| → PHINIA  |   |  |  | Machine Document   |   |   | Format No.  Rev. Level  Pay Date  | PH/ME/001<br>D<br>01.03.2024  |
|---|---|--|--|--|---|---|---|---|
| Model : P703 (28667720)Rev009; U704(28667721)Rev006; FD(42027893)Rev006; SA(42032060)Rev003; Gnome 42049149 (Rev001)  Machine name: Umbrella valve and Clip Press to retainer |   |  | WI No  | FMA03-MD-35-003  | Operator Skill Level  | Document Dated : 18 Sept. 17  |   | FIT/FUNCTION KPC  |
|   |   |  | Operation no.  |  |   |   |   | for Possible Machine Alignment sor instruction for proper handling  |
| ,   |   |  | P  | Product Parameters   | ,   |   | Operatior Skill Level<br>Required : 3   |   |
| Product Characteristics<br>(ड्राइंग में दिया गया है)<br>C   | Product Spec./ Tolerance<br>(पार्ट के माप का विशेष विवरण)   | Measuring mode<br>(पार्ट को चैक कैसे करें)   | Sample size<br>(कितने पार्ट चैक<br>करने है )   | Frequency<br>(कितनी देर में चैक करना है)   | Resp<br>(कौन चैक करेगा)   | Control m<br>(प्रोसेस पर नियंत्रण र   | ethod<br>खने का तरीका)  | Reaction plan<br>(प्रोसेस गलत होने पर क्या करें)  |
| Correct UV Clip Part<br>Number  | As per Model running (refer master Sample)  | visual   | Once   | Start Of Shift/Every<br>Changover/   | Operator  | DVIS(FMA03-DVIS-35-05)  DVIS(FMA03-DVIS-35-05)  |   | If Non-conforming part is found, place it in reject cotainer and notify team leaderr  |
| Correct Umbrella Valve Part<br>Number   | As per Model running (refer master Sample)  | visual   | Once   | Start Of Shift/Every<br>Changover/   | Operator  |   |   |   |
| Correct Retainer Part<br>Number   | As per Model running (refer master Sample)  | visual   | Once   | Start Of Shift/Every<br>Changover/   | Operator  | DVIS(FMA03-DVIS-35-05)  |   |   |
| Umbrella Valve Presence<br>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 notify team leder  |
| Snap lock Verification  | Proper Locking of UV Clip with 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 program Interlock   |   | If sensor does not detect process notify team leder   |
|   |   |  | Proc   | ess/Set up Parameters  | 1   |   |   |   |
| Process Characteristics (प्रोसेस में चैक करना है)   | Process Spec./ Tolerance<br>(प्रोसेस के पैरामीटर का विशेष विवरण)  | Measuring mode<br>(प्रोसेस को चैक कैसे करें)   | Sample size<br>(प्रोसेस में कितने<br>पार्ट चैक करने हैं)   | Frequency<br>(कितनी देर में चैक करना है)   | Resp<br>(कौन चैक करेगा)   | Control method<br>(प्रोसेस पर नियंत्रण रखने का तरीका)   |   | Reaction plan<br>(प्रोसेस गलत होने पर क्या करें)  |
| 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   |
| UV Vacuum Test range  | -35 to '-43 Kpa   | Pressure Switch  | 100%   | Continuous   | Auto Controlled   | DVIS/ Machine PLC program controlled  |   |   |
| 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  |   |   |
| 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  |   |   |
| 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   |
| Bin Cleanliness   | Should be free from dust and contamination  | Visual   | Once   | Every Changeover of Bin  | Operator  | Part feeding WI<br>PTGW_5.3_PC_GUR_03   |   | Infrom supervisor and press alarm button  |
| 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 supervisor  |
|   | P703 (28667720)Rev00 SA(42032060)Rev003; e name:  Umbrella valve and Claracteristics (ड्राइंग में दिया गया है)  Correct UV Clip Part Number  Correct Umbrella Valve Part Number  Umbrella Valve Presence Verification  Process Characteristics (प्रोसेस में चैक करना है)  Line Pressure  UV Vacuum Test range  UV Flow input Test Pressure  UV Flow Test Value  Master Part Verification  Bin Cleanliness | P703 (28667720)Rev009; U704(28667721)Rev006; FD(420276 SA(42032060)Rev003; Gnome 42049149 (Rev001) e name: Umbrella valve and Clip Press to retainer  Product Characteristics (ड्राइंग में दिया गया है) Correct UV Clip Part (refer master Sample) Correct Umbrella Valve Part (refer master Sample) Correct Retainer Part (refer master Sample) Correct Retainer Part (refer master Sample) Umbrella Valve Presence (पाटें के माप का विशेष विवरण) Umbrella Valve Presence (पाटें के माप का विशेष विवरण) UV Must seal against retainer  Proper Locking of UV Clip with retainer snap window  Process Characteristics (प्रोसेस में चैक करना है) Line Pressure UV Vacuum Test range UV Vacuum Test range UV Flow input Test Pressure UV Flow Test Value NOK1. Verifier rejected OK1. Verifier Accepted  Bin Cleanliness Should be free from dust and contamination  TPM checksheet Verification  TPM checksheet Verification | P703 (28667720)Rev009; U704(28667721)Rev006; FD(42027893)Rev006; SA(42032060)Rev003; Gnome 42049149 (Rev001)  a name: Umbrella valve and Clip Press to retainer  Product Characteristics (इहिंग में दिया गया है) Correct UV Clip Part Number As per Model running (refer master Sample) Correct Umbrella Valve Part Number As per Model running (refer master Sample) Correct Retainer Part Number UV Must seal against retainer UV Must seal against retainer Visual / Flow & Vaccum Inspection  Snap lock Verification Proper Locking of UV Clip with retainer snap window  Process Characteristics (प्रोसेस के परामीटर का विशेष विवरण) Line Pressure  4.5 - 5.5 bar Pressure Switch  UV Vacuum Test range 13±2 Kpa Pressure Switch  Waster Part Verification NOK1. Verifier rejected OK1. Verifier Accepted Bin Cleanliness Should be free from dust and contamination Visual Visual  Measuring mode (प्रोसेस के परामीटर का विशेष विवरण) Flow Meter  Master Part Verification  NOK1. Verifier rejected OK1. Verifier Accepted  Nokater Part Verification  Visual  Visual  Master Cycle Visual  Visual  Master Cycle Visual  Visual  Visual  Master Cycle Visual  Visual | P703 (28667720)Rev009; U704(28667721)Rev006; FD(42027893)Rev006; Wil No SA(4202060)Rev003; Gnome 42049149 (Rev001)  I umbrella valve and Clip Press to retainer  Product Characteristics (कृष्ट पार्ट के माप का विशेष विवरण) (पार्ट के माप के किये किये किये किये किये किये किये क | P703 (28667720) Rev009; U704(28667721)Rev006; FD(42027893)Rev006; SA(42032060)Rev003; Gnome 42049149 (Rev001)  D name: Umbrella valve and Clip Press to retainer  Operation no.  35  Product Characteristics (जूमिन दिया गया है)  Correct UV Clip Part Number  Correct Umbrella Valve Part (refer master Sample)  Correct Retainer Part Number  Correct Retainer Part (refer master Sample)  Umbrella Valve Presence  UV Must seal against retainer  Verification  Proper Locking of UV Clip with retainer snay window  Process/Set up Parameters  UV Wacuum Test range  4.5 - 5.5 bar  Pressure Switch  Once  Start Of Shift/Every Changover/  Uvacuum Test range  335 to '-43 Kpa  Pressure Switch  Once  Once/Cont.  Shift/Cont.  Wi No  Process/Set up Parameters  Once Start Of Shift/Every Changover/Start of Shift/Cont.  Assert Parameters  Process/Set up Parameters  Process/Set up Parameters  Process/Set up Parameters  Sample size  Quiter H date and a date and a date and a date and a date a da | P701 (2867726) Rev003, Gnome 42043149 (Rev001)  Umbrella valve and Clip Press to retainer  Product Parameters  Product Characteristics (वार में दिवा गया है) C (वार के माण के किया हो) C (वार के किया हो) C ( | Product Parameters   Produc | Product Characteristics   Sept 20 (1997   1998   1999 |

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