

<b>SRI</b>	ISO 9001: 2015 Quality Management System Quality Procedure Manual	
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Title : Procedure for Identification & Traceability		

## **Procedure for Identification & Traceability.**

### **Scope**

The company has established product identification & traceability which ensures that processes involved in the manufacture of any product could be traced back from end product up to component level.

### **Responsibility**

Head of the department & plant COP Manager.

### **1<sup>st</sup> Step**

Select the tyre traceability number from FG stores, finished tire from production or any complaint made by the customer with tyre serial (identification) number

### **2<sup>nd</sup> Step**

Check the PC-006A (BC) or PC-006B (MC) tyre building record sheets.

Refer the serial number select the building machine numbers and following items

- Bead Bundle no
- Roll no of Canvas types (Canvas, Breaker, Chafer)
- Tread and strip roll no's
- Stickers
- Production date

### **3<sup>rd</sup> Step**

#### **3.1 Pressing information.**

Refer to Building machine record sheet and production date, find tyre curing press number. Refer the PC-011-A /PC-11-B tyre curing record sheet. Gather following information through this record sheet.

- MC condition
- Press operator
- Curing temperature
- Curing time
- Curing pressure
- Mould conditions

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

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### 3.2 Profile Information.

Refer the ID label information from building record sheet (tread roll no, production dates)  
Gather tread details relevant from record sheet PC-005. (if it is necessary to review machine condition refer the MC-CL-005)

- Compound type & batch numbers
- Expire date
- MC operator
- Production date & time
- Technical parameters

### 3.3 Bias cutter

According to collect details of building machine information, refer the canvas roll number identified the rubberize canvas details with PC-004 bias cutter record sheet. (if it is necessary to review machine condition, refer to MC-CL-004).

- Rubberized canvas roll no
- Bias cut roll no
- Expire date
- MC operator
- Technical parameters

### 3.4 Cord Calender

Trace rubberized roll number by refereeing to cord calendaring information. refer to PC-002 cord calenderer record sheet (if it is necessary to review machine condition, refer to MC-CL-002 C)

- Nylon cord no
- Compound type
- Compound batch no
- Thickness of rubberized code (Refer Roll ID Card)
- Production date
- Calender operator

3.4.a. Refer to lab report and refer to IFS system for Nylon cord approval status

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### 3.5 Bead Wire.

According to building process information gathered, refer to PC-001 bead wire making record sheet for bead wire bundling no (if need machine condition refers the MC-CL-001)

- Bead wire bundling no
- Compound type & batch no
- Steel wire coil no
- Machine operator
- Plant no
- Technical parameters

3.5.a Refer to lab report and IFS system for Steel wire approval status.

### 3.6 Mixing

Refer to PC-011 mixing record sheet to gather polymer and chemical information. According to identified compound batch number (Profile calender, Cord calender& bead wire plant) and collect the details. Use computer lot creation data base identified the chemical and polymer invoice numbers.

- Polymer lots no (Use computer data base)
- Bulk chemical lot no (Use computer data base)
- Small chemical lot no (Use computer data base)
- Plant no
- Curing cycle
- Temperature
- Compound formula (PC-MIX-REC-01)

### 4<sup>th</sup> Step

Identify shipment details and lab reports of incoming material details through IFS system. Use the invoice number (Material Lot Identification), Use the applicable packing list to obtain information of steel wire coil number and nylon cord roll number.

- Shipment no
- Lab approval report
- Suppler name & code
- Country
- Shipping date etc information

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