

## PROCESS MONITORING CHART

Date :

Shift : I / II / III

Part No: 3235E3905 / C - 23.05.2023	Part Name: CASE - DIFF. FIN	Characteristics: Flatness on Spider face	Spec: 0.04 Max
Operation No/Name: 10 / ID Turning	Machine Description/Code: ACE - 2 & 3 / ACE - 2 & 3	Measuring Equipment: Special Gauge (variable)	Least Count : 0.001 mm
			EU9

**All Dimensions are in mm**

[illegible]

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

Operator:	Prod. Supervisor:	Line Inspector:	QA Supervisor:
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F/Q/010 Rev: 0

DC 001 / 10/ PMC - Rev No:0

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																				Shift : I / II / III			
Part No: 3235E3905 / C - 23.05.2023				Part Name: CASE - DIFF. FIN						Characteristics: Height								Spec: 64.24 / 64.33					
Operation No/Name: 10 / ID Turning				Machine Description/Code: ACE - 2 & 3 / ACE - 2 & 3						Measuring Equipment: Special Gauge (variable)								Least Count : 0.001 mm				EU6	
All Dimensions are in mm																							
	64.335																						
USL	64.330																						
	64.326																						
	64.321																						
	64.317																						
	64.312																						
	64.308																						
	64.303																						
	64.299																						
	64.294																						
	64.290																						
MEAN	64.285																						
	64.281																						
	64.276																						
	64.272																						
	64.267																						
	64.263																						
	64.258																						
	64.254																						
	64.249																						
	64.245																						
LSL	64.240																						
	64.236																						
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 / 10/ PMC - Rev No:0			



<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: Spherical Radius								Spec: R 82.57 / 82.63						
Operation No/Name: 10 / ID Turning				Machine Description/Code: ACE - 2 & 3 / ACE - 2 & 3						Measuring Equipment: Special Gauge (variable)								Least Count : 0.001 mm				EU7		
All Dimensions are in mm																								
	82.633																							
USL	82.630																							
	82.627																							
	82.624																							
	82.621																							
	82.618																							
	82.615																							
	82.612																							
	82.609																							
	82.606																							
	82.603																							
	MEAN	82.600																						
	82.597																							
	82.594																							
	82.591																							
	82.588																							
	82.585																							
	82.582																							
	82.579																							
	82.576																							
	82.573																							
LSL	82.570																							
	82.567																							
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							
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	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 / 10/ PMC - Rev No:0			