


<div></div> <div>PROCESS MONITORING CHART</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																					
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	
		Produced Qty:		Rejection Qty:		Rework Qty:				Stop and Correct the Production		First Piece itself Red				R	or	O			
Two Consecutive Pieces Green & Yellow or Yellow &Green												G	Y	Y	G	If two consecutive Pieces, At least one Orange				Y	O
Operator:				Prod. Supervisor:				Line Inspector:						QA Supervisor:							
F/Q/010-Rev.0																		CTS01 / 30 / PMC - Rev: 00			