

CTQ DIPPING	Prod. Date:				Former Type:				Conducted by:	Name:		Designation:	
	Shift:	A / B	Time:		Former Size:								
	Line:				L1:		R1:						
	Product:				L2:		R2:						

Process / Area	CTQ Items		Standard	Inspection		Action / Observation If (NG) - Insert action
				OK, Tick (✓)	NG, Tick (✗)	
1 Former Changing Area	1.1	Brush Condition	Brush contact with holder			
	1.2	Holder Carpet Condition	No tear & dirt			
2 Acid	2.1	Cleanliness of Solution	No floating particles			
	2.2	Foam Formation	Foam not touching S-track			
	2.3	Overflow Condition	No blockage & No excessive overflow			
	2.4	Dosing pump / CAA Functionality	No blockage & No leaking			
	2.5	S-track & Holder Condition	No dirt & excessive splashing			
	2.6	Main Chain Lip Condition	No overflow of oil & grease			
3 Hot Shower	3.1	Nozzle Coverage	Spray covers cuff area & nozzle not blocked			
	3.2	S-track & Holder Condition	No dirt & No spray to holder & S-track			
	3.3	Main Chain Lip Condition	No overflow of oil & grease			
4 Acid Bath (if Applicable)	4.1	Cleanliness of Solution	No floating particles			
	4.2	Foam Formation	Foam not touching S-track			
	4.3	Overflow Condition	No blockage & No excessive overflow			
	4.4	S-track & Holder Condition	No dirt & excessive splashing			
	4.5	Main Chain Lip Condition	No overflow of oil & grease			
5 Alkaline	5.1	Cleanliness of Solution	No floating particles			
	5.2	Foam Formation	Foam not touching S-track			
	5.3	Overflow Condition	No blockage & No excessive overflow			
	5.4	Dosing pump / CAA Functionality	No blockage & No leaking			
	5.5	S-track & Holder Condition	No dirt & excessive splashing			
	5.6	Main Chain Lip Condition	No overflow of oil & grease			
6 Hot Bath	6.1	Cleanliness of Water	No floating particles in the water			
	6.2	Foam Formation	Foam not touching S-track			
	6.3	Overflow Condition	No blockage & No excessive overflow			
	6.4	S-track & Holder Condition	No dirt & excessive splashing			
	6.5	Main Chain Lip Condition	No overflow of oil & grease			
7 Cleaning Brush	7.1	Nozzle Coverage (Entry, Middle & Exit)	No blockage & shower angle must not hit holder			
	7.2	Cleaning Brush Condition	Brush contact with former & No contamination			
			Water flow at brush & nylon bush			
	7.3	Cleaning Brush & Motor Rotation	All brush rotate in alternate direction (Clockwise & Anticlockwise)			
8 Hot Rinse	7.4	Main Chain Lip Condition	No overflow of oil & grease			
	8.1	Cleanliness of Water	No floating particles & white residue			
	8.2	Overflow Condition	No blockage			
	8.3	Pump Functionality	No leaking at joint			
	8.4	S-track & Holder Condition	No dirt & excessive splashing			
9 Hot Water	8.5	Main Chain Lip Condition	No overflow of oil & grease			
	9.1	Cleanliness of Water	No floating particles & white residue			
	9.2	Overflow Gutter Condition	No blockage			
	9.3	Sieve Condition	No damage			
	9.4	S-track & Holder Condition	No dirt & excessive splashing			
10 Hot Water Blower	9.5	Main Chain Lip Condition	No overflow of oil & grease			
	10.1	Air Intake Filter Condition	No dirt & damage			
	10.2	Holder Condition	No water dripping from holder			
	10.3	Former Dryness @ Exiting	No water droplet at finger tip & shank area			
	10.4	Main Chain Lip Condition	No overflow of oil & grease			

Process / Area	CTQ Items		Standard	Inspection			Action / Observation If (NG) - Insert action
				OK, Tick (✓)	NG, Tick (✓)		
11 Coagulant	11.1	Dip Tank Coagulant Condition	No bubble/ foam, creaming, oily surface, separation and stain				
			Have waterfall				
	11.2	Webbing Condition	Check coagulant webbing condition @ Withdrawal area	< 1/4 Webbing	3/4 Webbing	Full Webbing	
	11.3	Sieve Condition	No blockage & bubble after sieve				
	11.4	Feeding Tank	No dirt/ floating particles on the coagulant surface				
	11.5	Sieve Tray under S-track	No damage & Not submerged in coagulant solution				
11.6	Main Chain Lip Condition	No overflow of oil & grease					
12 B-Oven	12.1	CN Deposit @ 2nd door	No CN deposit surrounding the ducting hole				
	12.2	Former Dryness @ Exiting	Shinning & damp condition				
13 Latex	13.1	Dip Tank Latex Condition	No bubble/ foam, coagulum, oily surface and stain at latex dip area				
			No flowmark present on former surface				
			No wavy pattern at cuff area (Bad Latex Flow)				
	13.2	Webbing Condition	Check latex webbing condition @ Withdrawal area	< 1/4 Webbing	3/4 Webbing	Full Webbing	
	13.3	Dip Tank Sieve Condition	No blockage & bubble after sieve				
	13.4	Feeding Tank Condition	Check for dirt/ floating particles on the surface				
	13.5	Latex Build-up Condition	No latex build up @ Dripping tray & Support beam				
	13.6	Main Chain Lip Condition	No overflow of oil & grease				
13.7	Chiller Water Buffer Tank	No overflow & water level within range					
14 C Oven	14.1	Synerisis Condition	Continuous water flow at C oven tray @ Burner door				
15 Pre Leaching	15.1	Darkband Formation	Have darkband & No sign of water seeping into glove				
	15.2	Cleanliness of Water	No scum, emb gloves & excessive foam in the tank				
	15.3	Rotameter Functionality @ Tank 6	No leaking & fluctuating issue & within rotameter range				
	15.4	Sieve Condition	No blockage				
	15.5	S-track & Holder Condition	No dirt & excessive splashing				
	15.6	Main Chain Lip Condition	No overflow of oil & grease				
16 Pre Leaching Blower	16.1	Air Intake Filter Condition	No dirt & damage				
	16.2	Main Chain Lip Condition	No overflow of oil & grease				
17 Beading	17.1	Brush Condition	No stain on brush & brush not wavy				
	17.2	Former Rotation	V-belt in contact with former & No former bumping				
	17.3	Beading Formation	Beading start & end point within range				
			No flat & inconsistent beading				
17.4	Tray Condition	No damage, No dirt & stain accumulation					
18 Cooling	18.1	Cleanliness of Water	No scum & excessive foam				
	18.2	Rotameter Functionality	No leaking & within rotameter range				
	18.3	Sieve Condition	No blockage				
	18.4	S-track & Holder Condition	No dirt & excessive splashing				
	18.5	Main Chain Lip Condition	No overflow of oil & grease				
19 Neutralizer	19.1	Neutralizer Solution Condition	No dirt/ cloudy & floating particles				
	19.2	S-track & Holder Condition	No dirt & excessive splashing				
	19.3	Main Chain Lip Condition	No overflow of oil & grease				
20 Last Rinse Tank	20.1	Cleanliness of Water	No floating particles & cloudy				
	20.2	Rotameter Functionality	No leaking & within rotameter range				
	20.3	Sieve Condition	No blockage				
	20.4	S-track & Holder Condition	No dirt & excessive splashing				
	20.5	Main Chain Lip Condition	No overflow of oil & grease				
21 After Rinse Blower	21.1	Air Intake Filter Condition	No damage & dirt				
22 D Oven	22.1	Glove Dryness @ Exiting	No wet look/ watermark observed on glove				
23 Pre-Roller	23.1	Brush Condition	No stain on brush & brush not worn out/ wavy				
	23.2	Former Rotation	V-belt in contact with former & No former bumping				
	23.3	Cuff Roll Condition	Cuff roll start & end point within range				
			Cuff roll within clamp position				
24 GSR	24.1	Clamp condition	No damage & No misalignment				
	24.2	Platform Area Cleanliness	No glove accumulate on the platform surface				
25 Puller	25.1	Glove Line Condition (Fishing Line)	No damage				
	25.2	Platform Area Cleanliness	No removable dirt & glove on the platform surface				

