

<h1>SRI</h1>		ISO 9001: 2015 Quality Management System Quality Procedure Manual	
Document No: SRI-QPM 07- 7			Revision No :03
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Title : Procedure for Green Tyre Making			

7.7 PROCEDURE FOR MAKING GREEN TYRES (BICYCLE & MOTER CYCLE)

Flow	Activity	Responsibility	Ref
<div>PLANNING</div>	1. Examine the production plan.	APM / LED	PC-PLAN-02
	2. Examine available material stocks and received materials from relevant sections.	LED	
	3. Send material & green tyre stock to calendar section & Planning Department	„	E-Mail PC-BC-REP-01 PC-005/005E PC-PLAN-02F
	4. Examine quantity of green tyres as according to production plan	LED	
<div>MACHINE CHECK</div>	1. Check the Machines	OPE	MC-CL-006
	2. Set Machine as per instruction	„	
	3. If any problems inform to the maintenance section through IFS System	LEDER	IFS System
<div>INSPECTION OF MATERIALS</div>	1. Check tags on all materials received.	OPE	WI-006/WI-007
	2. Measure size, weight, and quality of material against the tag entries/ specifications.	LED/ OPE	PC-006A/ PC-006B
	3. Remove defective material after recording defectives.	LED/APM	IMI-FORM/ NC-FORM-01
	4. Enter the material wastage to IFS system or Scrapping Report	„	SRI-040
<div>TYRE BUILDING</div>	1. Feed material to machine	OPERATOR	WI-006
	2. Place appropriate bead wire in drum.	„	„
	3. Ensure the bead wire fit in to the grooves and correct over laps (Canvas & tread etc)	„	„
	4. Place Identification Numbers	„	„
	5. The green tyre sent to the venting machine if any	„	„
	6. Hang the built green tyre on the conveyer to send the press section.	HELPER/OPE	„

If MR signature is absent this will not be a controlled document.	Signature of Management Representative		
	Date		

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Flow	Activity	Responsibility	Ref
<div>INSTECTION</div> <div>↓</div> <div>REJECTION</div>	1. Inspect all tyres in each stage of building for any defects.	OPERATOR	WI-006/ WI-007
	2. Random quality check & record	OPERATOR & LEADER	PC-006A/ PC006B
	1. raise IMI or NC If any material or green tyre found to be quality problems.	LEADER/APM	IMI FORM / NC System
	2. Report material wastage to Account department through scrapping reports .	”	SRI-040
	3. Follow order progress	”	IFS system

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