

<div></div>			Machine Document										Format No. Rev. Level Rev. Date		PHME001 D 01.03.2024						
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				<div> FUNCTIONAL R/C SAFETY COMPLIANCE</div>			
JOB ELEMENT SHEET																			<div><div>#PIC 1</div></div> <div><div>#PIC 2</div></div> <div><div>#PIC 3</div></div> <div><div>#PIC 4</div></div> <div><div>#PIC 5</div></div> <div><div>#PIC 6</div></div> <div><div>#PIC 7</div></div> <div><div>#PIC 8</div></div> <div><div>#PIC 9</div></div> <div><div>#PIC 9</div></div> <div><div>#PIC 10&amp;11</div></div> <div><div>Pic 12</div></div> <div><div>Pic 13</div></div>		
Work sequence		<div></div>		Safety for operator		<div></div>		Quality checks				Critical process for product		<div></div>				Error proofing			
SYM	No.	Major process step					key points					Reason		EP Applicable							
<div></div>	1	Pick up Umbrella Valve from SS tray <b>as shown in pic#1</b> <b>Umbrella Valve को SS tray से उठाये</b>					Correct Umbrella Valve (Part Number As Per Model Running)					Correct Umbrella valve		Visual Aid							
<div></div>	2	Load Umbrella Valve into the stage 1 nest Pin <b>as shown in pic#2</b> <b>Umbrella Valve को stage 1 nest Pin में load करें</b>					Correct Orientation					Proper Alignment		Visual Aid							
<div></div>	3	Pick up retainer from bin <b>as shown in pic#3</b> <b>retainer को bin से उठाये</b>					Correct Retainer (Part Number As Per Model Running)					Component Matches Master Sample		Visual Aid							
<div></div>	4	Load Retainer over umbrella Valve in fixture <b>as shown in pic#4</b> <b>Retainer को umbrella valve के ऊपर से fixture में लोड करें</b>					Correct Orientation					Proper Alignment		Confirmation Sensor							
<div></div>	5	Push Retainer from top side by hands to assemble umbrella valve in to Retainer <b>as shown in pic#5</b> <b>Umbrella valve को असेंबल करने के लिए Retainer को ऊपर की तरफ से दबाए</b>					1. No damage to Umbrella Valve 2. Umbrella valve stem has to be fully inserted					Correct Assembly		Fixture Design							
<div></div>	6	Get UV Clip from SS tray <b>as shown in pic#6</b> <b>SS Tray से UV Clip उठाये</b>					Correct UV Clip (Part Number As Per Model Running)					Correct UV Clip		Visual Aid							
<div></div>	7	Insert UV Clip into the Top Tool <b>as shown in pic#7</b> <b>UV Clip को Top Tool में लगाएं</b>					Correct Orientation					Proper Alignment		Visual Aid							
<div></div>	8	Unload Retainer from nest 1 and load on nest 2 for clip insertion <b>as shown in pic#7</b> <b>Retainer को Nest 1 से निकालकर nest 2 में लगाएं</b>					Correct Orientation					Proper Alignment									
<div></div>	9	Activate m/c cycle: Fixture slide in forward direction thenTop Tool press clip into Retainer <b>Pic#8</b> & then Umbrella Valve test start. <b>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</b>					Umbrella valve presence					Umbrella Valve working		Flow and Vacuum							
							UV Clip Snap Lock					Tabs Fully engaged		Laser beam sens							
<div></div>	10	<b>Automatic</b> :Slide Return to home condition for unloading . <b>Automatic</b> :slider वापस आएगा, part unloading के लिए					No broken/damaged tabs UV Clip snap fully locked the Retainer					Tabs Fully engaged		Visual Aid							
<div></div>	11	Unload sub assy.from nest & do visual inspection <b>sub assy. को unload करें और उसका visual inspection करें</b>					No damaged/dropped parts					Good part verification									
<div></div>	12	Scrap Rejected Part. Load into Properly Identified scrap Bin. <b>as shown in pic#10</b> <b>rejected part को reject chute में डालें</b>					Proper Handling of Part					Reject Part Verification		Reject chute interlocked sensor							
<div></div>	13	<b>Move acceptable part to WIP. As shown in pic#11</b> <b>acceptable part को WIP में रखें</b>					No Damage/Drop Parts					Drop part policy		WIP Design							
Prepared By : Sandeep Yadav																			Approved By : Deepak Verma		

