

<div><div><div></div><div>MEI</div></div></div>																				Date :			
																				Shift : I / II / III			
Part No: 3235E3905 / C - 23.05.2023				Part Name: CASE - DIFF. FIN						Characteristics: Distance								Spec: 112.84 / 113.16					
Operation No/Name: 20 / OD Turning				Machine Description/Code: ACE -5 / ACE -5						Measuring Equipment: Special Gauge (variable)								Least Count : 0.001 mm				EU5	
All Dimensions are in mm																							
	113.176																						
USL	113.160																						
	113.144																						
	113.128																						
	113.112																						
	113.096																						
	113.080																						
	113.064																						
	113.048																						
	113.032																						
	113.016																						
	MEAN	113.000																					
	112.984																						
	112.968																						
	112.952																						
	112.936																						
	112.920																						
	112.904																						
	112.888																						
	112.872																						
	112.856																						
	LSL	112.840																					
	112.824																						
Time and shift	I	6:30	7:00	7:30	8:00		8:30	9:00	9:30	10:00	10:30	11:00	11:30	12:00	12:30	1:00		1:30	2:00	2:30	3:00		
	II	3:00	3:30	4:00	4:30		5:00	5:30	6:00	6:30	7:00	7:30	8:00	8:30	9:00	9:30		10:00	10:30	11:00	11:30		
	III	11:30	12:00	12:30	1:00	QA	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	QA	6:30					
PROCESS LOG CODE	CODE	DETAIL				CODE	DETAIL					CODE	DETAIL					CODE	DETAIL				
	A	TOOL CHANGE / INSERT CHANGE				D	POWER FAILURE					G	HARD MATERIAL					J	IDLE				
	B	TOOL ADJUSTMENT				E	MACHINE BREAK DOWN					H	WAITING FOR MATERIAL					K	NO PLAN				
	C	MACHINE VARIATION				F	SPEED / FEED CHANGE					I	MANDREL PROBLEM					L	NO MAN POWER				
Rules for use of Process Monitoring Chart																							
Start-up & Setting		Five Consecutive Component Green					G	G	G	G	G	Stop and Correct the Production	Two Consecutive Pieces are Yellow					Y	Y				
Continue the Production		Two Consecutive Pieces are Green					G	G					If two consecutive Pieces, At least one Red					Y	R	G	R		
		Two Consecutive Pieces Green & Yellow or Yellow &Green					G	Y	Y	G				Stop and Correct the Production					First Piece itself Red		R	or	O

Produced Qty:	Rejection Qty:	Rework Qty:	Production	If two consecutive Pieces, At least one Orange	Y	O	G	O
Operator:		Prod. Supervisor:		Line Inspector:		QA Supervisor:		
F/Q/010 Rev:0					DC 001 / 20/ PMC - Rev No:0			