

PROCESS MONITORING CHART

Date:

Shift: I / II / III

Sniπ: 1 / 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 Co	ount : 0.001 mm			EU5		
									All	Dimensio [,]	ns are in m						<u></u>					/r
113,176																						
113.128																						
113.112							7															1
113.096																						
113.080																						
113.064																						
113.048																						
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113.000								4														<u> </u>
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	C-20	7:00	7.20	2:00			0.20	0.00	0.20	10.00	10:20	11.00	11:20	12:00	12:20	1.00			1,20	3,00	2:20	3,00
· +			+ +	+	1			+			1					+ -	1			+	+ +	3:00 11:30
III	11:30	12:00	12:30	1:00	С	 JA	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00		 QA	6:30			
	CODE		DE	 ΓAIL		CODE	 		DETAIL			CODE			DETAIL		1	CODE	 	DE	TAIL	<u> </u>
PROCESS LOG CODE B		TOOL CH/			↓	D	POWER FAILURE						HARD MATERIAL						IDLE			
		TOOL AD!	JUSTMENT			E	MACHINE	MACHINE BREAK DOWN					WAITING FOR MATERIAL					К	NO PLAN	NO PLAN		
	С	MACHINE	MACHINE VARIATION F				SPEED / FEED CHANGE					1 1	MANDREL PROBLEM					L	NO MAN	NO MAN POWER		
								Rule	s for use	of Proce	ess Moni	coring Ch	nart									
& Setting		Five Cons	ive Consecutive Component Green				G	G	G	G	G			ect the					Y	Υ		
the Broduc		Two Cons	Two Consecutive Pieces are Green				G	G					Production				Pieces, A	t least	Υ	R	G	R
Continue the Production			Two Consecutive Pieces Green & Yellow or Yellow &Green				G	Y	Y	G					First Piece itself Red			R	or	0		
8	113.176 113.176 113.160 113.144 113.128 113.112 113.096 113.080 113.048 113.032 113.016 113.000 112.984 112.952 112.936 112.936 112.920 112.840 112.840 112.824 IIII	3235E3905 / C - 123 In No/Name: 20 / O 113.176 113.160 113.144 113.128 113.112 113.096 113.080 113.064 113.048 113.032 113.016 113.000 112.984 112.968 112.952 112.936 112.920 112.904 112.888 112.872 112.888 112.872 112.856 112.840 112.824 I 6:30 II 3:00 III 11:30 CODE A B C S Setting	3235E3905 / C - 223 On No/Name: 20 / OD 113.176 113.160 113.144 113.128 113.112 113.096 113.080 113.064 113.048 113.032 113.016 113.000 112.984 112.968 112.952 112.968 112.952 112.936 112.920 112.904 112.888 112.872 112.888 112.872 112.856 112.840 112.824 I 6:30 7:00 II 3:00 3:30 III 11:30 12:00 CODE A TOOL CHA B TOOL ADJI C MACHINE 3 Setting Five Cons Two Cons	13.176	113.176	Part Name: CASE - DIFF. F.	Part Name: CASE - DIFF. FIN	Part Name: CASE - DIFF. FIN	Part Name: CASE - DIFF. FIN	Part Name: CASE - DIFF. FIN Character	Part Name: CASE - DIFF. FIN Characteristics: Dim No/Name: 20 / OD Machine Description/Code: ACE - 5 / ACE - 5 Measuring Equip	Part Name: CASE - DIFF. FIN Characteristics: Distance	Part Name: CASE - DIFF. FIN Characteristics: Distance	Part Name: CASE - DIFF. FIN Characteristics: Distance Machine Description/Code: ACE - 5 / ACE - 5 Measuring Equipment: Special Gauge (varion No/Name: 20 / OD Machine Description/Code: ACE - 5 / ACE - 5 Measuring Equipment: Special Gauge (varion No/Name: 20 / OD Measuring Equipment: Special Gauge	Part Name: CASE - DIFF. FIN	Part Name: CASE - DIFF. FIN Characteristics: Distance	3235E3905 / C - 23	## Part Name: CASE - DIFF. FIN	Second Column Second Colum	2325E3905 / C - 233	## Special Control	Part Name: CASE - DIFF. FIN

Produced Qty:	d Qty: Rejection Qty:		Rework Qty:		Production If two co		nsecutive Pieces, At least ge	Υ	О	G	О
Operator:		Prod. Supervisor: Line Inspector:			QA Supervisor:						
F/Q/010 Rev:0										MC - Rev	No:0