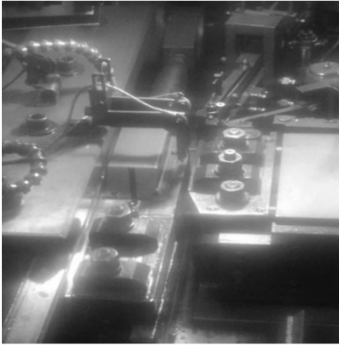
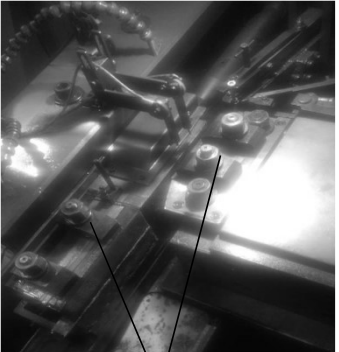



- 1 PURPOSE:** To Carry out Die set-up of Rolling Process as per Production plan to produce a Conforming Product
- 2 SCOPE:** Applicable to All Type of Hex Headed, Socket Headed, Flange Headed Bolts & other Bolts
- 3 RESPONSIBILITY:-** Rolling Operator, Head Production
- 4 REFERENCE MACHINE:** Thread Rolling Machines
- 5 DEFINATIONS AND ABBREVIATIONS:-** Nil
- 6 ENVIRONMENTAL CONDITION:** Not applicable
- 7 CHECK POINTS:** Size & Pitch of Die, Alignment Match, Ring Gauge Qualify, Die Locking Bolts Tighten
- 8 REFERENCE STANDARD:** NIL
- 9 PROCEDURE:**

S.No.	ACTIVITY	
a	Ask for the daily Machine Loading Plan for Rolling Process from Production Head	 <div style="border: 1px solid black; padding: 2px; display: inline-block;">ROLLING MACHINE</div>  <div style="border: 1px solid black; padding: 2px; display: inline-block;">LOCKING BOLTS</div>  <div style="border: 1px solid black; padding: 2px; display: inline-block;">THREAD ROLL PARTS</div>
b	Take out the Required Rolling Die Set from Store as per Product Specification.	
c	Clamp the Dies in their Die- Pockets and start product set up	
d	After Die Matching Set all other Parameters Such as Thread Dia, Pitch Dia, Required Thread Ring Gauge	
e	Now Set the Line for Piece entrance Between Die for rolling by setting the Head Pusher & Line Gap	
f	After Performing the set up, take out 1st five pieces for first off Inspection from Quality Inspector.	
g	Clear the Machine Tray before Starting the regular production. There must not be any setting part/without thread part left in tray	
h	Operator must ensure that all Locking Bolts are Tightened Enough to prevent die Loosen up	
i	Now Start the Machine for Regular Production After Clearance from Quality Deptt.	
j	Quality Inspector will check the machine tray for any setting part left in the tray. IF the machine tray is Empty then operator can start the production	
k	If There is any Problem while the machine is running then First Stop the Machine & Inform Head Production	
l	When Rolling Production for a particular Part is over then Clear all The pieces from the machine and Proceed for Next Lot	