
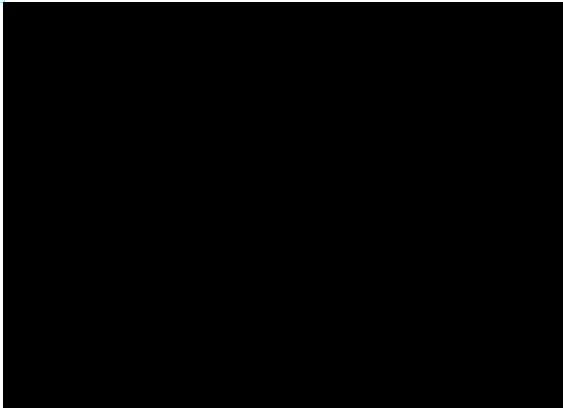
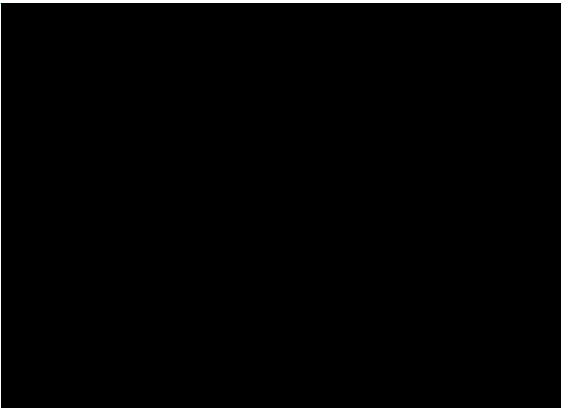
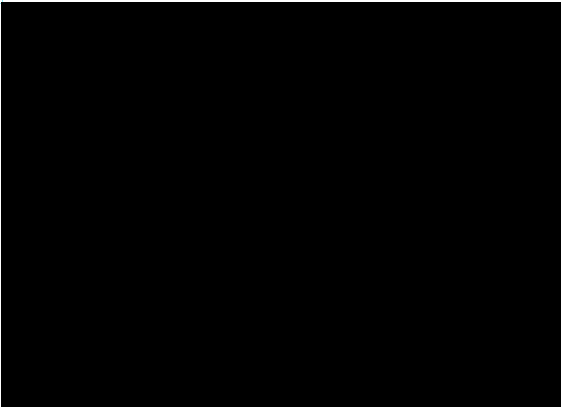


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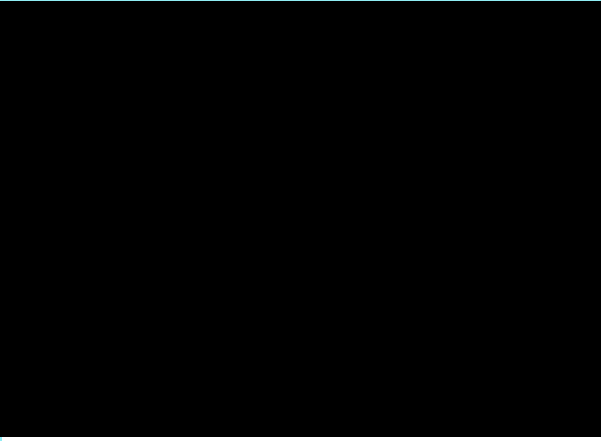
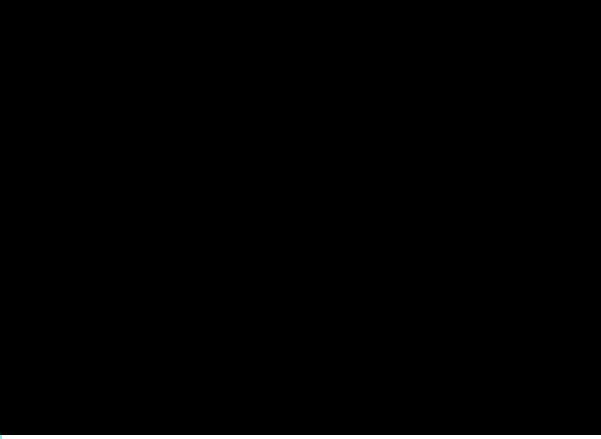
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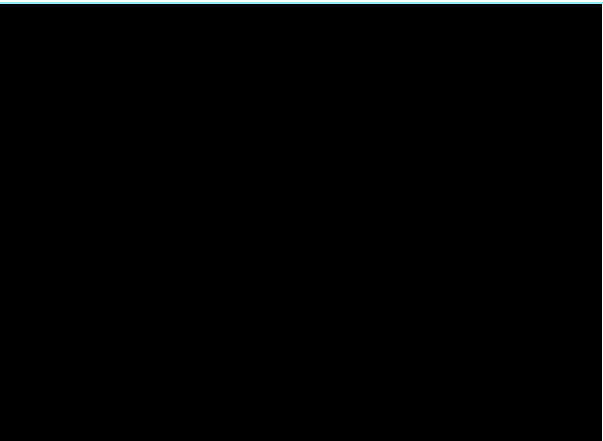
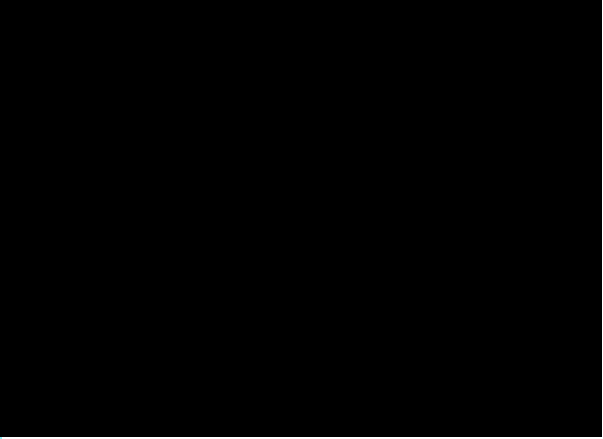
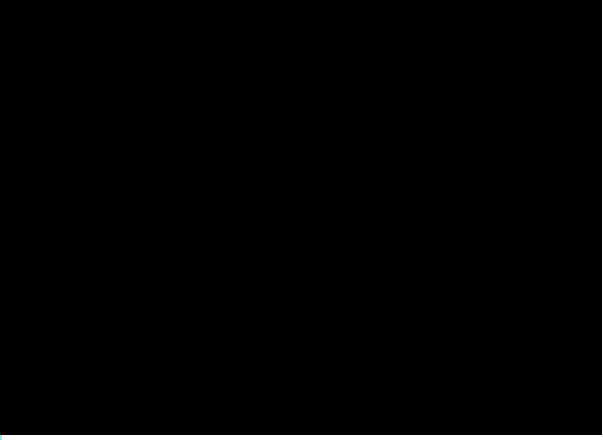
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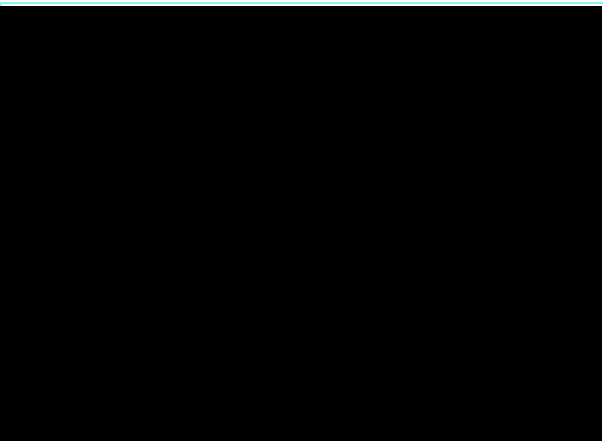
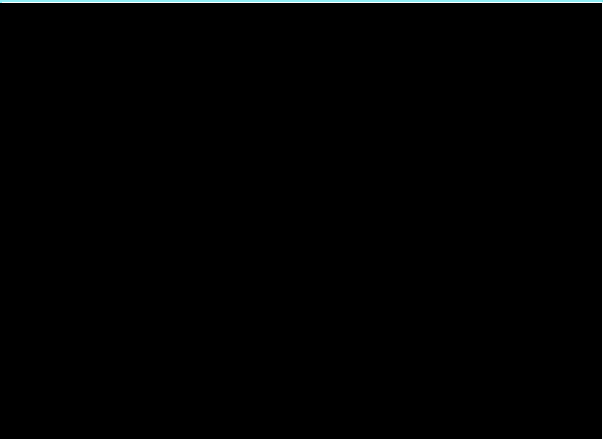

Sr. No	Check Point	Capture	Score	Remark
1	Is the RM stored in racks as per the standard practice-Same grade & same section		1	aOkay
2	Is the material with the tag placed at rack		0	bOkay
3	Is the FIFO board updated & followed, Check board for rack number, heat number/Heat code & check physically in Rack		1	cOkay




4	Is the material have color coding as per Color code chart		0	dOkay
5	Is the hold RM/Suspected/ Rejected RM placed in designated rack		2	eOkay
RM Storage Score			4	

Layer Audit Report

Sr. No	Check Point	Capture	Score	Remark
1	Is Stock size specification displayed on board ?		0	aOkay
2	Check if set up aapproval, hourly inspection monitored?		1	bOkay
3	Verify one cut billet sample as per specification?		0	cOkay


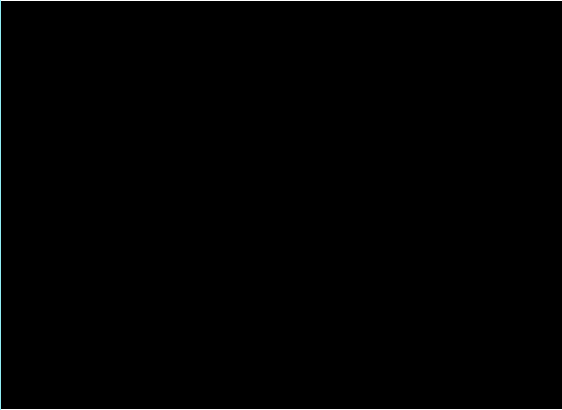
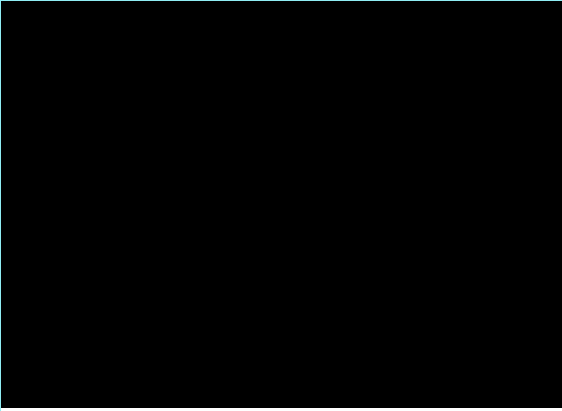
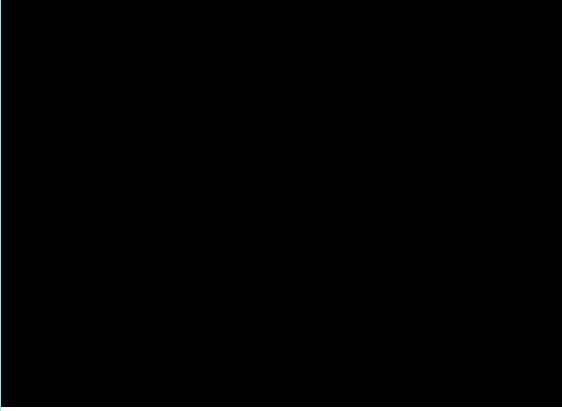
4	Verify JH check sheet for cutting machine & process filled up to till date		2	dOkay
5	Is the POKA YOKE working on cutting machine?		2	eOkay
6	Check weather two different grade & Same section materials are not cut on nearby machines?		2	fOkay

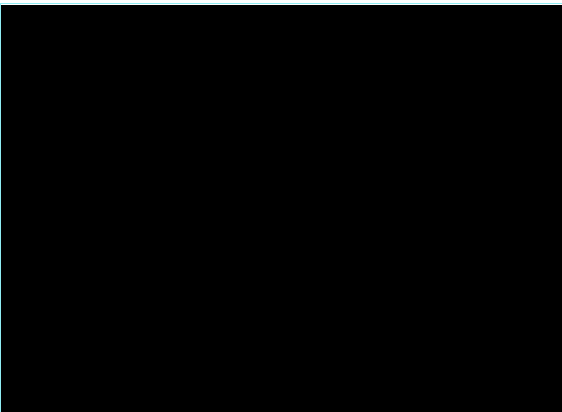
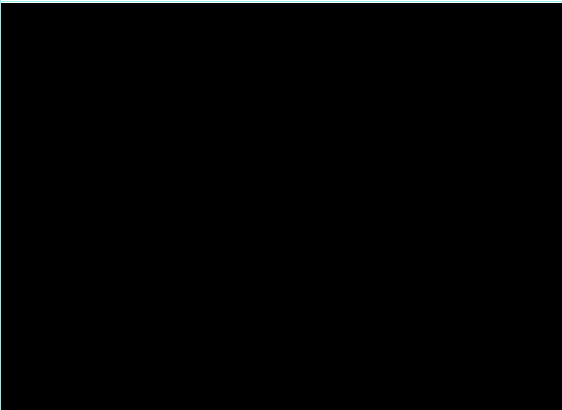
7	Are the Abnormalities of cutting machines are identified?		2	gOkay
8	Are actions taken on abnormality?		1	hOkay
9	Check weekly 5S register filled & check effectiveness		2	iOkay

10	Check skill matrix on work station		1	jOkay
11	Check if operator is following DWM		0	kOkay
12	Check operator awareness about product & process		2	lOkay
RM Cutting Score			15	

Layer Audit Report

Sr. No	Check Point	Capture	Score	Remark
1	Is the POKA YOKE of High/ Low Billet discard for temperature working on IBH machine?		2	aOkay
2	Is the POKA YOKE verification sheet updated for same?		1	bOkay
3	Is the UDS available on machine?		2	cOkay


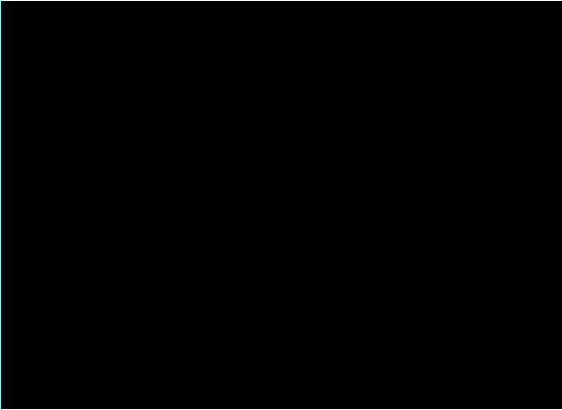
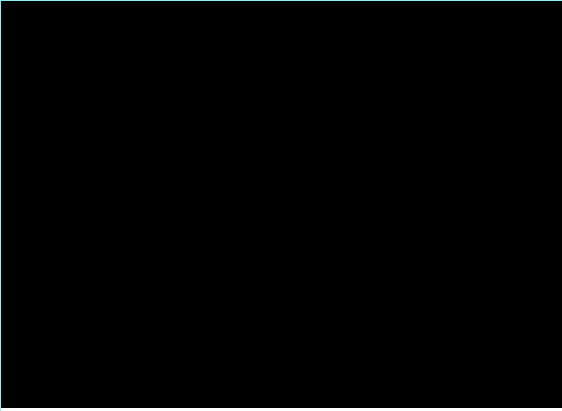
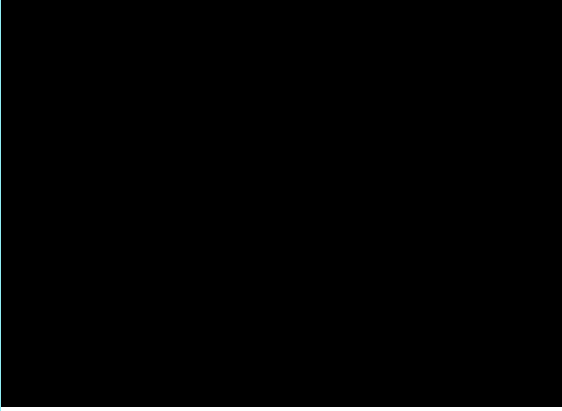
4	Are the Current & Speed pot as per UDS?		2	dOkay
5	Are the Current & Speed pot setting have lock & Key facility?		0	eOkay
6	verify list of authorized persons to do changes or modification in IBH Control panel.		2	fOkay
7	What is the temperature range set for the running part? Cross check it with UDS?		2	gOkay



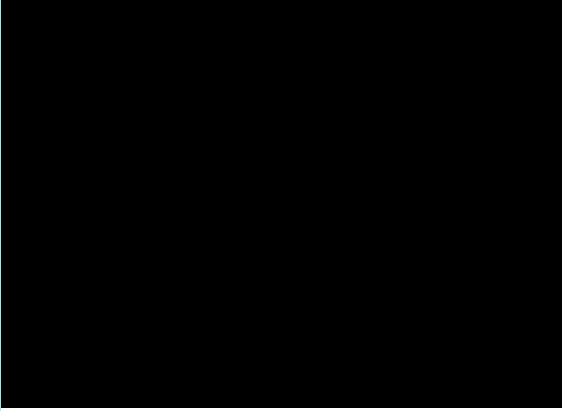
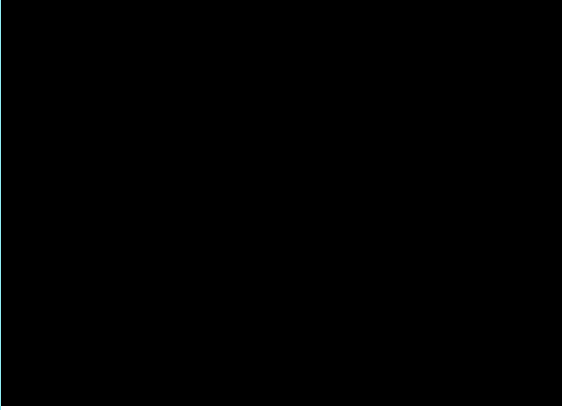
8	Verify the temperature of billet with handheld pyrometer. (Collect it from Hot Inspector)		2	hOkay
9	Check weekly 5S register filled & check effectiveness		2	iOkay
10	Is the IBH coil size as per UDS?			
IBH Heating Score			15	






Layer Audit Report

Sr. No	Check Point	Capture	Score	Remark
1	Production sequence set as per UDS?		0	aOkay
2	Verify the Parameters as per UDS -Cycle time, Lubrication ratio, Lubrication time etc.		2	bOkay
3	Is the Die release note available?		2	cOkay

4	Is there possibility of Part Stuck up in the flow from Press to End Pallet?		2	dOkay
5	Are the Drop out Billets are kept in separate area with Tagging?		1	eOkay
6	Are the Tags available on material/ pallets (From Forging to Storage (Prior to HT)?)		2	fOkay
7	Is the 4 M Change board updated?		2	gOkay

8	<p>Is the 4M change record fill up?</p> <p>How:-Observe if any change during audit & check record</p>		2	hOkay
9	<p>Is the operators skill matrix available?</p> <p>How:- Check operator name and check in skill matrix</p>		1	iOkay
10	<p>Are the TPM meeting circle adhere</p>		1	jOkay
11	<p>Is the PQCD SM board updated?</p> <p>To be updated 10th of every month</p>		2	kOkay

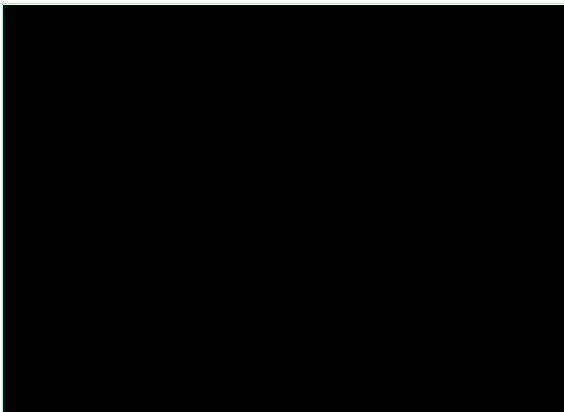
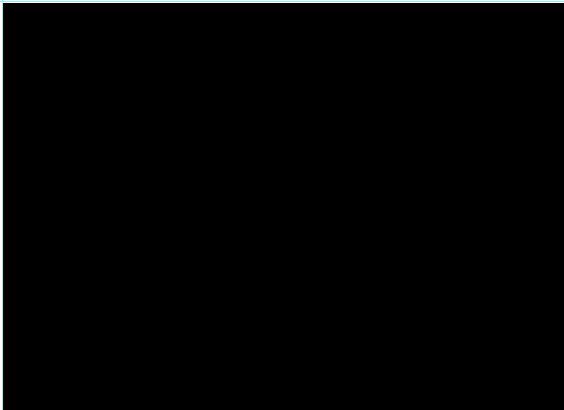


12	Are the JH , PM Check sheets updated?		2	IOkay
13	Check weekly 5S register filled & check effectiveness		2	mOkay
14	Are the Unsafe condition on lines? All persons wearing the PPE's?		1	nOkay
15	Are the countermeasures taken for Customer Complaints are implemented? How:- Check if any customer complaint and verify action implementation		2	oOkay

16	Check skill matrix on work station		1	pOkay
17	Check if operator is following DWM		0	qOkay
18	Check operator awareness about product & process		1	rOkay
Production Score			26	

Layer Audit Report

Sr. No	Check Point	Capture	Score	Remark
1	Drawing revision check with report of quality for Running product?		0	aOkay
2	Are all Quality records available & filled. -ie. Preform/1st off/CCPR/MPI		2	bOkay
3	Details of Last Customer complaint & it's action status?		0	cOkay

4	<p>Is the 4M Change addressed & countermeasure action done by Inspector?</p> <p>If 4M change -Check retroactive, set up and containment report</p>		2	dOkay
5	<p>Is the Process audit done?</p>		2	eOkay
6	<p>Is the NC area Defined?</p>		2	fOkay
7	<p>Is NC material identified & it's entery done in Logbook?</p>		2	gOkay

8	Is the NC material cleared in 24 Hr?		1	hOkay
9	All Instruments used are calibrated? How:- Check due date sticker pasted on instruments & Plan.		1	iOkay
10	Check skill matrix on work station		0	jOkay
11	Check if operator is following DWM		1	kOkay

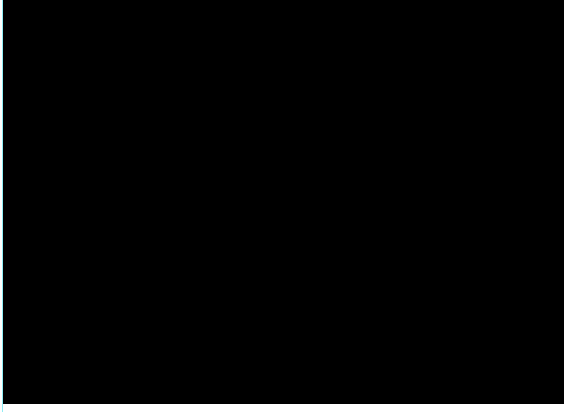
12	Check operator awareness about product & process			
Hot Inspection Score			13	





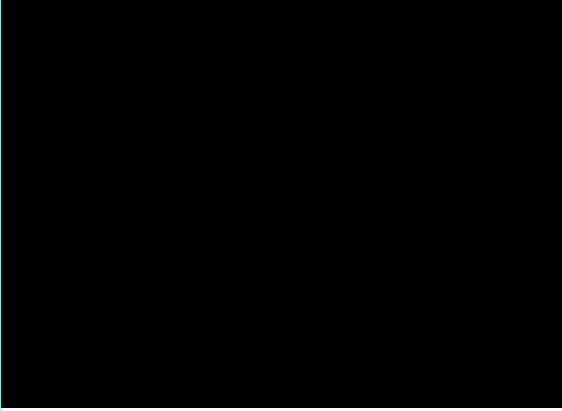
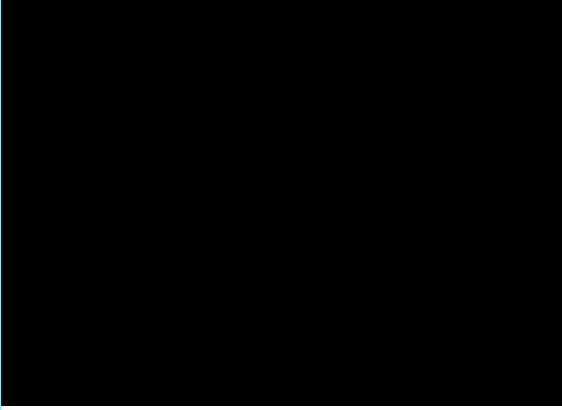
Layer Audit Report

Sr. No	Check Point	Capture	Score	Remark
1	All material is identified & Tagging done?		2	aOkay
2	All Endpiece are verified & record maintained?		0	bOkay
3	All PPE's are used by Operators?		2	cOkay
Spark & Spectra Score			4	

Layer Audit Report

Sr. No	Check Point	Capture	Score	Remark
1	Ensure the Heat treatment is as per Control plan? How:- Check diewise heat treatment standard		0	h
2	Ensure weather all Material is loaded as per Loading Standard?		1	aOkay
3	Check if Logbook maintinaed for Heat Code traceability?		2	bOkay

4	Is the 4M Change board is update for any change?		2	cNotOKay
5	Are the eddy current master seperately identified & kept?		2	dOkay
6	Are the Poka Yokes are in working conditions?		2	e
7	Are the JH / PM Check sheets are fill up?		0	f

8	Are the countermeasures taken for Customer Complaints are implemented? How:- Check if any customer complaint and verify action implementation		1	g
9	Check weekly 5S register filled & check effectiveness		0	i
10	Check skill matrix on work station		1	j
11	Check if operator is following DWM		2	k

12	Check operator awareness about product & process		1	I
Heat Treatment Score			14	