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|  |  | Machine Document |  |  |   |   |   | Format No.   | PHME/001  |   |
|   |  |                  |  |  |   |   |   | Rev. Level   | D   |   |
|   |  |                  |  |  |   |   |   | Rev. Date  | 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  | Document Dated : 18 Sept. 17                                 | Revision Date:20.06.2024  |  FFFFUNCTION KPC<br>SAFETY/COMPLIAN-<br>CE KPC |
| Machine name:   | Umbrella valve and Clip Press to retainer  |                  |  |  | Operation no.   | 35  | A: Alert Supervisor for Possible Machine Alignment<br>B: Follow super visor instruction for proper handling |  | A: Alert Supervisor for Possible Machine Alignment<br>B: Follow super visor instruction for proper handling |   |
| Product Parameters  |  |                  |  |  |   |   |   |  |   | Operator Skill Level<br>Required : 3  |
| S. No   | Product Characteristics<br>(इआईंग में दिया गया है)   | K<br>P<br>C      | Product Spec./ Tolerance<br>(पार्ट के माप का विशेष विवरण)        | Measuring mode<br>(पार्ट को चेक कैसे करें)   | Sample size<br>(कितने पार्ट चेक करने हैं )              | Frequency<br>(कितनी देर में चेक करना है)        | Resp<br>(कौन चेक करेगा)   | Control method<br>(प्रोसेस पर नियंत्रण रखने का तरीका)        | Reaction plan<br>(प्रोसेस गलत होने पर क्या करें)  |   |
| 1   | Correct UV Clip Part Number  |                  | As per Model running<br>(refer master Sample)                    | visual                                       | Once  | Start Of Shift/Every<br>Changover/              | Operator  | DVIS(FMA03-DVIS-35-05)                                       | If Non-conforming part is found,<br>place it in reject cotainer and notify<br>team leaderr                  |   |
| 2   | Correct Umbrella Valve Part Number   |                  | As per Model running<br>(refer master Sample)                    | visual                                       | Once  | Start Of Shift/Every<br>Changover/              | Operator  | DVIS(FMA03-DVIS-35-05)                                       |   |   |
| 3   | Correct Retainer Part Number   |                  | As per Model running<br>(refer master Sample)                    | visual                                       | Once  | Start Of Shift/Every<br>Changover/              | Operator  | DVIS(FMA03-DVIS-35-05)                                       |   |   |
| 4   | Umbrella Valve Presence Verification   |                  | UV Must seal against retainer                                    | Visual / Flow & Vaccum<br>Inspection         | Once/100%   | Start Of Shift/Every<br>Changover/Every 2 hour. | Operator/Auto<br>Controlled   | DVIS(FMA03-DVIS-35-05) / PLC program<br>Interlock            | If machine does not detect process<br>notify team leder   |   |
| 5   | Snap lock Verification   |                  | Proper Locking of UV Clip with<br>retainer snap window           | Laser beam sensor                            | Once/100%   | Start Of Shift/Every Changover                  | Operator/Auto<br>Controlled   | DVIS(FMA03-DVIS-35-05)/EPVS/Machine PLC<br>program Interlock | If sensor does not detect process<br>notify team leder  |   |
| Process/Set up Parameters   |  |                  |  |  |   |   |   |  |   |   |
| S. No   | Process Characteristics<br>(प्रोसेस में चेक करना है)   | K<br>C<br>C      | Process Spec./ Tolerance<br>(प्रोसेस के पैरामीटर का विशेष विवरण) | Measuring mode<br>(प्रोसेस को चेक कैसे करें) | Sample size<br>(प्रोसेस में कितने<br>पार्ट चेक करने है) | Frequency<br>(कितनी देर में चेक करना है)        | Resp<br>(कौन चेक करेगा)   | Control method<br>(प्रोसेस पर नियंत्रण रखने का तरीका)        | Reaction plan<br>(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,<br>do not use equipment and notify<br>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<br>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<br>Shift/Cont.        | Operator/Auto Controlled  | DVIS/ Machine PLC program controlled                         |   |   |
| 5   | Master Part Verification   |                  | NOK1. Verifier rejected<br>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<br>cycle, inform to team leader  |   |
| 6   | Bin Cleanliness  |                  | Should be free from dust and<br>contamination                    | Visual                                       | Once  | Every Changeover of Bin                         | Operator  | Part feeding WI<br>PTGW_5.3_PC_GUR_03                        | Infrom supervisor and press alarm<br>button   |   |
| 7   | TPM checksheet Verification  |                  | As per TPM check-sheet   | Visual                                       | Once  | Start Of Shift/Every<br>Changeover              | Line Leader /<br>Supervisor   | TPM check sheet<br>PH/MAINT/FMA-03/018                       | If any abnormality, inform to<br>supervisor   |   |
|   |  |                  |  |  |   |   |   |  |   |   |
| Prepared By : Sandeep Yadav   |  |                  |  |  | Approved By : Sandeep Yadav                             |   |   |  |   |   |