
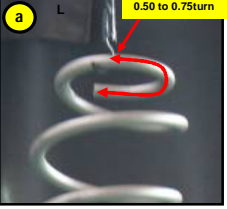
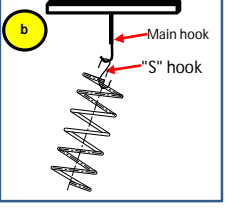






SSSS HALOL		STANDARD WORK INSTRUCTIONS (Loading to powder coating hook)					Process / Dept	PRE - TREATMENT
							Rev no / Date	00 / 02.11.18
							Doc no/Page	MF-WI-008/1 of 1
Seq no	Frequency	Activity (What to do)	How to do	Sketch	Key points	Why to do	Abnormality if not done	Responsibility
1	Cyclic	Pick the spring	Manually pick the spring from exit of Demagnetizing M/c		<ul style="list-style-type: none"> ◆ Spring to be picked only from De magnetizing M/c ◆ Hold the spring at middle coils 	<ul style="list-style-type: none"> To ensure spring is demagnetized For easy handling 	Chance for slippage	Operator
2	Cyclic	Load the first spring to hook (Follow - Annexure- Loading pattern)	a) Load 1 spring to M/c hook as shown	 	<ul style="list-style-type: none"> ◆ Load only at first coil of spring to hook ◆ Load between 0.5 - 0.75 turns ◆ For springs with wire dia of 14.0mm and above do not directly load to hook, use "S" hook for loading as shown in Photo (b) 	<ul style="list-style-type: none"> To avoid NG part To avoid spring falling down To reduce powder burr at hook hanging portion 	<ul style="list-style-type: none"> 1. Spring may slip and fall from conveyer 2. Productivity loss Powder burr projection at hook hanging portion will be more than 1mm (Rejection) 	Operator
3	Cyclic	Load second spring to hook (Follow - Annexure Loading pattern)	a) Use 'S' hook for loading b) Fix one end of 'S' hook to first spring c) Load second spring to other end of 'S' hook		<ul style="list-style-type: none"> ◆ Fix between 0.5 - 0.75 turns of bottom end ◆ Load between 0.5 - 0.75 turns of first coil 	<ul style="list-style-type: none"> To avoid spring falling down To avoid spring falling down 	<ul style="list-style-type: none"> 1. Spring may slip and fall from conveyer 2. Productivity loss 	Operator
* In case of Abnormality / Defect - Operator to Report Supervisor Immediately & Wait for Instruction								
Note : In case of lunch time/ any break / shift change /operator called by supervisor - points to be considered 1. Operator has to inform supervisor in case of moving away from work place 2. Do not leave the running part with out completing the process 3. Do not leave the parts with out identification 4. Hand over the process to alternative operator if available or stop the process 5. In case of any emergency situatuion (accidents) alternative operator / supervisor to handle the situation								
SI no	KEY ASPECTS	KEY IMPACTS	SAFETY GADGETS	RECORDS	CHANGE HISTORY			
1	Smoke & ash generation at Hook Burning	Air & Land contamination	1. Safety shoes	NIL	Rev No.	Rev Date	Change Description	
					00	02.11.2018	Initial release	
					<div style="border: 1px solid red; padding: 5px; display: inline-block;"> NOTE :- DO NOT USE COTTON GLOVES FOR HANDLING SPRINGS </div>			
 - Safety  - Quality  - Critical					Prepared by : Paresh Chauhan	Checked by: Chetak	Approved by: Chandrasekhar	