PROCESS MONITORING CHART

Date :	
Shift : I / II / III	

Part No: 3235E3905 / C - 23.05.2023	Part Name: CASE - DIFF. FIN	Characteristics: Squareness on Bearing Dia &Bearing Shoulder wrt A	Spec: 0.064 Max
Operation No/Name: 70 / OD Grinding	Machine Description/Code: HMC- OD GRINDING / HMC- OD GRINDING	Measuring Equipment: Special Gauge (variable)	Least Count : 0.001 mm / EU5

All Dimensions are in mm

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
								If two consecutive Pieces, At least one Orange	Y	O	G O

Produced Qty:	Rejection Qty:	Rework Qty:	

Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**

PROCESS MONITORING CHART

Date :	
Shift : I / II / III	

Part No: 3235E3905 / C - 23.05.2023	Part Name: CASE - DIFF. FIN	Characteristics: Bearing Diameter	Spec: Ø 101.675 / 101.730
Operation No/Name: 70 / OD Grinding	Machine Description/Code: HMC- OD GRINDING / HMC- OD GRINDING	Measuring Equipment: Air gauge	Least Count : 0.001 mm / EU4

All Dimensions are in mm

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	
								If two consecutive Pieces, At least one Orange	Y	O	G	O

Produced Qty:	Rejection Qty:	Rework Qty:	
Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**

PROCESS MONITORING CHART

Date :	
Shift : I / II / III	

Part No: 3235E3905 / C - 23.05.2023	Part Name: CASE - DIFF. FIN	Characteristics: Ovality on Bearing Diameter	Spec: 0.01 Max
Operation No/Name: 70 / OD Grinding	Machine Description/Code: HMC- OD GRINDING / HMC- OD GRINDING	Measuring Equipment: Air gauge	Least Count : 0.001 mm / EU4

All Dimensions are in mm

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
								If two consecutive Pieces, At least one Orange	Y	O	G O

Produced Qty:	Rejection Qty:	Rework Qty:	

Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**

PROCESS MONITORING CHART

Date :	
Shift : I / II / III	

Part No: 3235E3905 / C - 23.05.2023	Part Name: CASE - DIFF. FIN	Characteristics: Taper on Bearing Diameter	Spec: 0.01 Max
Operation No/Name: 70 / OD Grinding	Machine Description/Code: HMC- OD GRINDING / HMC- OD GRINDING	Measuring Equipment: Air gauge	Least Count : 0.001 mm / EU4

All Dimensions are in mm

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	
								If two consecutive Pieces, At least one Orange	Y	O	G	O

Produced Qty:	Rejection Qty:	Rework Qty:	
Operator:	**Prod. Supervisor:**	**Line Inspector:**	**QA Supervisor:**