

# Standard Work Instruction

**Process:** Cutting Alum Components at Chop Saw for Frames

**Version:** 5/30/2024

**STEP** **NOTES:** **PURPOSE:** Instruction for an Operator familiar with Chop Saw operation to select Aluminum Components to cut per Production Order and Framing Sheet.

**REFERENCE:** Production Order Form, Framing Sheet, Gate Configurator Sheet

**1A** **Review** Production Orders in Clear Order packet.

The Production Order will show a SINGLE Job Number (-75) (1), Item Number (2), Item Description (3), Component ID (4), Qty Required (5.00) (5) and Panel Length (6) (e.g. 92.265").

**1B** **Look** For Shapes: **AL01, AL02, AL06** and any **Aluminum SPEC** parts in the Component ID

**1C** **Highlight** any parts in the Production Order to pick and cut.

**ALSO:** Review the **Framing Sheet** as it has all the Cut Aluminum needed for the Sales Orders, that consists of multiply Prod Orders.

**QUESTIONS?** - Please refer to Configurator Sheet, Component P/N Sheet or see the Framing Leader/Supervisor

SHAPE	SHAPE DESC.
AL01xxx	Door Jam
AL02xxx	Top Track
AL03xxx	VP Ext.
AL04xxx	Lead Post
AL05xxx	Sill
AL06xxx	Jam-Deep Channel

**NOTE:** To advance the work, it would be necessary at certain times to make the AL03xxx components first, which are the rods (VP. Ext.) so that other workers are not left without work.

Production Order		Issue Date: May 25, 2024
Production Order Number: G052724-10		Due Date: Jun 18, 2024
Special Instructions:		Page: 1
101095 JAX-0109414/27772 4/26 ORDER REI	Item Number DYLP200281D	Production Quantity 1.00
12-PNL, 81 1/4, LO, OFFSET, RH	Production Order Status Open	Total Est. Hours 79.130
Component ID	Description	Hours
SPEC-66.75	QTY(12) FULL PANELS	1.00
SPEC-104	SLIM HINGE FULL PNL = 3.100	1.00
SPEC-105.1	SLIM 3/4 PNL CUSTEL = 1.4955	1.00
SPEC-106	SLIM HINGE 1/2 PNL = 1.355	1.00
SPEC-70	HARD HINGE CONNECTORS	1.00
SPEC-44	LEAD POST GIB	1.00
3/8x7/8x1-7/8DELRIN	BLK, LEAD POST GIB	0.05
AL04N	LEAD POST CLEAR	1.00
SPEC-07.1	LEFT HAND LEAD POST	1.00
AL01N	DOOR JAM CLEAR	1.00

- 2A** Review **Framing Sheet** in Clear Order packet. It gives a summary of the Framing Size, Type, and Handing of multiple orders. The **Framing Sheet** will show **MULTIPLE WO Numbers** and **SO Numbers, Qty, Size, Length, AL Color, and Lead Post Hand (LH or RH)**. It will allow you to select aluminum for multiple orders to save cut time.
- 2B** **NOTE** the different LENGTH and AL COLOR. Also note Each Panel needs (2) AL03.
- 2C** **Highlight** any parts in the Framing Sheet to pick and cut.  
**QUESTIONS?** - Please refer to Configurator Sheet or see the Framing Leader/Supervisor

## Framing Sheet Sample

QTY	SIZE	LENGTH	AL COLOR	ACRYLIC /WOOD/VINYL COLOR	LEAD POST	VISI	1/2 PNL CONNECTOR	WO Number	SO Number	PRODUCT	REI
12	FULL-SLIM	79.130	CLR	LT OAK	LH(1)		GRAY	G052724-10	101095	DYLP200281D	
1	3/4-CUSTEL	79.130	CLR	LT OAK					27772		
12	FULL-SLIM	79.130	CLR	WHT	LH(1)		GRAY	G052724-9	101096	DYWP200281D	
1	3/4-CUSTEL	79.130	CLR	WHT					27896		
12	FULL-SLIM	79.130	CLR	WHT	LH(1)		GRAY	G052724-8	101097	DYWP200281D	
1	3/4-CUSTEL	79.130	CLR	WHT					27907		
12	FULL-SLIM	79.130	CLR	WHT	RH(1)		GRAY	G052724-7	101097	DYWN200281D	
1	3/4-CUSTEL	79.130	CLR	WHT					27907		
12	FULL-SLIM	79.130	CLR	WHT	LH(1)		GRAY	G052724-6	101098	DYWP200281D	
1	3/4-CUSTEL	79.130	CLR	WHT					27908		

- 3A** Pull Inventory quantities from existing **WIP** Racks or from **Raw Material Racks** based on the Production Order Component IDs and/or Framing Sheet. **NOTE:** If the inventory already exist in the WIP Rack, pull from them. If NOT, then pull from Raw Material Racks.
- 3B** Stage materials in **Vertical racks** or on **Work Tables**.
- 3C** **SAFETY:** Be Careful in handling materials to prevent injury and material damage. Don't move a quantity that weights more than 20 lbs or what could be held easily in 2 hands, whichever quantity is less.
- 3D** **CHECK** Shape, Quantity, Lengths and Color of all material pulled. Also **CHECK** for **DAMAGES**. If damaged, see Step 5.  
**QUESTIONS?** - Please refer to Configurator Sheet or see the Framing Leader/Supervisor

**WIP STORAGE RACKS**



**RAW STORAGE RACKS**



**Vertical Staging**



**Work Table Staging**



**4A Check Frame Parts for Damage.**

If damaged;

- 4B** 1) If damaged area cannot be trimmed, place in Damage Return Pallets and note in Log,  
**4C** 2) If Usable, sort for damage trimming cuts.

**QUESTIONS?** - Please see the Framing Leader/Supervisor

**Typical Damage from Handling, Packaging or Strapping**



**Damaged Return Cart**



**Damaged Return Skid Sheet**

<u>SX10 #3 CUSTOM</u>	
3/14/2024	→ 4/12/2024
A203N R-1	= 54
A203NL2 R-1	= 91
A203B R-1	= 4
A203Bx2 R-1	= 116
A204NL2	= 61
A204Bx2	= 14

**5A Trim Damaged areas in Chop Saw FIRST**

**5B MAINTENANCE:** Lube the Saw Blade with Edge Lube before starting Cuts and after every 100 pcs.

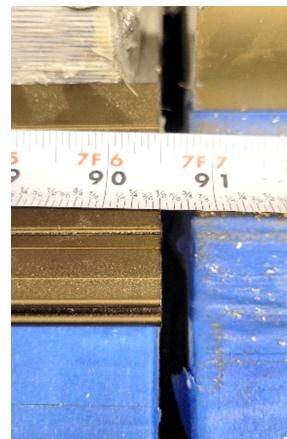
**5C DOUBLE CHECK** the Length BEFORE CUTTING, to avoid cutting too short.

**SAFETY:** Do not operate a Chop Saw unless you have been Trained and Approved by the Framing Leader/Supervisor.

**Trim Damaged End in Chop Saw**



**Check BEFORE Cutting**



**TAPMATIC Edge Lube**



**6A Use Stops, Shims, and Spacers to set correct Length based on Cut Sheet.**

**NOTE:** Spacers are located under saw bed.

Use Tape measure to confirm Length.

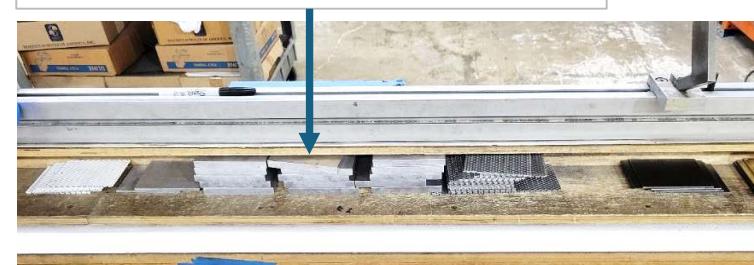
**Trim to Length in Chop Saw**



**Check Cut Length**



**Shims & Spacers under Chop Saw Bed**



**Confirm Cut Length with Framing Sheet or Production Order**

QTY	SIZE	ALUM	ACRYLIC	LEAD POST
22	FULL-SLIM	LENGTH 78.270	COLOR CLR	BLK
2	3 1/4-SLIM	78.270	CLR	BLK

**7A Cut remaining Alum to Length and Stack in WIP Wall Tube Storage Racks.**

**7B Move Lead Posts to next operation - Milling Mag Slot and Drilling of Handle holes**

Use Stickers to note Prod Order #, and place on materials, if Necessary for Production Order ID.

**7D DOUBLE CHECK COUNT**

Confirm Production Order - #

Create Sticker and place on Lead Posts

# Production Order

Production Order Number:

G032524-57

**Special Instructions:**

SO#100258 30287

