebar stem. 配无牙竖管前叉, 顶盖与前叉竖管顶端距离最少2.5mm, 最多不超过立管高度的15%		
		17.4		The single screw locking torque: 180 ~ 200kgf.cm, the force 500kgf.cm, driver not displacement, double screw locking torque: 130kgf.cm, 800kgf.cm driver shall not force displacement 与车手组立后单螺丝锁紧扭力: 180~200kgf.cm, 施力 500kgf.cm 车手不得位移, 双螺丝锁紧扭力: 130kgf.cm, 施力 800kgf.cm 车手不得位移	✓	
	Handlebar stem to fork connection	17.5	2.12.3 (b)	The dimensional tolerance of the outside diameter of the handlebar stem with respect to the inside diameter of the fork tube shall be from a minimum of a sliding fit to a maximum clearance of 1.0 mm. 车把立管外部直径与前叉头管内部直径差应小于1.0毫米	✓	
18	Brake lever 刹车手把	18.1		Locking torque: 60 ~ 90kgf.cm 握把座锁紧扭力: 60~90kgf.cm	✓	
19	Shifter lever 变速手把	19.1		Locking torque: 40~60kgf.cm 变速手把座螺丝锁紧力: 40~60kgf.cm	✓	
20	Grip 把手套	20.1		Without grease when assembled, assembly correct 组装时不得加润滑剂, 并须完全组装到位	✓	
21	Shifter function 变速功能	21.1		Running smoothly 变速时变速芯线运作顺畅, 不可与固定物摩擦	✓	
		21.2		Running smoothly, exactly, without noise 各段变速应顺畅, 迅速准确, 不可有杂音及跳齿情形	✓	
22	Braking System	22.1	2.14.1 & 2.14.2 & 2.14.2.1	All Bicycles shall be equipped with not less than two brakes, one on the front and one on the rear. On childrens bikes one brake shall be a back-pedal brake. Front brake lever on RHS of handlebar, Rear brake on LHS of handlebar. 所有自行车应配有前后两个刹车装置, 儿童车应配有倒刹。手刹右前左后。	✓	
	Lever attachment 刹把附件	22.2	2.14.2.2	Readily accessible to the rider. Withstand Vibration, with locking devices. 便于操控. 能承受振动, 装配有锁定机构	✓	
	Handgrip dimension	22.3	2.14.2.3	Point A: pivot point of lever. A点: 刹把中点 D $\leq 90\text{mm}$ (Adult's bicycle). D $\leq 60\text{mm}$ (Children's bicycle) D: grip dimension 刹把尺寸 Point B: the point 12 mm from the end of the lever. B点: 距刹把末端12mm的标记点 BD -AC $\leq 12\text{mm}$. Line AC and BD are parallel to the handlebar centerline 测量时: 线AC与BD和车把中心线平行	✓	
	Pre-travel force travel force (预置力)	22.4	2.14.2.4	Correctly adjust the brake system as per's instruction. Use force F to cause the brake pad contact with the rim. F $\leq 45\text{N}$ 当施加45N的作用力在刹把上能保证刹车块接触到轮圈	✓	
	Cantilever brakes 悬臂闸	22.5	2.14.2.8	A safety device shall be fitted to prevent the stirrup cable from contacting the tyre in the event of failure of the main brake cable. 当主刹线断裂时, 必须有个安全装置来保护其控制线以免接触到轮胎		
		22.6	2.14.3.1 & 2.14.3.2 & 2.14.3.3	Operating force: Back-pedal brakes shall be actuated by a force applied to the pedal in a direction opposite to that of the drive force. The differential between the drive and brake positions of the crank shall be not more than 60° when the crank is placed alternately against each position under a torque of not less than 15 Nm. Independent Operation: The brake mechanism shall function independently of any drive-gear position or adjustment. 应能用一与驱动方向相反的作用力控制。倒刹60度应有刹车效果, 在刹车以及驱动方向各用15N.m的扭矩作用, 两个位置的角度差不能超过15度。刹车系统应不受齿轮位置以及调节影响, 独立作用	✓	
	Brake lever operating force 刹车手把操作力	22.7		Force $\leq 45\text{kgf.cm}$, brake shoes touch rim more than 10, consecutive parts shall not be damaged 施力 $\leq 45\text{kgf.cm}$, 刹车鞋与车圈接触, 连续10次以上各零件不得损坏脱落	✓	
23	Chaincover on Childrens Bike	23.1	2.9.1 (a)	A guard enclosing at least the upper junction of the chain and chainwheel. 链罩须完全覆盖链轮和链条的上部分。		
		23.2	2.9.1 (b) (i) & (ii)	Shield the chain for a distance of at least 25 mm prior to the first engagement point. Disc guard Ø chainwheel guard - Ø chainwheel $\geq 10\text{mm}$ 需保护从链条与链轮第一个结合点向后25mm这段距离, 盘链罩直径需大于链轮齿顶圆直径10mm以上		

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					√	X
23	Chaincover 链罩	23.3		The chain cover to cover the chain at least 90 ° (1/4) above 链罩要覆盖在链条上及覆盖到齿盘至少90° (1/4)面以上	✓	
		23.4		Chaincover end from rear axle must be within 80mm. 链罩尾端向后到后轮轴心必须在80mm以内	✓	
		23.5		Chaincover from top to front, the width twice than chain width. 链罩上端由后轮至链罩最前端部分,链罩宽度须为链条宽度的2倍	✓	
		23.6		Chaincover rear width must bigger than 1/2 of chain width. 链罩后端宽度须大于或者等于链条宽度的1/2	✓	
24	Kickstand 停车架	24.1		The tilt angle is 7 ~ 12 ° 组立后停车倾斜角度为7~12°	✓	
		24.2		支架向前5~20mm	✓	
		24.4		Screw locking 180~230kgf.cm 中立停车架螺丝锁紧力为180~230kgf.cm	✓	
		24.5		Do not touch the frame and spare parts, and in parallel with the chain stay 支架不可碰触车架及各零配件,且与下叉处于平行状态	✓	
25	rack 货架	25.1		Tilt 2~3° 组装后向前倾斜2~3°	✓	
26	seat post 座管	26.1	2.13	Must have a minimum insertion mark, the mark from the bottom of stem should be at least 2.5 times of dia of stem. The seat pillar and saddle assembly shall incorporate a substantial positive means of preventing the pillar from penetrating the saddle. 须标有一最低插入安全标记,安全线位置由底端至少为其直径的2倍	✓	
	screw 座管螺丝	26.2		The locking torque of 150 ~ 180kgf.cm. 锁紧扭力为150~180kgf.cm		
		26.3		QR pull-off force ≥7kgf.cm 快拆型锁紧后拉脱力≥7kgf.cm	✓	
	Saddle 座垫	26.4		The locking torque of 150 ~ 180kgf.cm 与座管组立后锁紧扭力为150~180kgf.cm	✓	
		26.5		Horizontal thrust ≥ 23kgf.cm, saddle without removable, baby stroller halved 水平推力≥23kgf.cm,座垫无移位,童车减半	✓	
27	Reflector. All reflectors must comply to AS 2142 反光片	27.1	2.15.2.5	White front reflector, higher than front wheel. 前反光片为白色, 组装后高于前轮	✓	
		27.2	2.15.2.2	Red rear reflector, higher than axle, from middle of saddle ≥75mm 后反光片为红色,组装后高于轮轴,距座垫中心面 ≥75mm	✓	
		27.3		Angle 90° ±5° 反光片组立角度90°±5°	✓	
		27.4		Reflector bracket should be able to withstand thrust ≥ 9kgf.cm and reflective angle move ≤ 5 ° 反光片架锁紧后应能承受 ≥9kgf.cm推力而反光片角度位移 ≤5°	✓	
		27.5	2.15.2.3	Reflector. All reflectors must comply to AS 2142 轮反光片应为黄色, 符合澳洲标准AS2142	✓	
		27.6	2.15.2.3 (b)	Clearance between wheel reflector and inner wheel rim ≤76mm 轮反光片组于车轮后距轮圈内侧 ≤76mm	✓	
28	Pedal 脚踏	28.1	2.11.1	Must be symmetrical. 必须左右对称,上下面都应有脚踏面	✓	
		28.2		Should have “L”、“R” mark. 应有“L”、“R”标记	✓	
		28.3	2.15.2.4	W/reflector, yellow reflector. All reflectors must comply to AS 2142 有脚踏反光片,反光片为黄色, 符合澳洲标准AS2142	✓	
29	Safety angle 安全倾角	29.1	2.6.1 & 2.6.2	Pedal flat in the lowest state, bicycle vertical position to one side, adult bike ≥ 25 ° childrens bike ≥ 20 ° pedal don't touch the ground 脚踏处于最低状态放平,自行车垂直位置向一侧倾斜,成人车 ≥25°童车 ≥20°而脚踏不触及地面。	✓	
30	Toe clearance (脚趾间隙)	30.1	2.7	Bicycles (not equipped with toe clips) Toe clearance ≥88 mm 未装配脚套的自行车,间隙 ≥88 mm	✓	
31	Height of handle bar and saddle 车手与座垫高度差	31.1	2.12.1	Lowest of saddle ≤400mm Highest of handle bar 车手调至最高,座垫调至最低,高度差 ≤400mm	✓	
32	Decal 商标	32.1		Position correct, no missing, wrinkling foaming, skew, damage situation 商标的贴位置须符合档案,不可有漏贴,起皱,起泡,歪斜,破损等情形	✓	
33	training wheel 辅助轮	33.1		The highest is 10~25mm 支架调至最高时轮子离地面应在10~25mm之间		
		33.2		The distance between frame and training wheel ≥175mm 车架中心线的垂直平面距每个辅助轮的垂直平面水平距离应 ≥175mm		
34	Painting 油漆	34.1		Paint color same as color code, No scratches 烤漆件颜色与色卡、色管须保持一致,油漆不可有碰伤	✓	
		34.2		Cross-cut test: cut into 1mm square, then use the transparent adhesive stick on the paint surface, the paint not come off when remove the adhsvie 百格试验:用刀片横竖割成1mm方格,然后用透明胶粘在油漆表面,撕开后不得有脱漆现象	✓	
		34.3		Drop test: drop a 8.5g solid steel ball from 1.5 mH, The paint not come off. 落球试验:使用8.5g的实心钢球从1.5米高试验管中垂直落下,表面油漆不得有脱落现象	✓	
		34.4		Hardness test: H pencil write on the paint surface, no any scratched 硬度试验:用H级铅笔在油漆表面划漆膜不得有损伤	✓	
35	Warning device 警告装置	35.1	2.16	An efficient bell or some other suitable audible warning device shall be fitted. 出口澳洲的自行车须一只有用的车铃或者其他鸣响警告装置	✓	
Defects Found 异常原因说明						
Solution 改善处理对策				Final judge 综合判定	YES 合格 <input checked="" type="checkbox"/>	
					NO 不合格 <input type="checkbox"/>	
				Reject 不合格处理	Inspect all 全检 <input type="checkbox"/>	
					Ok this time 特采 <input type="checkbox"/>	
					Rework 重工 <input type="checkbox"/>	

Approve 批准:

Check 审核: 

OQC成品检验: Sean Du