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## 8.2.2 AUDITING OF PROCESS AND PRODUCT COMPLIANCE. (STSRTING FROM MATERIAL TO END PRODUCT)

### 8.2.2.1 SCOPE

Auditing the compliance of all related process and inspection of quality characteristics of tyre and tube components.

### 8.2.2.2 *Procedure for auditing production process & inspection of tyre & tube components.*

#### *A) Compound Mixing*

Flow	Activity	Responsibility	Ref
	1. Audit compound mixing process.	COP OFFICER	COP-WI-001
	2. Collect samples as specified.	„	COP-SA-001
	3. Record audit & sample details.	„	COP-QC-007
	1. Carry out inspection and obtain the required measurements & records.	COP OFFICER	COP-WI-001 COP-QC-007
	2. Report results to relevant sections.	COP OFFICER	COP-QC-007
	2. If the results are not within the relevant specification and work instructions, inform to responsible personnel for prompt action	„	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	„	COP-WI-001 QIP SYSTEM
	4. Analyze root course to <i>NC reports</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	„	

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## B) Cord Calendaring

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">AUDITING &amp; SAMPLING</div>	1. Audit cord calendaring process.	COP OFFICER	COP-WI-002A/002B
	2. Collect samples as specified.	”	COP-SA-020A,/002B
	3. Record audit & sample details.	”	COP-QC-001
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">TESTING &amp; RECORDING</div>	1. Carry out inspection and obtain the required measurements & records.	COP OFFICER	COP-WI-02A/002B COP-QC-001
	1. Report results to relevant sections.	COP OFFICER	COP-QC-001
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-002A/002B QIP SYSTEM
	4. Analyze root course to <i>NC report s</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	”	

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### C) Bias Cutter

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">AUDITING &amp; SAMPLING</div>	1. Audit Bias cutting process.	COP OFFICER	COP-WI-003A/003B
	2. Collect samples as specified.	”	COP-SA-003A/003B
	3. Record audit & sample details.	”	COP-QC-002
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">TESTING &amp; RECORDING</div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-003A/003B COP-QC-002
	1. Report results to relevant sections.	COP OFFICER	COP-QC-002
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-003A/003B QIP SYSTEM
	4. Analyze root course to <i>NC reports</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	”	

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### D) Tread Profiling

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">AUDITING &amp; SAMPLING</div>	1. Audit tread profiling process.	COP OFFICER	COP-WI-004A/004B
	2. Collect samples as specified.	”	COP-SA-004A/004B
	3. Record audit & sample details.	”	COP-QC-003
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">TESTING &amp; RECORDING</div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-004A/004B COP-QC-003
	1. Report results to relevant sections.	COP OFFICER	COP-QC-003
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-004A/004B QIP SYSTEM
	4. Analyze root course to <i>NC report s</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	”	

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### E) Tread Extrusion

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">AUDITING &amp; SAMPLING</div>	1. Audit tread extrusion process.	COP OFFICER	COP-WI-005A/005B
	2. Collect samples as specified.	”	COP-SA-005B
	3. Record audit & sample details.	”	COP-QC-009
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">TESTING &amp; RECORDING</div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-005A/005B COP-QC-009
	1. Report results to relevant sections.	COP OFFICER	COP-QC-009
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-005A/05B QIP SYSTEM
	4. Analyze root course to <i>NC report s</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	”	

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## F) Tube Extrusion

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">AUDITING &amp; SAMPLING</div>	1. Audit tube extrusion process.	COP OFFICER	COP-WI-005C
	2. Collect samples as specified.	”	COP-SA-005C
	3. Record audit & sample details.	”	COP-QC-010
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">TESTING &amp; RECORDING</div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-005C COP-QC-010
	1. Report results to relevant sections.	COP OFFICER	COP-QC-010
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-005C QIP SYSTEM
	4. Analyze root cause to <i>NC report s</i> & take corrective actions with relevant department.	COPM	
	Verify the effectiveness of the corrective action before close the <i>NC report</i>	”	

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**G) Bead Wires Manufacturing**

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>AUDITING &amp; SAMPLING</b> </div>	1. Audit bead wire manufacturing process.	COP OFFICER	COP-WI-006A/006B
	2. Collect samples as specified.	”	COP-SA-006A/006B
	3. Record audit & sample details.	”	COP-QC-004
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>TESTING &amp; RECORDING</b> </div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-006A/006B COP-QC-004
	1. Report results to relevant sections.	COP OFFICER	COP-QC-004
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>REPORTING</b> </div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-006A/006B QIP SYSTEM
	4. Analyze root cause to <i>NC reports</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	”	

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## H) Green Tyre Building

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>AUDITING &amp; SAMPLING</b> </div>	1. Audit green tyre building process.	COP OFFICER	COP-WI-007A/007B
	2. Collect samples as specified.	„	COP-SA-007A/007B
	3. Record audit & sample details.	„	COP-QC-005-1/005-2
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>TESTING &amp; RECORDING</b> </div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-007A/007B COP-QC-005-1/005-2
	1. Report results to relevant sections.	COP OFFICER	COP-QC-005-1/005-2
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>REPORTING</b> </div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	„	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	„	COP-WI-007A/007B QIP SYSTEM
	4. Analyze root cause to <i>NC report s</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	„	

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### 1) Green Tube Splicing

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: fit-content; margin: 10px auto;">AUDITING &amp; SAMPLING</div>	1. Audit green tube splicing process.	COP OFFICER	COP-WI-007C
	2. Collect samples as specified.	”	COP-SA-007C
	3. Record audit & sample details.	”	COP-QC-011
<div style="border: 1px solid black; padding: 5px; text-align: center; width: fit-content; margin: 10px auto;">TESTING &amp; RECORDING</div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-007C COP-QC-011
	1. Report results to relevant sections.	COP OFFICER	COP-QC-011
<div style="border: 1px solid black; padding: 5px; text-align: center; width: fit-content; margin: 10px auto;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-007C QIP SYSTEM
	4. Analyze root cause to <i>NC reports</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	”	

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## J) Green Tyre Curing

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">AUDITING &amp; SAMPLING</div>	1. Audit green tyre curing process.	COP OFFICER	COP-WI-008A/008B
	2. Collect samples as specified.	„	COP-SA-008A/008B
	3. Record audit & sample details.	„	COP-QC-006
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">TESTING &amp; RECORDING</div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-008A/008B COP-QC-006
	1. Report results to relevant sections.	COP OFFICER	COP-QC-006
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	„	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	„	COP-WI-008A/008B QIP SYSTEM
	4. Analyze root course to <i>NC reports</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i>	„	

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## H) Green Tube Curing

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>AUDITING &amp; SAMPLING</b> </div>	1. Audit green tube curing process.	COP OFFICER	COP-WI-008C
	2. Collect samples as specified.	”	COP-SA-008C
	3. Record audit & sample details.	”	COP-QC-011
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>TESTING &amp; RECORDING</b> </div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-08C COP-QC-011
	1. Report results to relevant sections.	COP OFFICER	COP-QC-0011
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>REPORTING</b> </div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-008C QIP SYSTEM
	4. Analyze root course to <i>NC reports</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i> .	”	

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### L) Jointed Tube Manufacturing

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>AUDITING &amp; SAMPLING</b> </div>	1. Audit Jointed tube manufacturing.	COP OFFICER	COP-WI-09C
	2. Collect samples as specified.	„	COP-SA-009C
	3. Record audit & sample details.	„	COP-QC-012
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>TESTING &amp; RECORDING</b> </div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-009C COP-QC-012
	1. Report results to relevant sections.	COP OFFICER	COP-QC-012 COM BOOK
<div style="border: 1px solid black; padding: 5px; text-align: center; width: 100px; margin: 10px auto;"> <b>REPORTING</b> </div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	„	
	3. Raise <i>NC report</i> for any non-conformity.	„	COP-WI-009C QIP SYSTEM
	4. Analyze root cause to <i>NC report s</i> & take corrective actions with relevant department.	COPM	
	Verify the effectiveness of the corrective action before close the <i>NC report</i>	„	

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**M) Air Bag Manufacturing**

Flow	Activity	Responsibility	Ref
<div style="border: 1px solid black; padding: 5px; text-align: center; font-weight: bold;">AUDITING &amp; SAMPLING</div>	1. Audit air bag manufacturing.	COP OFFICER	COP-WI-010
	2. Collect samples as specified.	”	COP-SA-010A
	3. Record audit & sample details.	”	COP-QC-008
<div style="border: 1px solid black; padding: 5px; text-align: center; font-weight: bold;">TESTING &amp; RECORDING</div>	1. Carry out inspections and obtain the required measurements & records.	COP OFFICER	COP-WI-010 COP-QC-008
	1. Report results to relevant sections.	COP OFFICER	COP-QC-008
<div style="border: 1px solid black; padding: 5px; text-align: center; font-weight: bold;">REPORTING</div>	2. If the results are not within the relevant specifications and work instructions, inform to responsible personnel for prompt actions	”	COM BOOK
	3. Raise <i>NC report</i> for any non-conformity.	”	COP-WI-010 QIP SYSTEM
	4. Analyze root cause to <i>NC reports</i> & take corrective actions with relevant department.	COPM	
	5. Verify the effectiveness of the corrective action before close the <i>NC report</i> .	”	

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