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F/Q/010-Rev.0

PROCESS MONITORING CHART

Date:

CTS01 / 30 / PMC - Rev: 00

																					Shift: I /	' II / III		
Part No: 23.05.20	3235E390)23	05 / C -		Part Nan	ne: CASE	- DIFF. F	IN			Characteristics: Squareness on Bearing Dia &Bearing Shoulder wrt A										Spec: 0.064 Max				
Operation Grinding	on No/Nar	ne: 70 /	OD	Machine / HMC- (-		le: HMC	- OD GRI	NDING	G Measuring Equipment: Special Gauge (variable) Least C								Least Co	st Count : 0.001 mm			EU5		
All Dimensions are in mm																								
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			
Time and shift	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	
	Ш	11:30	12:00	2:00 12:30 1:00			Α	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	q	ĮΑ	6:30				
		CODE		DET	AIL		CODE			DETAIL			CODE	DETAIL					CODE		DETAIL			
PDOCECC	PROCESS LOG CODE B			ANGE / INS	ERT CHAN	GE	D	POWER F	AILURE				G HARD MATERIAL							IDLE				
PROCESS				USTMENT			E	MACHINI	BREAK D	own			Н	WAITING FOR MATERIAL					К	NO PLAN				
		С	MACHINE	MACHINE VARIATION				SPEED / F	EED CHAN	GE I MANDREL PROBLEM							L	NO MAN POWER						
									Rule	s for use	of Proce	ss Moni	toring C	hart					'					
Start-up 8	& Setting		Five Con	secutive C	omponen	it Green		G	G	G	G	G	Stop	and Corre	ct the	Two Consecutive Pieces are Yellow				Y	Y			
Caratian	Alexa December		Two Con	secutive P	ieces are	Green		G	G					Production	n	If two co one Red	nsecutive	Pieces, A	t least	Υ	R	G	R	
Continue				secutive P Green	ieces Gre	en & Yello	ow or	G	Υ	Υ	G		Stop	and Corre	ct the	First Piece itself Red			R	or	О			
Produced	Produced Qty: Rejection Qty: Rew						Rework	Qty:				Production		If two co one Orar		Pieces, A	t least	Y	0	G	o			
Operator	Operator: Prod. Supervisor:								Line Inspector: QA Supervisor:															

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PROCESS MONITORING CHART

Date:

Shift: I / II / III

																				Shift: I	/ II / III		
Part No: 3 23.05.202		5 / C -		Part Nan	ne: CASE	- DIFF. F	:IN			Characteristics: Bearing Diameter Spec: Ø									Ø 101.675 / 101.730				
Operation Grinding	-	ne: 70 /	OD		e Descrip	otion/Cod IDING	le: HMC-	OD GRI	NDING	IDING Measuring Equipment: Air gauge Least Count : 0.0							.001 mm		El	J4			
										All	Dimension	ns are in m	m										
1	I	6:30	7:00	7:30	8:00		8:		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	
Time and shift	II	3:00	3:30	4:00	4:30				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	
	Ш	11:30	12:00	12:30	1:00	Q	ĮΑ	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	5:30 6:00 QA		6:30				
A		CODE		DET	ī AIL		CODE		DETAIL					DETAIL COD						DETAIL			
DDOCECC I	PROCESS LOG CODE			ANGE / INS	ERT CHAN	IGE	D	POWER F	OWER FAILURE G HARD MATERIAL								J	IDLE		_			
PROCESS L				TOOL ADJUSTMENT E MACH						CHINE BREAK DOWN					H WAITING FOR MATERIAL K								
		С	MACHINE	VARIATIO	N		F	SPEED / F	SPEED / FEED CHANGE I MANDREL PROBLEM L							NO MAN	POWER						
									Rule	s for use	of Proce	ss Moni	toring Cl	nart									
Start-up &	Setting		Five Cons	secutive Co	omponen	nt Green		G	G	G	G	G	Stop	Stop and Correct the Two Cor			Two Consecutive Pieces are Yellow			Υ			
Continuo	h a Dradu		Two Cons	secutive P	ieces are	Green		G	G					Productio	n	If two co	nsecutive Piec	es, At least	Υ	R	G	R	
Continue t	ne Produc		Two Cons Yellow &	secutive P Green	ieces Gre	en & Yello	ow or	G	Υ	Υ	G		Stop	and Corre	ct the	First Piec	e itself Red		R	or	О		
Produced Qty: Rejection Qty:								Rework (Qty:				Production	1	If two co	nsecutive Piec ige	es, At least	Υ	О	G	О		
Operator: Prod. Supervisor:								Line Inspector: QA Supervisor:															
F/Q/010-Re	v.0																		CT	S01 / 30 /	PMC - Rev:	00	

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PROCESS MONITORING CHART

Date:

Shift : I / II / III

																					Shift: I /	'II / III		
Part No: 3 23.05.202	3235E390 23)5 / C -		Part Nar	me: CASE	: - DIFF. F	FIN			Characteristics: Ovality on Bearing Diameter Spec: 0.										0.01 Max				
Operation Grinding	on No/Nan	ne: 70 /	OD		e Descript		le: HMC-	- OD GRII	NDING	Measuring Equipment: Air gauge Least Count : 0							unt : 0.0	nt : 0.001 mm			J4			
_		*		-					,	All	Dimension	ns are in m	m											
	ı	6:30	7:00	7:30	8:00				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	
Time and shift	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	
	Ш	11:30	12:00	12:30	1:00	Q	ĮΑ	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	Q/	A	6:30				
		CODE		DET	TAIL		CODE		DETAIL					DETAIL					CODE	DETAIL				
PROCESS	PROCESS LOG CODE			ANGE / INS	SERT CHAN	IGE	D	POWER FA	AILURE		G HARD MATERIAL J								J	IDLE				
PROCESS I				JUSTMENT		MACHINE	ACHINE BREAK DOWN					WAITING FOR MATERIAL					К	NO PLAN						
/		С	MACHINE	E VARIATIO)N		F	SPEED / F	SPEED / FEED CHANGE I MANDREL						L PROBLEN	М			L	NO MAN F	OWER			
									Rule	es for use	of Proce	ss Monit	toring Ch	nart				_						
Start-up &	k Setting		Five Cons	secutive C	Componen	ıt Green		G	G	G	G	G	Stop	Stop and Correct the Two C			Two Consecutive Pieces are Yellow			Y	Υ			
Continue	the Dradu		Two Con	secutive P	ieces are	Green		G	G					Production	h	If two cor one Red	nsecutive Pi	Pieces, At	least	Υ	R	G	R	
Continue	the Produc	tion	Two Con Yellow &	nsecutive P kGreen	ieces Gre	en & Yello	ow or	G	Υ	Υ	G		Stop	and Correc	ct the	First Piece	e itself Red	I		R	or	o		
Produced	Produced Qty: Rejection Qty: Re								Rework (Qty:				Production	1	If two cor	nsecutive Pi ige	Pieces, At	least	Y	О	G	О	
Operator:	Operator: Prod. Supervisor:									Line Insp	ector:					QA Supervi	isor:							
F/Q/010-Re	ev.0																			CTS	01 / 30 / F	PMC - Rev:	00	

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PROCESS MONITORING CHART

Date:

Shift : I / II / III

																					Shift: I /	'II / III		
Part No: 3 23.05.202	3235E390 23)5 / C -		Part Nar	me: CASE	: - DIFF. F	FIN			Characteristics: Taper on Bearing Diameter Spec: 0.										0.01 Max				
Operation Grinding	on No/Nan	ne: 70 /	OD		e Descript		le: HMC	- OD GRII	NDING	Measuring Equipment: Air gauge Least Count : 0.								unt : 0.0	: 0.001 mm			J4		
_		*		-				,		All	Dimension	ns are in m	m											
	ı	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	2:30 1:00			1:30	2:00	2:30	3:00	
Time and shift	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	
	Ш	11:30	12:00	12:30	1:00	0	QA	1:30	2:00	2:30	3:00	3:30	4:00	4:30	5:00	5:30	6:00	Q/	A	6:30				
		CODE		DET	TAIL		CODE		DETAIL					DETAIL					CODE	DETAIL				
			TOOL CH	ANGE / INS	SERT CHAN	IGE	D	POWER FA	AILURE				G	HARD MA	TERIAL				J	IDLE				
PROCESS I	PROCESS LOG CODE B			TOOL ADJUSTMENT E MACH						ACHINE BREAK DOWN					H WAITING FOR MATERIAL					NO PLAN				
/		С	MACHINE	E VARIATIO)N		F	SPEED / F	SPEED / FEED CHANGE						L PROBLEN	М			L	NO MAN F	OWER			
									Rule	es for use	of Proce	ss Monit	toring Ch	nart									1	
Start-up &	k Setting		Five Cons	secutive C	Componen	ıt Green		G	G	G	G	G	Stop	Stop and Correct the			Two Consecutive Pieces are Yellow			Y	Υ			
Continue	the Dradu		Two Con	secutive P	ieces are	Green		G	G					Production	h	If two cor one Red	isecutive Pi	e Pieces, At least		Υ	R	G	R	
Continue	the Produc	tion	Two Con Yellow &	nsecutive P kGreen	ieces Gre	en & Yello	ow or	G	Υ	Υ	G		Stop	and Correc	ct the	First Piece	e itself Red	i		R	or	o		
Produced	Produced Qty: Rejection Qty: Re								Rework (Qty:				Production	1	If two cor	nsecutive Pi ige	Pieces, At	least	Y	О	G	О	
Operator:	Operator: Prod. Supervisor:									Line Insp	ector:					QA Supervi	visor:							
F/Q/010-Re	ev.0																			CTS	01 / 30 / F	PMC - Rev:	00	