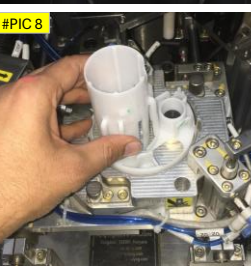
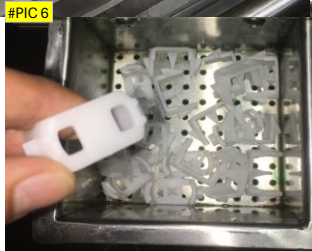
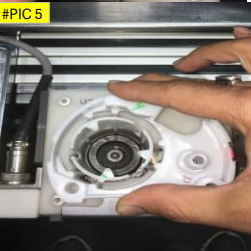
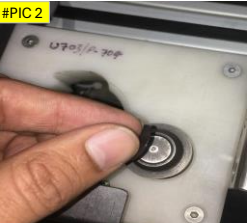
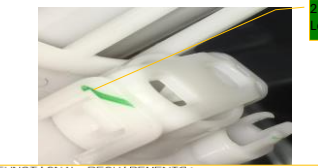


		Machine Document										Format No.	PHME001								
Model :		P703 (28667720)Rev009; U704(28667721)Rev006; FD(42027893)Rev006; SA(42032060)Rev003; Gnome 42049149 (Rev001)					WI No		FMA03-MD-35-003			Operator Skill Level Required : 3		Document Dated : 18 Sept. 17		Revision Date:		20.06.2024			
Machine name:		Umbrella valve and Clip Press to retainer					Operation no.		35			A: Alert Supervisor for Possible Machine Alignment B: Follow super visor instruction for proper handling								SAFETY CONSIDERATION	
Product Parameters																					
S. No	Product Characteristics (इंग्लिश में दिया गया है)		K P C	Product Spec / Tolerance (पार्ट के माप का विशेष विवरण)		Measuring mode (पार्ट को चेक कैसे करें)		Sample size (कितने पार्ट चेक करने हैं)		Frequency (कितनी देर में चेक करना है)		Resp (कौन चेक करेगा)		Control method (प्रोसेस पर नियंत्रण रखने का तरीका)		Reaction plan (प्रोसेस गलत होने पर क्या करें)					
1	Correct UV Clip Part Number			As per Model running (refer master Sample)		visual		Once		Start Of Shift/Every Changover/		Operator		DVIS(FMA03-DVIS-35-05)		If Non-conforming part is found, place it in reject cotainer and notify team leaderr					
2	Correct Umbrella Valve Part Number			As per Model running (refer master Sample)		visual		Once		Start Of Shift/Every Changover/		Operator		DVIS(FMA03-DVIS-35-05)							
3	Correct Retainer Part Number			As per Model running (refer master Sample)		visual		Once		Start Of Shift/Every Changover/		Operator		DVIS(FMA03-DVIS-35-05)							
4	Umbrella Valve Presence Verification			UV Must seal against retainer		Visual / Flow & Vaccum Inspection		Once/100%		Start Of Shift/Every Changover/Every 2 hour.		Operator/Auto Controlled		DVIS(FMA03-DVIS-35-05) / PLC program Interlock		If machine does not detect process notify team leder					
5	Snap lock Verification			Proper Locking of UV Clip with retainer snap window		Laser beam sensor		Once/100%		Start Of Shift/Every Changover		Operator/Auto Controlled		DVIS(FMA03-DVIS-35-05)/EPVS/Machine PLC program Interlock		If sensor does not detect process notify team leder					
Process/Set up Parameters																					
S. No	Process Characteristics (प्रोसेस में चेक करना है)		K C C	Process Spec / Tolerance (प्रोसेस के पैरामीटर का विशेष विवरण)		Measuring mode (प्रोसेस को चेक कैसे करें)		Sample size (प्रोसेस में कितने पार्ट चेक करने हैं)		Frequency (कितनी देर में चेक करना है)		Resp (कौन चेक करेगा)		Control method (प्रोसेस पर नियंत्रण रखने का तरीका)		Reaction plan (प्रोसेस गलत होने पर क्या करें)					
1	Line Pressure			4.5 - 5.5 bar		Pressure Switch		Once		Start Of Shift/Every Changover		Operator		DVIS		If parameter is out of specification, do not use equipment and notify team leader					
2	UV Vacuum Test range			-35 to -43 Kpa		Pressure Switch		100%		Continuous		Auto Controlled		DVIS/ Machine PLC program controlled							
3	UV Flow input Test Pressure			13±2 Kpa		pressure Switch		Once/Cont.		Every Changeover/Start of Shift/Cont.		Operator/Auto Controlled		DVIS/ Machine PLC program controlled							
4	UV Flow Test Value			30 to 40 LPM		Flow Meter		5 pcs/100%		Every Changeover/Start of Shift/Cont.		Operator/Auto Controlled		DVIS/ Machine PLC program controlled		If machine does not ask for master cycle, inform to team leader					
5	Master Part Verification			NOK1. Verifier rejected OK1. Verifier Accepted		Master Cycle		Once		Every Changeover/Start Of Shift		Auto-Controlled		Machine logic tied with changeover							
6	Bin Cleanliness			Should be free from dust and contamination		Visual		Once		Every Changeover of Bin		Operator		Part feeding WI PTGW_5.3_PC_GUR_03					Infrom supervisor and press alarm button		
7	TPM checksheet Verification			As per TPM check-sheet		Visual		Once		Start Of Shift/Every Changover		Line Leader / Supervisor		TPM check sheet PH/MAINT/FMA-03/018		If any abnormality, inform to supervisor					
JOB ELEMENT SHEET																					
Work sequence		Safety for operator					Quality checks			Critical process for product			Error proofing								
SYM	No.	Major process step						key points				Reason		EP Applicable							
○	1	Pick up Umbrella Valve from SS tray as shown in pic#1 Umbrella Valve को SS tray से उठाये						Correct Umbrella Valve (Part Number As Per Model Running)				Correct Umbrella valve		Visual Aid							
○	2	Load Umbrella Valve into the stage 1 nest Pin as shown in pic#2 Umbrella Valve को stage 1 nest Pin में load करें						Correct Orientation				Proper Alignment		Visual Aid							
○	3	Pick up retainer from bin as shown in pic#3 retainer को bin से उठाये						Correct Retainer (Part Number As Per Model Running)				Component Matches Master Sample		Visual Aid							
○ ▼	4	Load Retainer over umbrella Valve in fixture as shown in pic#4 Retainer को umbrella valve के ऊपर से fixture में लोड करें						Correct Orientation				Proper Alignment		Confirmation Sensor							
○ ▼	5	Push Retainer from top side by hands to assemble umbrella valve in to Retainer as shown in pic#5 Umbrella valve को असेबल करने के लिए Retainer को ऊपर की तरफ से दबाए						1. No damage to Umbrella Valve 2. Umbrella valve stem has to be fully inserted				Correct Assembly		Fixture Design							
○	6	Get UV Clip from SS tray as shown in pic#6 SS Tray से UV Clip उठाये						Correct UV Clip (Part Number As Per Model Running)				Correct UV Clip		Visual Aid							
○ ▼	7	Insert UV Clip into the Top Tool as shown in pic#7 UV Clip को Top Tool में लगाएं						Correct Orientation				Proper Alignment		Visual Aid							
○ ▼	8	Unload Retainer from nest 1 and load on nest 2 for clip insertion as shown in pic#7 Retainer को Nest 1 से निकालकर nest 2 में लगाएं						Correct Orientation				Proper Alignment									
○ + ▼ ▲	9	Activate m/c cycle: Fixture slide in forward direction thenTop Tool press clip into Retainer Pic#8 & then Umbrella Valve test start. M/c cycle activate करें : fixture forward direction में slide करेगा Top tool UV Clip को Retainer में press करेगा और उसके बाद Umbrella Valve टेस्ट स्टार्ट होगा						Umbrella valve presence  UV Clip Snap Lock				Umbrella Valve working  Tabs Fully engaged		Flow and Vacuum Inspection  Laser beam sensor							
○ + ▼	10	Automatic :Slide Return to home condition for unloading . Automatic :slider वापस आएगा, part unloading के लिए						No broken/damaged tabs UV Clip snap fully locked the Retainer				Tabs Fully engaged		Visual Aid							
○ + ▼	11	Unload sub assy.from nest & do visual inspection sub assy. को unload करें और उसका visual inspection करें						No damaged/dropped parts				Good part verification									
○ + ▼	12	Scrap Rejected Part. Load into Properly Identified scrap Bin. as shown in pic#10 rejected part को reject chute में डालें						Proper Handling of Part				Reject Part Verification		Reject chute interlocked sensor							
○	13	Move acceptable part to WIP. As shown in pic#11 acceptable part को WIP में रखें						No Damage/Drop Parts				Drop part policy		WIP Design							
<div>FUNCTIONAL REQUIREMENTS: [INSERT] UMBRELLA VALVE ASM FULLY INTO RETAINER. VALVE MUST SEAL AGAINST RETAINER. QUALITY INFORMATION: NO VISUAL DAMAGE ON FEATURES USED AS SUPPORT FOR ASSEMBLY. [N-2] LOCKING FEATURES MUST FULLY ENGAGE INTO MATING COUNTERPART</div> <div>Unplanned Interruption Action: If any child part or sub assy fallen down on floor or there is electricity , or any other unplanned break down in between part processing. Take out part from machine &amp; put it into rejection box.</div>																					
<div>Prepared By : Sandeep Yadav</div> <div>Approved By : Deepak Verma</div>																					



### VISUAL AIDS



2 no Snap  
lock



only 1 side  
lock

FUNCTIONAL REQUIREMENTS:  
[INSERT UMBRELLA VALVE ASM FULLY INTO RETAINER,  
VALVE MUST SEAL AGAINST RETAINER.  
QUALITY INFORMATION:  
NO VISUAL DAMAGE ON FEATURES USED AS SUPPORT FOR  
ASSEMBLY.  
[N-2] LOCKING FEATURES MUST FULLY ENGAGE INTO MATING  
COUNTERPART

Unplanned Interruption Action: If any child part or sub assy fallen down on floor or there is electricity , or any other unplanned break  
down in between part processing. Take out part from machine & put it into rejection box.