

SAGAR SPRINGS PVT. LTD.	<u>WORK INSTRUCTION</u> Work Instructions for Hanger changing and cleaning	Doc. No. : QWI/Powder Coating/05
		Rev. No. : 02
		Date : 20.05.2024
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1.0 Purpose

To define hanger changing and its cleaning.

2.0 Scope

All the hangers to be change and cleaning.

3.0 Responsibility

Manager Powder Coating Plant	For development of work instructions.
Powder coating plant supervisor	For implementation of work instructions.
Managing Director	For approval of the work instructions.

4.0 Instructions

Following are the reference instruction to be followed while hanger changing and its cleaning.

1. Remove hangers from the conveyer after every week / 6 working days required for and keep it at hanger repairing area burning and cleaning.
2. If hanger observed with 8 or more than 8 nos of hole block during running condition then remove it and replace with clean one.
3. Remove silicon caps from the hangers and send hangers for burning. Put broken and unbroken silicon rubber caps separately
4. Clean powder ash from the burnt hangers with the help of wet cloth and clean locks properly with wire brush.
5. At the time of hanger cleaning, ensure that resting portion of hanger and hanger resting pin of bracket should cleaned properly.
6. Replace broken silicon rubber cap and remove broken pieces which are found in cleaning.
7. Clean block hole of hanger with the help of hand drill and by using 1.80 mm drill.
8. Check hanger in bend checking fixture before loading it on conveyer. If bend is observed correct it scrap it in worst condition.
9. While checking hanger if hanger finger observed bend correct it by checking on gauge.
10. At the time of hangers changing, ensure all hangers are locked with resting pin properly. Clean all the hangers by DM water rinsing after hanging on conveyer line.

Following are the instructions to be followed for hooks usage.

1. Hooks for spring hanging should be handle carefully and its frequency of burning and cleaning to be monitored.

Prepared By: Department Head	Reviewed By: MR	Approved By: Managing Director	Document Control Status:
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2. After use of fresh hooks it is to be re used for 3 times; total max 4 times (after burning and cleaning) then hooks should be scrapped.
3. Cleaning method for hooks: - Used hooks will be covered with powder film, hence powder should be burnt to remove. In order to clean hook; burned hooks are shot peened for maximum 2 minutes. After completing this cycle hooks are ready for next use.
4. While using re-cycled hooks during each use loading person should confirm ie. hooks are in proper shape and should be able to carry spring properly. If in some case hooks found not in good condition it should be scrapped.
5. For monitoring hooks burning cycle OPL should followed. Bins for hook storing should be properly identified and kept according to its sequence of use as shown in OPL.

5.0 Documents for reference

1. Quality Procedure – QP/Powder Coating /01.

6.0 Documents generated

None

7.0 Document location, distribution, storage and disposal

	Document	Location	Distribution	Period of Retention	Method of Disposal
1	Instruction for Hanger changing and cleaning. (QWI/Powder Coating/05)	Original (in English) with MR. 1 controlled copy (in English) with front office 1 controlled copy (in English) with Powder Coating Department. 1 displayed on the Inspection line.		As long as work instructions are current and required.	Burning / shredding when not required.

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