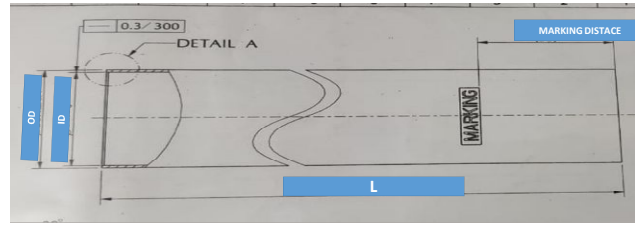


M/C NO:	AE/MK/01,AE/MK/02, AE/MK/03,AE/MK/04	OPERATION NO:	40	CELL NAME	Marking cell	REV. DATE: 08.08.2024
M/C NAME	Marking machine	OPRATION Disc:	Marking			
		PART NAME	Outer Tube			

SETTING PROCEDURE

01: JOB SETTING :

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



02: OPERATING PROCEDURE

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

SL. NO	PARAMETER/	SPECIAL	SPECIFICATION	MEASUREMEN	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

03: POKA YOKE

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

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

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
REV.NO	Rev. Date	Rev. Detail