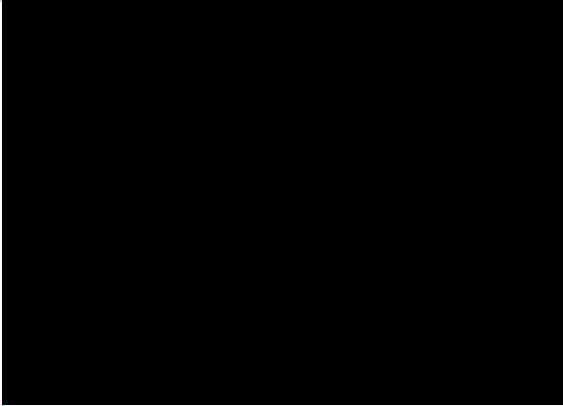
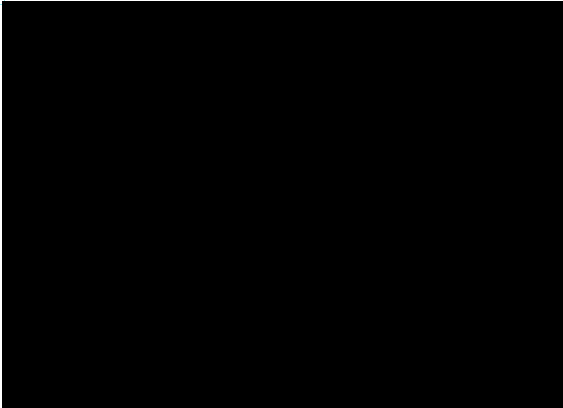
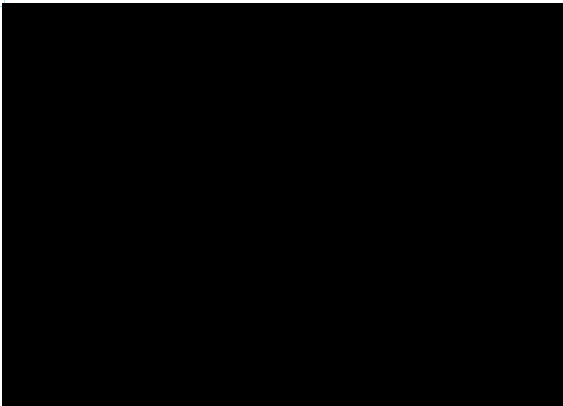


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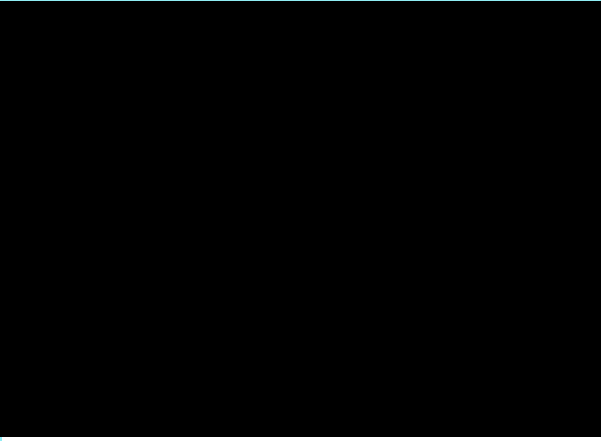
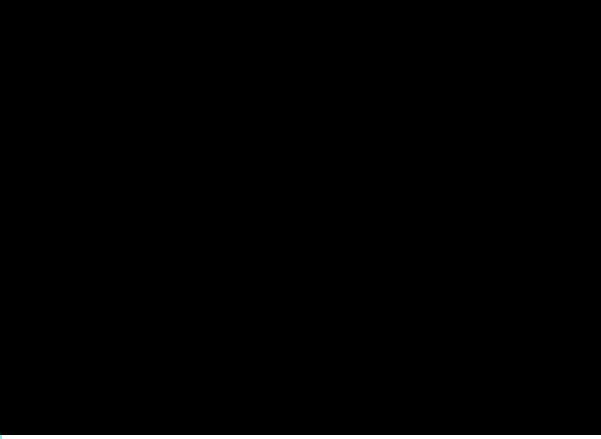
Layer Audit Report

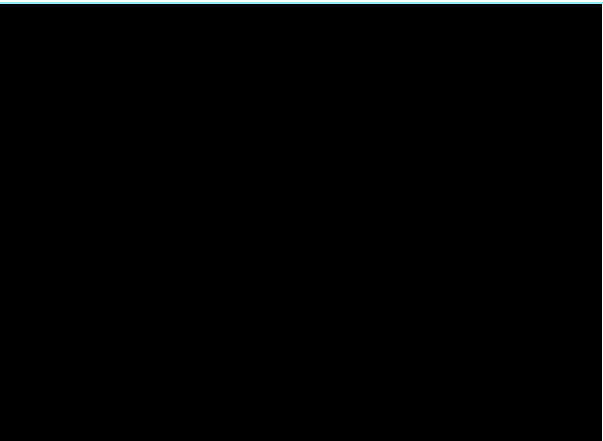
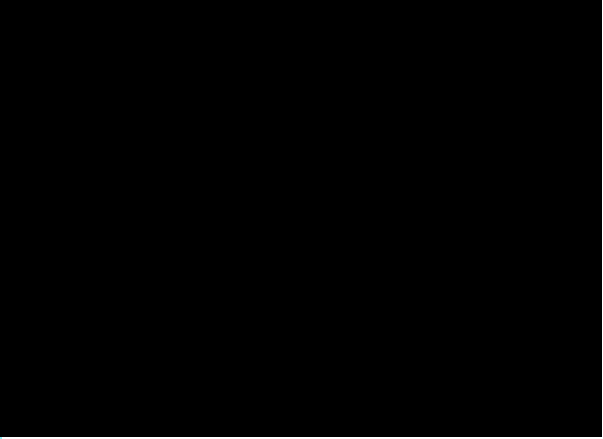
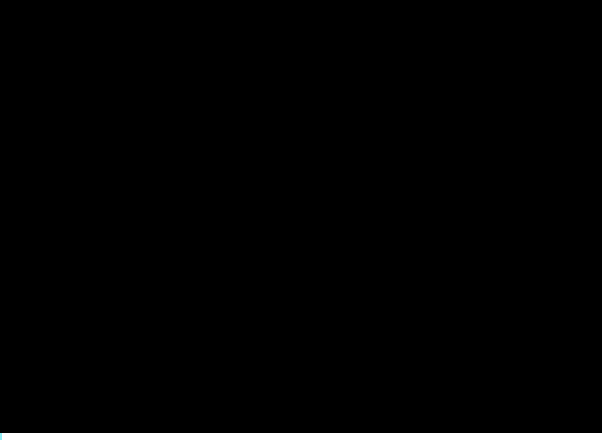
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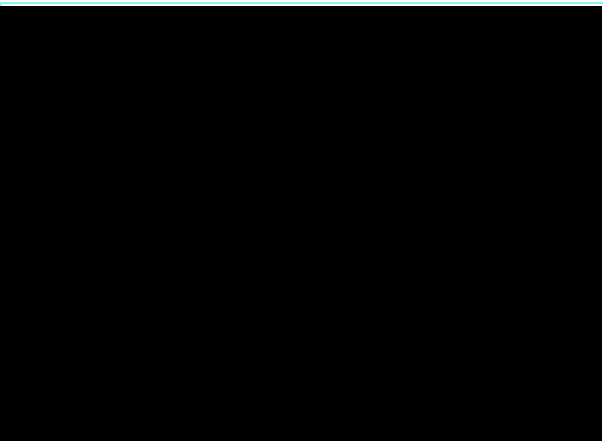
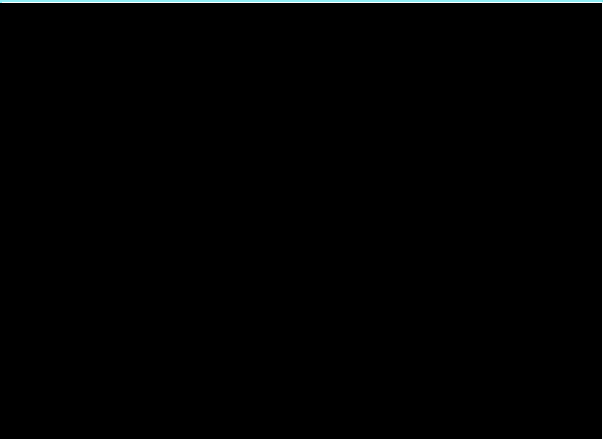

Sr. No	Check Point	Capture	Score	Remark
1	Is the RM stored in racks as per the standard practice-Same grade & same section		2	This a weight staorage
2	Is the material with the tag placed at rack		0	
3	Is the FIFO board updated & followed, Check board for rack number, heat number/Heat code & check physically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

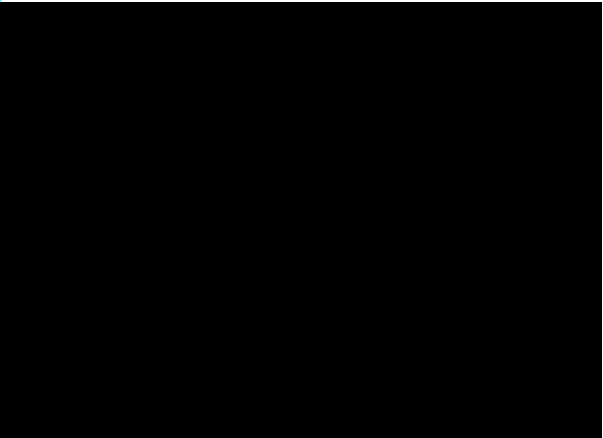

4	Is the material have color coding as per Color code chart		0	
5	Is the hold RM/Suspected/ Rejected RM placed in designated rack		2	
RM Storage Score			5	

Layer Audit Report

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

4	Verify JH check sheet for cutting machine & process filled up to till date		2	
5	Is the POKA YOKE working on cutting machine?		0	
6	Check weather two different grade & Same section materials are not cut on nearby machines?		0	

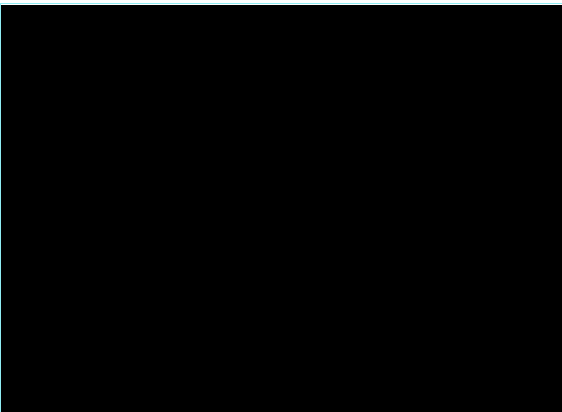
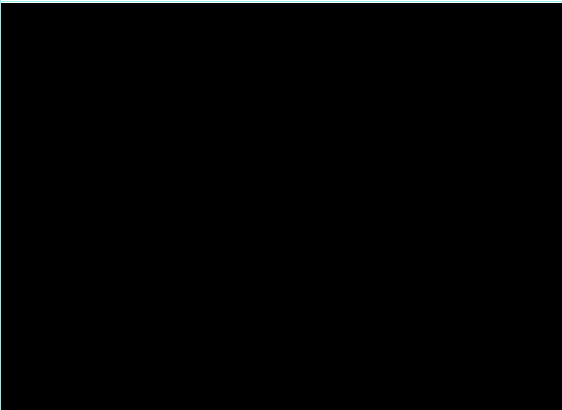
7	Are the Abnormalities of cutting machines are identified?		0	
8	Are actions taken on abnormality?		1	
9	Check weekly 5S register filled & check effectiveness		0	

10	Check skill matrix on work station		0	
11	Check if operator is following DWM		1	
12	Check operator awareness about product & process		2	
RM Cutting Score			7	

Layer Audit Report


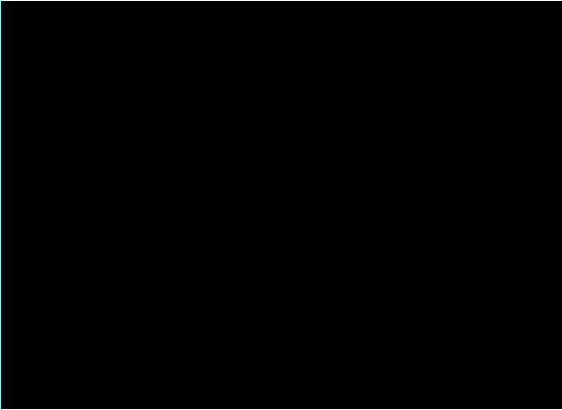
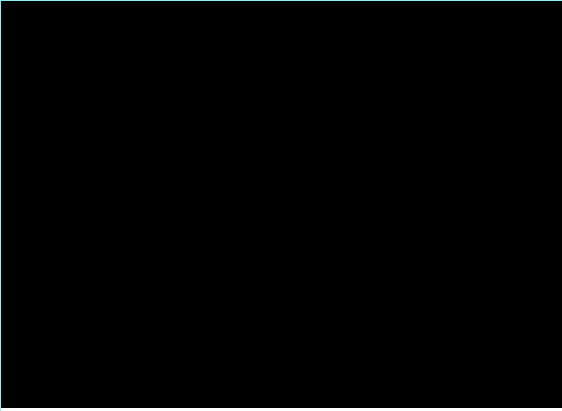
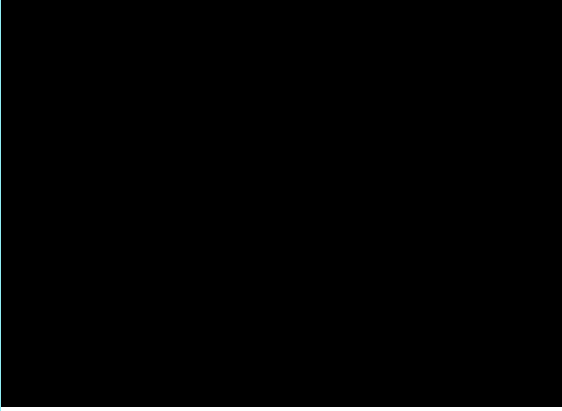
Sr. No	Check Point	Capture	Score	Remark
1	Is the POKA YOKE of High/ Low Billet discard for temperature working on IBH machine?		2	
2	Is the POKA YOKE verification sheet updated for same?		0	
3	Is the UDS available on machine?		0	



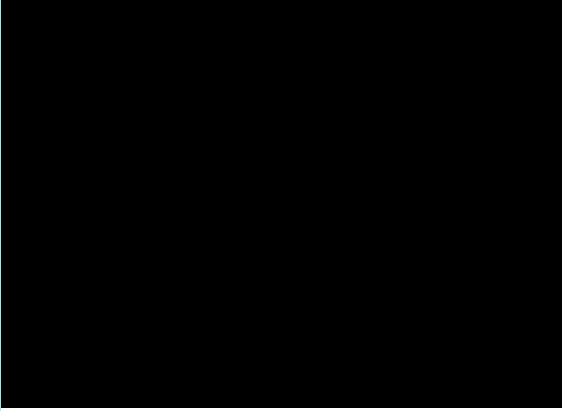
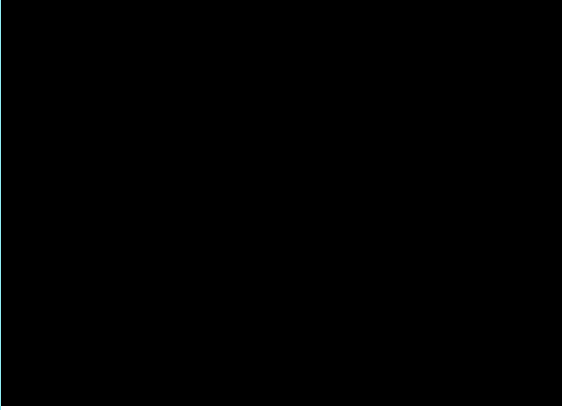
4	Are the Current & Speed pot as per UDS?		0	
5	Are the Current & Speed pot setting have lock & Key facility?		2	
6	verify list of authorized persons to do changes or modification in IBH Control panel.		2	
7	What is the temperature range set for the running part? Cross check it with UDS?		2	




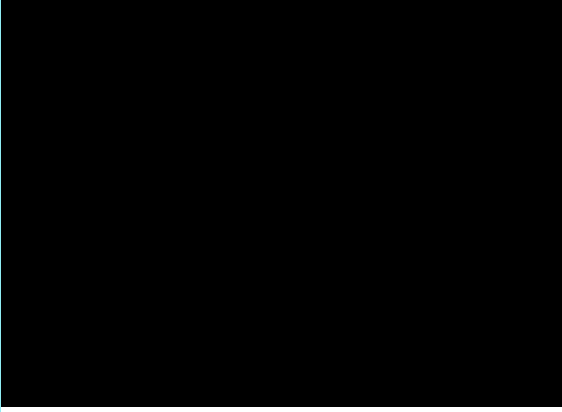
8	Verify the temperature of billet with handheld pyrometer. (Collect it from Hot Inspector)		0	
9	Check weekly 5S register filled & check effectiveness		2	
10	Is the IBH coil size as per UDS?			
IBH Heating Score			10	




Layer Audit Report

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

4	Is there possibility of Part Stuck up in the flow from Press to End Pallet?		0	
5	Are the Drop out Billets are kept in separate area with Tagging?		1	
6	Are the Tags available on material/ pallets (From Forging to Storage (Prior to HT)?)		2	
7	Is the 4 M Change board updated?		0	

8	<p>Is the 4M change record fill up?</p> <p>How:-Observe if any change during audit & check record</p>		0	
9	<p>Is the operators skill matrix available?</p> <p>How:- Check operator name and check in skill matrix</p>		1	
10	<p>Are the TPM meeting circle adhere</p>		2	
11	<p>Is the PQCD SM board updated?</p> <p>To be updated 10th of every month</p>		0	

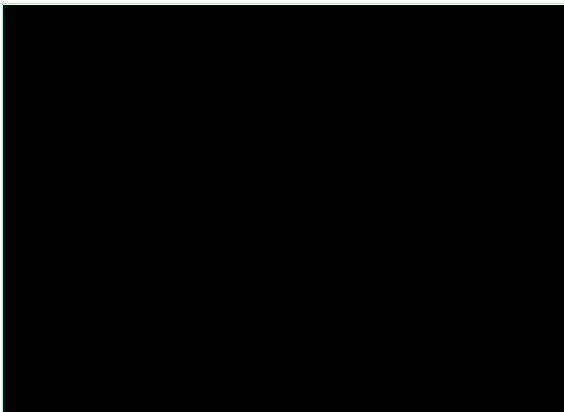
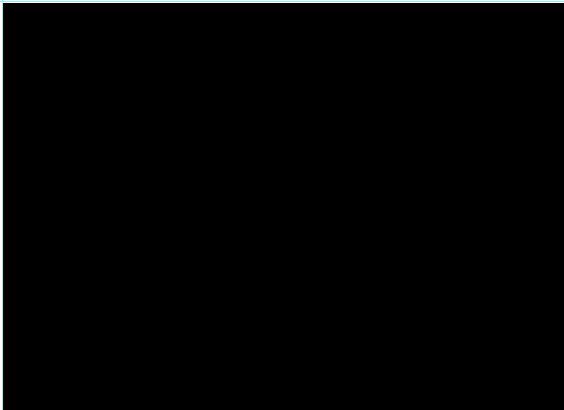


12	Are the JH , PM Check sheets updated?		2	
13	Check weekly 5S register filled & check effectiveness		1	
14	Are the Unsafe condition on lines? All persons wearing the PPE's?		1	
15	Are the countermeasures taken for Customer Complaints are implemented? How:- Check if any customer complaint and verify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

16	Check skill matrix on work station		1	
17	Check if operator is following DWM		2	
18	Check operator awareness about product & process		1	
Production Score			22	

Layer Audit Report

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

4	Is the 4M Change addressed & countermeasure action done by Inspector? If 4M change -Check retroactive, set up and containment report		0	
5	Is the Process audit done?		0	
6	Is the NC area Defined?		0	
7	Is NC material identified & it's entery done in Logbook?		0	

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


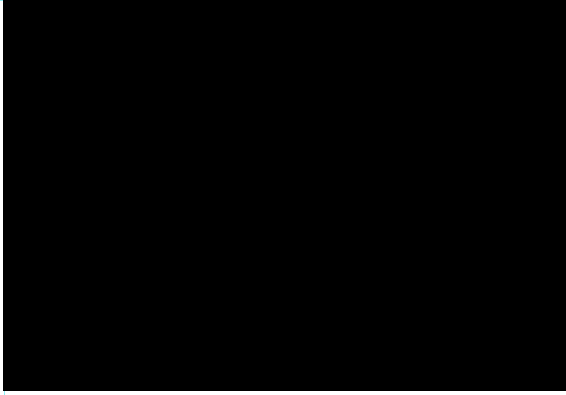
12	Check operator awareness about product & process			
Hot Inspection Score			0	




Layer Audit Report

Sr. No	Check Point	Capture	Score	Remark
1	All material is identified & Tagging done?		0	
2	All Endpiece are verified & record maintained?		2	
3	All PPE's are used by Operators?		2	
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		2	
2	Ensure weather all Material is loaded as per Loading Standard?		0	
3	Check if Logbook maintained for Heat Code traceability?		0	

4	Is the 4M Change board is update for any change?		0	
5	Are the eddy current master seperately identified & kept?		0	
6	Are the Poka Yokes are in working conditions?		1	
7	Are the JH / PM Check sheets are fill up?		0	

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

12	Check operator awareness about product & process		0	
Heat Treatment Score			9	