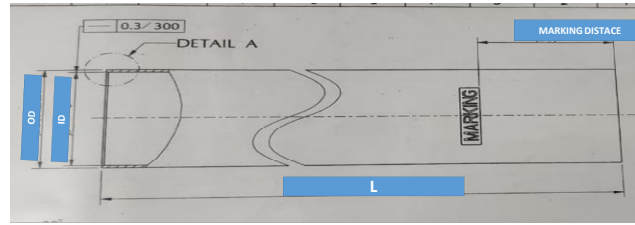


ACCRETE ELECTROMECH PVT. LTD. AURANGABAD.				STANDARD OPERATING PROCEDURE		DOC NO:SOP/PROD/40 REV. NO: 04 REV. DATE: 15.10.24	
M/C NO:	AE/MK/01,AE/MK/02, AE/MK/03,AE/MK/04	OPERATION NO: OPRATION Disc:	40 Marking	CELL NAME	Marking cell		
M/C NAME	Marking machine	PART NAME	Outer Tube				

SETTING PROCEDURE

01: JOB SETTING :

- Set the number punches in the marking block as per master tag.
- Set the mandrel as per size
- Clamp the marking block into machine
- Set the pressure as per table 02
- Press the ON switch of machine.
- load the tube in the mandrel
- Press the pedal
- To check the job
- If job is not ok then to keep in rejection box
- Then follow the Sr No.6
- If job ok then first 5 job to check
- Fill the first 5 piece report and verified by QA person
- Then strat the production



02: OPERATING PROCEDURE

- Load tube in to mandrel.
- Press the pendal for to start the marking.
- Ensure the marking
- Set the pressure as per marking inspection
- Fill the first five piece report and then start production.
- Keep the OK job properly in to bin
- Damaged tube used after ball passing
- Timer Knob Play condition to be checked at start of shift and at time of setup 3

SL. NO	PARAMETER/	SPECIAL	SPECIFICATION	MEASUREMENT	CHECKING	CONTROL	REACTION PLAN	RESP.
1	OD	NA	Technical data sheet/ Master Tag	DVC	starting of shift 5nos / 1pic per 2hr	-	If found not OK reject the part , reset the setting	OPERATOR
2	ID	NA	Technical data sheet/ Master Tag	DVC	starting of shift 5nos / 1pic per 2hr			OPERATOR
3	Total length	NA	Technical data sheet/ Master Tag	DHG	starting of shift 5nos / 1pic per 2hr			OPERATOR
4	Marking distance	NA	Master Tag	DVC	starting of shift 5nos / 1pic per 2hr			OPERATOR
5	Marking Detail	NA	Master Tag	Visual	starting of shift 5nos / 1pic per 2hr			OPERATOR
6	Marking Pressure OD	NA	Technical data sheet/ Master Tag	Ring Gauge	starting of shift 5nos / 1pic per 2hr			OPERATOR
7	Appearance	NA	No dent, damage,Scratch on OD No Line Mark on OD	Visual	starting of shift 5nos / 1pic per 2hr			OPERATOR

9. Spring condition to be check on weekly basis.100% Part to be check for invisible marking 4

TABLE NO : 02		PROCESS CHARACTERISTICS						
SL.NO	PROCESS	PARAMETER / CHARACT	SPECIFICATION	MEASUREMENT METHOD	CHECKING FREQUENCY	CONTROL METHOD	RESP.	
1	Marking	Pressure	20 to 35 kg/cm2	Pressure Gauge	at the time of setting & First five piece	Inspection report	Operator/line supervisor	
2	Marking	Marking block flatness	0.1 mm	Plunger dail gauge		Check sheet	Operator/line supervisor	
3	Marking	Marking roller condition	No damage, no wear out	Visual	At the time of preventive maintenance	PM checksheet	Production supervisor	

03: POKA YOKE 2

04: SAFETY PRACTICES

1 USE HAND GLOVES , SAFETY SHOES

TABLE NO : 03		CHEMICAL DETAILS					
SL.NO	TOOL NAME	SPECIFICATION	CHANGE FREQUENCY	Control Method	QA ENGG		QA HEAD
1					Prepared By :		Approved By

REV.NO	Rev. Date	Rev. Detail
4	15.10.2024	Spring condition to be check on weekly basis
3	08.08.2024	Knob play condition checkpoint added
2	11.07.2023	Rollar Condition Added
1	02.11.2022	Action of Invisible Marking is updated in Process Characteristics
0	04.08.2018	New Release