1. **Purpose:** To Determine the Anodizing Thickness of Frame During Incoming Quality Inspection.
2. **Scope:** For Inspection of Frame used in GSPL.
3. **Reference Documents:** NA
4. **Authority and Responsibility:** IQC And Inprocess Quality Control Engineer
5. **Procedure:** As below

Rules for Operating Personnel

1. Never use a machine if you are not trained or not Familiar with it.
2. Never Remove Shield or Machine Guard.
3. Wear Proper PPE as Per Requirement.
4. Check the Safety device on a regular, Periodic basic to confirm that they are operating correctly.
5. Keep hand and Body clear when Operating Machine, Always Maintain a safe distance from Moving Parts.
6. Never try to climb or extent your hand over safety device, Equipment and Guards.

Work Instructions (Steps)	Pictures	Check Points

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1) Switch on the instrument (Fig.1). 2) Place the instrument (Anodizing meter) on specimen (object to be tested- e.g Al.frame). The measurement reading appears in display (Fig.2). 3) Lift up instrument at least 25 mm from the surface. Place the instrument down again for the next measurement. Measure the Anodizing thickness at 10 different positions on same frame. 4) Before testing, calibrate the Anodizing thickness gauge (or Coating thickness gauge). 5) Incase anodize thickness less than	 Fig.1  Fig.2	1). Always wear the personal protective equipment.

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15micron then do double sampling for again verification. 6) Incase in double sampling it will fail again then inform to purchase/supplier for action plan and material will put on HOLD with proper identification. **Calibration Process :-**		

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1) Perform 5 to 10 measurement on the uncoated reference part (Fig.3.1, Fig.3.2).

2) Press the multifunctional key ok to complete the normalization. The message “please measure several times: CAL-rated value or please measure several times : 75.3 µm appears in the display.”

3) Place the calibration foil on the uncoated reference part (Fig.4).

4) Perform 5 to 10 measurement on the calibration foil. To do this place the probe on the foil within the circle each time (Fig.5).

5) Press the multifunctional key Ok to quit the measurement and to

Fig.3.1

Fig.3.2

set up the CAL rated value.

6) Use the multifunctional key ↑↓ to set the rated value of the calibration foil.The rated value printed on calibration foil.

7) Remove calibration foil from the reference part.

8) Press multifunctionl key Ok to complete the calibration.

Fig.4

Fig.5

Check for Potential Hazards signage on WorkPlace	
	Machine Grounding

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	Danger High Voltage and Non Touching
 Danger	In an Urgent situation and if not avoided, it will result in serious casualties.
 Warning	Potential urgent situation, and if not avoided, it will result in serious casualties.
 Warning	Potential situation if not avoided, it will result in Minor injuries or property loss.

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