

SET-UP APPROVAL REPORT

PART NO :	W/O No.		
M/C NO :	OPER. :		M/S BELLITE SPRINGS PVT LTD L11/2/2, WALUJ MIDC AURANGABAD
DATE :	SHIFT :		

SR NO	A. PROCESS PARAMETERS	SPEC.	CHECKING METHOD	RESPONSIBILITY	OBSERVATION	Remarks
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1. COILING STAGE

1	PART PER MINUTE (PPM)		DISPLAY / COUNTER	OPERATOR		
2	FRONT WIRE GUIDE GROOVE SIZE		WIRE GAUGE	OPERATOR		
3	FORK GROOVE SIZE		WIRE GAUGE	OPERATOR		
4	ROLLER GROOVE SIZE		WIRE GAUGE	OPERATOR		
5	CUTTER BOLT ASSEMBLY	SHOULD BE TIGHT	ALLEN KEY	OPERATOR		
6	VISUAL APPEARANCE		VISUAL	OPERATOR		

2. STRESS RELIEVING STAGE

1	1ST ZONE TEMP	330±10°	DIGREE COUNTER / THRMOCOUPLE	OPERATOR		
2	2ND ZONE TEMP	330±10°	DIGREE COUNTER / THRMOCOUPLE	OPERATOR		
3	3RD ZONE TEMP	330±10°	DIGREE COUNTER / THRMOCOUPLE	OPERATOR		
4	TIME	15±5 Minute	TIMER	OPERATOR		
5	POKA-YOKE	Power spect= Orange, Between spect = Green, Above spect = Red	VISUAL	OPERATOR		

4. SCRAGGING STAGE

1	SCRAGGING HEIGHT		DISPLAY BORD	OPERATOR		
2	SCRAGGING PPM		STROKE COUNTER	OPERATOR		
4	FIXTURE ID (PIPE ID)		VERNIER	OPERATOR		
5	SCRAGGING PIN OD		VERNIER	OPERATOR		
6	VISUAL APPEARANCE		VISUAL	OPERATOR		

5. SHOT PEENIG

1	SHOT SIZE	1.60 mm	VERNIER	OPERATOR		
2	CYCLE TIME		TIMER	OPERATOR		

Remarks : Accept/Reject	Operator Sign:
Reason	Inspector Sign:

F/03/F-PDN-16/Rev01

