

<b>SRI</b>	ISO 9001: 2015 Quality Management System Quality Procedure Manual	
Document No: SRI-QPM 07 (2.1) Date Issued : 01/11/2024 Revision Date:	<b>DSI Tyres®</b>	Revision No :00 Page No : 1 of 2
Title : Procedure for Planning Bead Wire		

### **7.2.1 PROCEDURE FOR PLANING BEAD WIRE**

#### **7.2.1.1 SCOPE**

The Objective is:

- To plan the production to ensure the delivery promising date
- To keep finished goods stocks at minimum level
- To minimize the work –in-progress
- To Minimize the idle time due to non-availability of materials
- To ensure optimum utilization of machines and man

#### **7.2.1.2 RESPONSIBILITY**

Overall responsibility of production planning lies with the Senior Planning Manger further it is assisted by Senior Assistant Planning Manager

#### **7.2.1.3 PROCEDURE STEPS**

1. The Bead Wire production plan is prepared using the Pre-actor Planning Board.
2. The Bead Wire production plan is prepared on a weekly basis by the Planning department according to the specifications released by R&D and the approved production norms provided by the Production Manager/COP.
3. The Bead Wire production plan is developed by considering the Weekly Press Plan, actual stock levels, item-wise machine allocation, and labor availability.
4. The Bead Wire plant must strictly adhere to the production plan when executing daily Bead Wire production.
5. If any adjustments to the plan are required, they should be communicated immediately after the release of the production plan for the following week.
6. The weekly plan will be issued on Wednesday of each week.
7. The Bead Wire plant is not permitted to produce more Bead Wires than the plan requirement (overruns are not allowed).
8. For BC category items, if the weekly plan quantity of a particular Bead Wire item is too small (less than 3,000 units), it should be planned and produced in a single run per week to achieve production efficiencies.
9. Regarding point 7, if further consideration is required, please provide your comments.
10. Here after planning dept will use IFS stocks to do Bead Wire workings
11. Bead Wire Plant and Building section should ensure the accuracy of the Bead Wire stocks available at IFS at any given time

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	Date	

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Page No : 2 of 2

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**7.2.1.4 PROCEDURE ACTIVITIES TO BE PERFORMED**

No	Description	Responsibility
01	Before commence the workings , ask Bead wire section to report the production to IFS to ensure updated stocks are available in the system	Planner / PM in Bead Wire Plant
02	Same time , check whether all the vulcanize tyre qty produced on last day were reported to the IFS	Planner / PM in Press Section
03	According to that , it is necessary to ensure that updated Bead wire inventory is available at IFS in all stock locations	Planner
04	Get Bead Wire stock from IFS	Planner
05	Get Bead Wire requirement for next week plan from PreActor	Planner
06	Call Bead Wire working sheet ( Format is shown in the attachment)	Planner
07	Enter IFS stocks , requirement and decide the no of Bead Wire required for next week plan	Planner
08	Create Shop orders at IFS and import those shop orders to Preactor	Planner
09	Do scheduling in the Planning Board considering the Standard machine allocation and labor availability	Planner
10	Send Bead Wire Plan to Bead Wire Plant	Planner
11	Call comments to the Plan	Planner /PM in Bead Wire Plant
12	Adjust the plan , if necessary	Planner
13	Finalize the Plan and send to Bead Wire Plant	Planner
14	Bead Wire Plant should execute the Plan	PM in Bead Wire section
15	Report daily production to IFS	PM in Bead Wire section
16	Apply same procedure to revise the plan due to production losses at Bead Wire Plant on daily basis	Planner/ PM in Bead Wire section
17	Prepare Daily production report ( Target Vs Actual ) including rejections and send to AGM (Pro Co)	PM in Bead Wire section
18	This report will be sent to management on daily basis	AGM ( Pro Co )

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