

Attachment B4
Positive Control Log Matrix for Forming Machine

Attachment B4 POSITIVE CONTROL LOG MATRIX FOR FORMING MACHINE									Revision: 3	
INPUT VARIABLE				PLATFORM (FORMING MACHINE)					HEPCO	
Item	Category	Subcategory	Frequency	HOPE SEIKI						
				ADLT		ADGT		ADCV		
				Ammopak	Reel	Ammopak	Reel	Ammopak	Reel	
1	Speed	Speed Meter	Every set-up	N/A	N/A	N/A	N/A	N/A	N/A	
2	Orientation	Style P or A	Every set-up	ON	ON	ON	ON	N/A	N/A	
		Style M or E	Every set-up	N/A	N/A	N/A	N/A	N/A	N/A	
3	Sealing Assembly	Sealing Temperature	Every set-up	130-190°C	130-190°C	130-190°C	130-190°C	N/A	130-190°C	
		Air Pressure	Every set-up	4.7 - 6.0 kgf/cm	4.7 - 6.0 kgf/cm	4.7 - 6.0 kgf/cm	4.7 - 6.0 kgf/cm	N/A	4.7 - 6.0 kgf/cm	
		Part Counter	Every set-up	1000 units	2000 units	2000 units	N/A	N/A	2000 units	
		Free Transfer (Leader / Trailer)	Every set-up	24 pockets	24 pockets	24 pockets	24 pockets	N/A	N/A	
		Folded Stack	Every set-up	24 units	N/A	25 units	N/A	N/A	N/A	
		Feed Roller Torque Motor	Every set-up	2 - 3	2 - 3	2 - 3	2 - 3	N/A	2 - 3	
4	Lead Form Requirement	Based on Requirement	Every set-up	N/A	N/A	N/A	N/A	N/A	Standard/Specific (Specify if what flow#)	
	Lead Form Measurement	Passed or Failed	Every set-up	N/A	N/A	N/A	N/A	N/A	Passed or Failed	