

		Machine Document										Format No. PHME/001															
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															
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 असेंबल 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 then Top 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				Umbrella Valve working		Flow and Vacuum													
								UV Clip Snap Lock				Tabs Fully engaged		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. 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 & put it into rejection box.</div>																											
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