

SRI	ISO 9001: 2015 Quality Management System Quality Procedure Manual	
Document No: SRI-QPM 07- 6	DSI Tyres	Revision No :04
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Title : Procedure for Calendaring		

7-6) PROCEDURE FOR CORD CALENDERING

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">PLANING</div>	1. Examine the Production plan	MAN/LEADER/OP	PC-PLAN-02F
	2. Order Material from relevant department	LEADER/SUP	IFS-System
	3. Report current material stock to planning dept.	LEADER/SUP	Com.Soft Copy
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">MATERIAL RECEIVING</div>	1. Receive nylon tyre cord from stores with test report	LEADER/SUP	IT-REC-055
	2. Receive Compounds from Mixing	LEADER/SUP	PC-SCHED-01
	3. Check lab report of tyre cords and topping compound.	LEADER/SUP	IT-REC-055 IT-FORM-02A WI-002
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">MACHINE PREPARATION</div>	1. Check the Machine	LEADER/OPE	MC-CL-002M MC-CL-002C
	2. Set Machine as per Instruction	„	WI-002
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">RUBBERIZING</div>	1. Worm up and Issue the rubber compound to calender	MILL OPE	WI-002
	2. Feed compound to calender machine	OPE/HELPER	WI-002
	3. Rubberize	CORD OPE	„
	4. Check quality when rubberizing and record (Measure the thickness of canvas)	OPE/HELPER	PC-CAL-REC-01
	5. Complete Rubberizing, and remove rubberized cord roll form calender and attach identification tag	CORD OPE	„
	6. If necessary, cover cord roll with Polythene film.	OPE-HELPER	
	7. Fill the record sheet and report rubberized qty to IFS System.	OPE/DATA ENTRY OPE	PC-002 IFS System

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7-6) *PROCEDURE FOR BIAS CUTTING OF RUBBERIZED CANVAS*

Flow	Activity	Responsibility	Ref
FEEDING MATERIALS	1. Examine the Production plan	LEADER/SUP/ MAN	PC-PLAN-02F
	2. Feed rubberized canvas	OPE/HELPER	WI-003
MACHINE PREPARATION	1. Check the Machine	OPERATOR	MC-CL-004
	2. Set Machine Width & Angle as per specification	LEDER/OPE	PC-CAL-TABLE-03
CUTTING & WINDING	1. Check the current stock level available in the section and building section	OPERATOR	WI-003
	2. Cut and remove any damages of the canvas	„	„
	3. Cut joint and wind the canvas	„	„
	4. Check width and weight, wrinkles when winding.	OPE/HELPER	„
	5. Attach identification sticker after completing the winding.	„	„
	6. Hang onto the conveyer	„	„
	7. Fill the record and report canvas production to IFS system	OPE/ DATA ENTRY OPE	PC-004/ IFS System
DELIVARY	1. Deliver canvas roll to the building section according to production plan after maturation period and enter details in to IFS system	LEADER/ HELPER	PC-PLAN-02F WI-003
REJECTION	1. Fill up IMI form and use NC form, if necessary	APM/LEADER/	IMI-FORM NC-FORM-01
	2. Weight and dispose damage canvas cuttings through the scraping report.	APM/LEADER	SRI-040
	3. Analyze wastage graphically for improvement.	„	„

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7-6) PROCEDURE FOR PROFILE CALENDERING

Flow	Activity	Responsibility	Ref
<div>PLANING & CHECKING MATERIALS</div>	1. Examine the Production plan.	OP/LEADER/SUP	PC-PLAN-02G
	2. Check current stocks and inform to planning department	LEADER/SUP	Com.Soft Copy
	3. Check material coming from mixing section <ul style="list-style-type: none"> Adequacy Quality 	LEADER/SUP	PC-SCHED-01 WI-005 IT-FORM-02A
<div>CHECKING PREPARATI</div>	1. Check the Machine.	PROFILE OP/ MILL OP	MC-CL-005 MC-CL-002M
	2. Set Machine as per instruction	APM/LEADER/ OPE	WI-005
<div>PROFILE</div>	1. Worm up and issue compound	MILL OPERATOR	WI-005
	2. Profile calendaring	PROFILE OPE	„
<div>INSPECTION & WINDING</div>	1. Check Wight, Thickness and width of tread and enter the record sheet	PROFILE OPE	PC-005
	2. Attach identification sticker after winding complete.	„	„
	3. Hang on the conveyer	HELPER	„
	4. Fill Record sheet and enter the tread & liner production qty to IFS system.	OPE/DATA ENTRY OP	PC-005 IFS System
<div>DELIVARY</div>	1. Delivery to building section after the maturation period according to requirement.	HELPER	WI-005
<div>REJECTION</div>	1. Raise the IMI form	LEADER/SUP	IMI-FORM
	2. Report dispose compound to the IFS System and complete the scrapping report as per IMI instructions	„	IFS System SRI-040

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