



FMA03

Choose from drop down

Daily Verification/ Inspection Sheet

FORMAT.NO

REV.LEVEL

REV.DATE

PH/ME/002

D

01.03.2024

Document Date : 10 Nov 20

Revision Date:

01-Aug-24

DVIS Number :FMA03-DVIS-35-003

Date

Shift:

Line:

P/N:

SAMPLE SIZE:

As per the Control Plan.

FREQUENCY:

At Set-up (Shift) and as specified in the Control Plan.

Choose from drop down

P/N: (Initial)

P/N: (Ist Changeover)

P/N: (IInd Changeover)

P/N: (IIIRD Changeover)

Delphi part #

Model

Customer part #

28667720

P703

MB3Q-9H307-AC

28667721

U704

MB3Q-9H307-BA

42027893

FD

PB3Q-9H307-FD

42032060

SA

PB3Q-9H307-SA

42049149

Gnome

RB3Q-9H307-GA

NOTE:

Select from

Choose from drop down

OK's are for Attribute only . Record in numeric form for variable data.

Record quantity of parts that need to be tagged because of what you found in "ACTION TAKEN"

In case of ABNORMAL SITUATION, Process paramter issue, Error proofing issue, follow the abnomal handling procedure.

In case of process or machine maintenance is carried out - redo the verifDiation - Tick mark the type of verification done below the sub group column.

In case of start up; DG/ Model Changeover; continuous rejection follow first piece approval is required.

CHARACTERISTICS

Record Time

SAMPLE:

Sub Group 1

Sub Group 2

Sub Group 3

Sub Group 4

OP #35 - Umbrella Valve and Clip Press to Retainer

MACHINE SETTINGS

Program selection on HMI (HMI से Program select करना है)

Line pressure (4.5 - 5.5 bar) ①

O-ring conditon(UV Flow check sealing area), should not be damaged (O-ring सील की स्थिति सही होनी चाहिए)

UV Flow input Test Pressure(13+/- 2 KPa) (11-15) kPa ②

UV Vaccum Test range(-35 to -43 KPa) ③

UV Flow Value (30~40 LPM)(HMI) ④

Master Verification for LVDT (OK/NG)

Good and Bad master verification (refer EPVS)

Test Pressure for Vacumm generation (0.25 ~ 0.3 Mpa)⑤

Umbrella Valve Assembly in Retainer in UV Assy Station

Tool Alignmnet (Top & Bottom) (Tool Alignment) सही होना चाहिए

Tool Id:

Top Tool : FMA-03-35- T05 (P703/U704/SA/FD/Gnome)

Bottom Tool : FMA-03-35-T06 (P703/U704/SA/FD)

FMA-03-35-T08 (Gnome)

UV Assy Stage 1: FMA-03-35- T07 (P703/U704/SA/FD)

FMA-03-35-T09 (Gnome)

PRODUCT PARAMETERS

Retainer Part no - 42001878 (P703/U704/SA/FD)

42050758 (Gnome)

UV Clip Part No - 42000829 (P703/U704/SA/FD)

42000829 (Gnome)

Umbrella Part No - 25094588 (P703/U704/SA/FD/Gnome)

UV Clip pressing -proper locking of 2 nos snap

GENERAL

All workstations are clean (Y/N) वर्कस्टेशन साफ होना चाहिए (हाँ/ना)

All Error proofing / Error detection verification done (Y/N)

Station Operator will confirm that every bin feeded on line is free from contamination (Y/N) PTGW\_5.3\_PC\_GUR\_03

Team Leader/Operator initial

Shift Supervisor Initials

Quality Supervisor Initials

For Operators : IF any machine setting / product parameters is out of specification , please follow the reaction plan.

CONCERN IDENTIFIED

CAUSE IF KNOWN

ACTION TAKEN

Change Record:

Revision Level

Rev. Date

Person Initiating Change

Description of Change

CONCERN & ACTION TAKEN

First Time Approval (ABNORMAL)

Manufacturing

QUALITY

Prepared By :

Approved By :



**Error Proofing List and Verification Sheet -**  
**FMA-03-EPVS-003: P703(28667720); U704(28667721); FD(42027893); SA(42032060); Gnome(42049149)**

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01-Aug-24

**Masterlist of Error Prevention**

EP #	MODEL	WORK STATION	PURPOSE OF ERROR PROOFING	VERIFICATION METHOD	Record	EP Master	STATUS / PLAN	Alternative Method	CURRENT STATUS( As per Running Model)		
									A	B	C
EP # 01	P703 U704 FD SA/ Gnome	Umbrella Valve and Clip Press to Retainer	Ensure right model selection in respective of Model selection	Start the machine by selecting other model then running model on HMI.Machine should not start	EPVS	N/A	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 02			Ensure Umbrella valve presence sensor working on umbrella valve press to retainer operation	Keep the retainer on station without umbrella valve and press manually , vacuum will not start on Top tool.		FMA-03-35-M01(T6) FMA-03-35-M09(Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 03			Ensure Umbrella valve and retainer Assy complete stroke confirmation sensor working on UV press to retainer operation	Keep the retainer on station with umbrella valve and press manually , vacuum will start on Top tool.		N/A	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 04			Ensure UV Clip presence sensor working	Load the master of UV Clip in top tool and check the master Judgement on machine		FMA-03-35-M02 (T6/Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 05			Ensure UV Clip fully snap locked with 2 no's of retainer snap	Load the Snap NG master, Machine cycle should show NG cycle		FMA-03-35-M03 (T6) FMA-03-35-M10 (Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 06			Ensure Umbrella valve Flow Test	Start the machine with master and judgement will given by machine		FMA-03-35-M04 (T6) FMA-03-35-M11 (Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 07			Ensure umbrella valve vacuum test	Start the machine with master and judgement will given by machine		FMA-03-35-M05 (T6) FMA-03-35-M12 (Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 08			Verify machine LVDT mounting	Load / LVDT master		FMA-03-35-M06 (T6/Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 09			Ensure top & bottom tool alignment	Load alignment master in bottom tool, slide & than lift by hand, Machine show OK if alignment is OK		FMA-03-35-M07 (T6/Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG
EP # 10			Ensure complete cycle ok working	Load Ok master in machine lower nest		FMA-03-35-M08 (T6) FMA-03-35-M13(Gnome)	Working	100% Inspection By Operator	Select by drop down list OK NG	Select by drop down list OK NG	Select by drop down list OK NG

Program selection on HMI (HMI से Program select करना है)
<b>Line pressure (4.5 - 5.5 bar)</b>
O-ring condition(UV Flow check sealing area), should not be damaged (O-ring सील की स्थिति सही होनी चाहिए)
UV Flow input Test Pressure(13+/- 2 KPa) (11-15) kPa
UV Vacuum Test range(-35 to -43 KPa)
UV Flow Value (30~40 LPM)(HMI)
Master Verification for <b>LVDT (OK/NG)</b>
Good and Bad master verification ( <b>refer EPVS</b> )
Test Pressure for Vacuum generation (0.25 ~ 0.3 Mpa)
Umbrella Valve Assembly in Retainer in UV Assy Station
Tool Alignment (Top & Bottom) (Tool Alignment) सही होना चाहिए
Tool Id: Top Tool ID : FMA-03-35- T05 (P703/U704/SA/FD/Gnome) Bottom Tool ID: FMA-03-35-T06 (P703/U704/SA/FD) FMA-03-35-T08 (Gnome) UV Assy Stage 1 ID: FMA-03-35- T07 (P703/U704/SA/FD) FMA-03-35-T09 (Gnome)
Retainer Part no - 42001878 (P703/U704/SA/FD) 42050758 (Gnome)
UV Clip Part No - 42000829 (P703/U704/SA/FD) 42000829 (Gnome)
Umbrella Part No - 25094588 (P703/U704/SA/FD/Gnome)
Retainer ID lubrication
UV Clip pressing -proper locking of 2 nos snap
All workstations are clean (Y/N) वर्कस्टेशन साफ होना चाहिए (हाँ/ना)
All Error proofing / Error detection verification done (Y/N)
Station Operator will confirm that every bin feeded on line is free from contamination (Y/N) PTGW_5.3_PC_GUR_03
<b>Team Leader/Operator initial</b>
<b>Shift Supervisor Initials</b>
<b>Quality Supervisor Initials</b>

CONCERN IDENTIFIED
CAUSE IF KNOWN
ACTION TAKEN

	CHARACTERISTICS	(Regular pro
	Record Time	
	SAMPLE:	1
Drop down list for model number	P703 U704 FD SA Gnome	P703
Data enter with keyboard		5.12
Drop down list for model number	OK NG	OK
Data enter with keyboard		14
Data enter with keyboard		-37
Data enter with keyboard		34
Drop down list	OK NG	OK
Drop down list	OK NG	OK
Data enter with keyboard		0.28
Drop down list	OK NG	OK
Drop down list	OK NG	OK
Drop down list	FMA-03-35- T05 (P703/U704/SA/FD/Gnome)	FMA-03-35- T05
Drop down list	FMA-03-35-T06 (P703/U704/SA/FD) FMA-03-35-T08 (Gnome)	FMA-03-35-T06
Drop down list	FMA-03-35- T07 (P703/U704/SA/FD) FMA-03-35-T09 (Gnome)	FMA-03-35- T07
Drop down list	42001878 (P703/U704/SA/FD) 42050758 (Gnome)	42001878
Drop down list	42000829 (P703/U704/SA/FD) 42000829 (Gnome)	42000829
Drop down list	25094588 (P703/U704/SA/FD/Gnome)	25094588
Drop down list	OK NG	OK
Drop down list	OK NG	OK
Drop down list	Yes NO	Yes
Drop down list	Yes NO	Yes
Drop down list	Yes NO	Yes
		Drop down list for Name
		Drop down list for Name
		Drop down list for Name


Sub Group 1				Sub Group 2					
cess Data) /(Post Maintenance data)				(Regular process Data) /(Post Maintenance data)					(Regula
2	3	4	5	1	2	3	4	5	1

-36	-37	-36	-40	-37	-39	-36	-37	-36	-40
36	35	34	39	36	35	34	39	36	39

[illegible][illegible][illegible]

	Drop down list for Name	
	Drop down list for Name	
	Drop down list for Name	
<b>CONCERN &amp; ACTION TAKEN</b>		

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Data enter with keyboard

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Data enter with keyboard

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Data enter with keyboard

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	<b>Manufacturing</b>	<b>Quality</b>
	Drop down list for Name	Drop down list for Name