



**POWDER COATING/પાવડર કોટિંગ**






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Rev. No.	01
Rev. Date	03-10-2022 (Spring & Conveyor Hook Cleaning added)

STUMPP SCHULE & SOMAPPA SPRINGS PVT.LTD  
HALOL PLANT

MAINTENANCE DAILY CHECKSHEET

MONTH:-		SHIFT:-		OPERATOR:-																																	
SR NO.	WORK LOCATION	CHECK POINT	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31				
1	HANGER MAINTENANCE/ હોંગર મેઇન્ટેનન્સ	CHECK EARTHING AND CONTINUITY ON MATERIAL AND HANGER/ હોંગર અને મટેરીઅલ પર નું અર્થિનગ એન્ડ કોંટીનુઇટી ચેક કરવું																																			
2	Spring Hook Cleaning / કન્વેયર હૂક ની સફાઈ	Spring Hooks to be cleaned on daily basis / સ્પ્રિંગ હૂક દરરોજ સાફ કરવા																																			
3	Conveyor HOOK Cleaning / કન્વેયર હૂક ની સફાઈ	Conveyor HOOKs to be cleaned every 15 days / દર ૧૫ દિવસે કન્વેયર હૂક સાફ કરવા																																			
4	POWDER COATING/ પાવડર કોટિંગ	SET CONVEYOR CYCLE TIME AS PER TTR/કન્વેયોર સાઇકલ ટાઇમ TTR પ્રમાણે સેટ કરવો																																			
5		CHECK OVEN TEMP.200 C TO 220°C/ઓવન નું તાપમાન 200 થી 220 ડીગ્રી જોઈએ																																			
6		CHECK CAMPONENT LOADING AND OVERLAP/ કોમ્પોનન્ટ લોડ કરતી વખતે બે કોમ્પોનન્ટ ઓવરલેપ નથી થતા તે ચેક કરવું																																			
7		CHECK PHOSPHATE POINTAGE/ ફોસ્ફેટ થયેલ મટેરીયલ પીળા રંગ નું થયું છે કે નહીં તે ચેક કરવું																																			
8		CLEAN BY AIR ALL COMPONENT / એર થી મટેરીઅલ ને સાફ કરવું																																			
9		FRESH POWDER AND RE USED POWDER TAKE AS PER 80 TO 20/ ફ્રેશ પાવડર અને પહેલા વાપરેલ પાવડર 80 થી 20 ના પ્રમાણ માં લેવું																																			
10		CHECK POWDER COATING GUN DEFLECTOR/ પાવડર કોટિંગ ગન નું ડિફ્લેક્ટર ચેક કરવું																																			
11	POWER PACK SETTING/ પાવર પેક સેટિંગ	AIR PRE. 05 TO 1 bar/ એર પ્રેસર 0.5 થી 1 bar																																			
12		POWDER OUT PUT 0.5 TO 1.5 bar/ પાવડર આઉટ 0.5 થી 1.5 bar																																			
13		FLUIDIZED AIR PRES. 0.3~0.5 bar/ફ્લુઇડાઇઝ્ડ એર પ્રેસર 0.3~0.5 bar																																			
14		GUN VOLTAGE IN REWORK 50 TO 70 KV/રી વર્ક માટે ગન વોલ્ટેજ 50 થી 70 KV																																			
SING		SHIFT SUPERVISOR																																			

NOTE:- 1.USE V KEY WHERE THE CHECK POINT FOUND AS PER REQUIREMENT 2.USE X KEY WHERE THE DEVIATION IS OBSERVED 3.ADD VALUE WHERE EVER NECESSARY 4.WHERE EVER DEVIATION IT SHOULD BE COMMUNICATED TO QA

Seq no	Frequency	Activity ( What to do )	How to do	Sketch	Key points	Why to do	Abnormality if not done	Responsibility
1	Every shift	Prepare paint for touch up	Use black / silver / red color paint (as required ) Mix paint with thinner in a cup and use		◆ Mix paint with thinner in 10:2 ratio approx	For proper paint flow	paint lumps will be formed at hook portion	Operator
2	Cyclic	Unloading bottom spring	a) Hold the bottom spring in one hand and hold the 'S' hook in other hand b) Lift the spring to remove from hook		◆ Hold the spring at middle coils ◆ Lift only 1 spring at a time	For easy handling To avoid dropage  For easy handling	Chance for spring slip & lead to coating damage	Operator
3	Cyclic	Unloading top spring	a) Hold the top spring in one hand and hold the 'S' hook in other hand b) Lift the spring & 'S' hook at a time to remove. c) Place the 'S' hook on the tray		◆ Hold the spring at middle coils	For easy handling To avoid dropage	Chance for spring slip & lead to coating damage	Operator
4	Cyclic	Hook touchup	a) Hold the unloaded spring in one hand b) Hold paint brush in other hand c) Do paint touchup at hook portions as shown d) <b>Clean the paint slug if accumulated at hook touching portion.</b>	 	◆ Hold the spring at middle coils ◆ Use brush of 10mm size ◆ Tilt the spring as required for painting ◆ Do not over paint	For easy handling To avoid dropage  To avoid paint on other portion  To avoid paint lumps / projections	Chance for spring slip & lead to coating damage Excess size will spread paint on other portion  <b>Paint lumps will be formed at hook portion</b>	Operator
5	Cyclic	Place the spring for next process	a) Place the painted spring in the bin manually b) Provide identification tag for each bin	 <div style="border: 2px solid red; border-radius: 15px; padding: 5px; display: inline-block; color: red; font-weight: bold;">Provide identification tag for each bin</div>	◆ Ensure springs are placed Neatly & do not load zig zag ◆ Do not over load the spring in the bin	To avoid entangle of spring to spring  Spring may fall down if loaded more	Difficult to remove spring at next process Coating damages & chance for accident	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

Sl no	KEY ASPECTS	KEY IMPACTS	SAFETY GADGETS	RECORDS	CHANGE HISTORY		
1	Paint spillage	Land contamination	1. Safety shoes	Daily production rejection record	Rev No.	Rev Date	Change Description
2	Empty paint tins disposal	Land contamination			00	03-10-2022	Initial release
3	Thinner Spillage	Land contamination					
4	Paint brush	Land contamination					

+ - Safety    
 ◆ - Quality    
 △ - Critical