
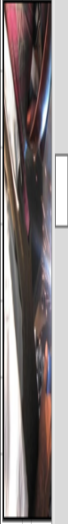


60	MIG WELDING	1	Appearance	No scaling	QC Sup	1	Machine	Mig welding m/c	QC Sup./ Prod sup	Mention on machine (Visual)	Every Shift	Prod. register	
				No breakage in welding	QC Sup	2	Wire feed	20-35mm/sec	Operator	Scale on M/c	1 time /shift	Daily machine check sheet	
				No over weld	QC Sup	3	Current	100-130 Amp	Operator	Ampere meter	1 time /shift	Daily machine check sheet	
				No spatter	QC Sup	4	Voltage	20-40 Volt	Operator	Volt meter	1 time /shift	Daily machine check sheet	
				No welding unfilling	QC Sup	5	Gas	Co ²	Operator	Marking on cylinder	1 time /shift	Daily machine check sheet	
						6	Gas pressure	10-30 lbs/in ²	Operator	Flow meter	1 time /shift	Daily machine check sheet	
						7							

BEFORE- NOZZEL CLEANING FREQUENCY WAS NOT DEFINE

							No damage			QC Sup	<input type="radio"/>	Tool regrinding/resharpening/polishing	50,000 to 52,000 stroke	QC Sup./ Prod sup /Tool sup	As per production record	Every Shift	History card	
60	MIG WELDING	1	Appearance	No scaling	QC Sup		Machine	Mig welding m/c	QC Sup./ Prod sup	Mention on machine (Visual)	Every Shift	Prod. register						
				No breakage in welding	QC Sup	<input type="radio"/>	Wire feed	20-35mm/sec	Operator	Scale on M/c	1 time /shift	Daily machine check sheet						
				No over weld	QC Sup	<input type="radio"/>	Current	100-130 Amp	Operator	Ampere meter	1 time /shift	Daily machine check sheet						
				No spatter	QC Sup	<input type="radio"/>	Voltage	20-40 Volt	Operator	Volt meter	1 time /shift	Daily machine check sheet						
				No welding unfilling	QC Sup		Gas	Co ²	Operator	Marking on cylinder	1 time /shift	Daily machine check sheet						
						<input type="radio"/>	Gas pressure	10-30 lbs/in ²	Operator	Flow meter	1 time /shift	Daily machine check sheet						
							Nozzle cleaning	When block	Operator	Smooth running	1 time /shift	.						

AFTER-NOZZEL CLEANING FREQUENCY DEFINED

PART NAME :- ADJ KOPGAREA:- ASSEMBLY
PROBLEM:-PIN HOLE

MY CHECK POINT
FOR INPROCESS

APPROVED BY:-

VARIFIED BY:-

MADE
BY:-

Mr. Subodh
Upadhyay

Mr. Nimit
Prakash

Mr. Nimit Prakash

CHECK POINT

FOR INSPECTION :-

1-पार्ट में कहीं पर भी पिन होल नहीं होना चाहिए

नोट रू

खराब पीस मिलने पर उसे रेड बिन में रखे -
किसी भी अनियमित परिस्थिति में तुरंत
सुपरवाइजर को सूचित करे

PHOTOGRAPH EXAMPLE



NG



OK

S.NO	TRAINING NEED	NAME /DEPT	PLANNED MONTH	TO BE PROVIDED BY	DATE OF TRAINING	EFFECTIVENESS VERIFICATION & FOLLOW UP
	<p>Problem- Pin Hole in Aqly. KOPs</p> <p><u>IN PROCESS:</u></p> <p>Welding करके समझ एक से Nozzle को clearly साफ करे।</p> <p><u>FINAL INSPECTION</u></p> <p>UP में चेकी करे की Pin hole की ही चलिए।</p>	<p>Brahmad - Shamif - Sachin - Sulekha - Gudija - Aarti - Ashu - Aakash -</p> <p>Asharjod Ram Sagar Vipin Sanjay</p> <p>} Final Inspector } welder</p>	-	Overseer	3/6/2022	