Machine Document

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	Document Dated : 18 Sept. 17	Revision Date:20.06.2024	◇ FTP/FUNCTION KPC ◇ SAFETY/COMPLIANCE KPC
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			A: Alert Supervisor for Possible Machine Alignment B: Follow super visor instruction for proper handling

Operatior Skill Level Required : 3

Product Parameters

S. No	Product Characteristics (ड्राइंग में दिया गया है)	K P C	Product Spec./ Tolerance (पार्ट के माप का विशेष विवरण)	Measuring mode (पार्ट को चैक कैसे करें)	Sample size (कितने पार्ट चैक करने है)	Frequency (कितनी देर में चैक करना है)	Resp (कौन चैक 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)	
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)	If Non-conforming part is found, place it in reject cotainer and notify team leaderr
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 चैक करना है)	K C C	Process Spec./ Tolerance (प्रोसेस के पैरामीटर का विशेष विवरण)	Measuring mode (प्रोसेस को चैक कैसे करें)	Sample size (प्रोसेस में कितने पार्ट चैक करने है)	Frequency (कितनी देर में चैक करना है)	Resp (कौन चैक 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	
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	If machine does not ask for master cycle, inform to team leader
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 Changeover	Line Leader / Supervisor	TPM check sheet PH/MAINT/FMA-03/018	If any abnormality, inform to supervisor

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