

RULE

RULE FOR FIRST MIDDLE LAST TOOL CHANGE (FMLT) SYSTEM

ISD-QA-028

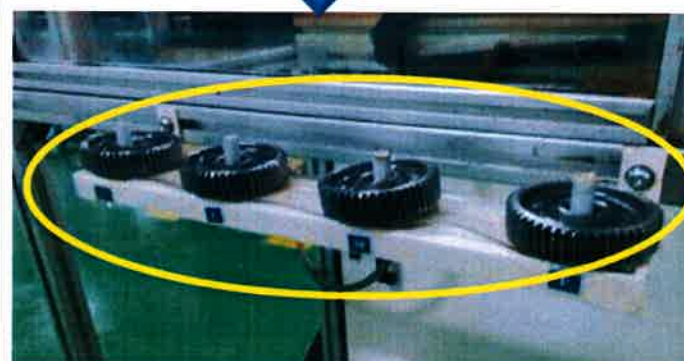
DATE : 01.08.15

Issue 01

REV 0

TIME CHART

SHIFT	FIRST	MIDDLE	LAST
FIRST SHIFT	8:55 TO 9:05 AM	12:35 TO 12:45 PM	2:30 TO 2:40 PM
SECOND SHIFT	3:50 TO 4:00 PM	6:50 TO 7:00 PM	10:30 TO 10:40 PM
THIRD SHIFT	12:45 TO 12:55 AM	2:45 TO 2:55 AM	4:15 TO 4:25 AM



INPROCESS INSPECTION

PRODUCE THE PART

INSPECT FIRST SAMPLE STARTING OF THE SHIFT AS PER TIME CHART

REWORK

NG

TAKE THE CORRECTIVE ACTION

OK

REWORK

NG

FOLLOW THE NG PART HANDLING PROCEDURE (ISD-QA-014)

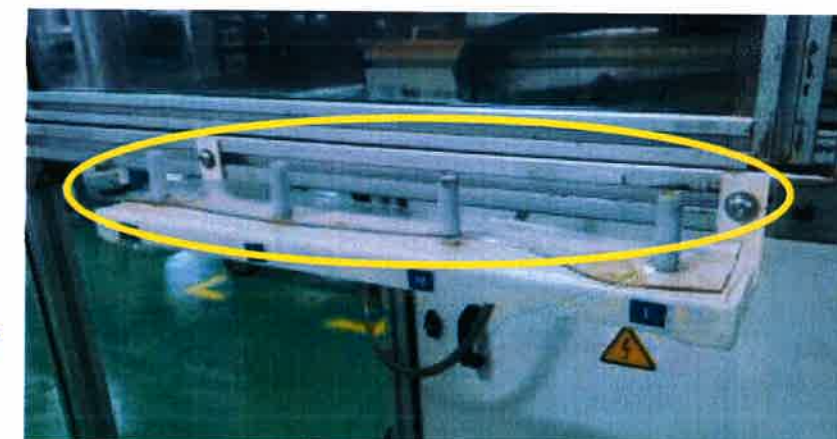
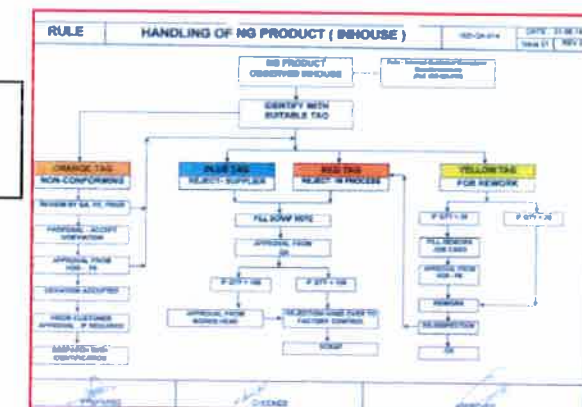
OK

RECORD THE RESULTS IN THE LOT CONTROL SHEET/ TOOL CHANGE SHEET

KEEP THE SAMPLE IN FML BRACKET

FOLLOW THE ABOVE STEPS FOR MIDDLE, LAST & AFTER TOOL CHANGE PRODUCED PARTS

END OF THE SHIFT CLEAR THE PARTS FROM FML BRACKET



PREPARED

CHECKED

APPROVED