PLY : 5 Machines

1) PMC makes schedule

2) PMC upload schedule

3) There are 5 machines of ply

4) Ply Machine start

5) Operator enter emp id

6) schedule download in machine

7) Batch comes from calendring

8) Batch cut in 45 angle

9) Its uses fifo method for batch in ply machine

10) Then after completion of cutting then id card generated

That was the process of ply which I understood

Cheffer : 1 Machine

Schedule is required which created by pmc

Cheffer is like ply its used with IL in tyre building

BW(beed wire) : 2 Machines

Schedule is required which created by pmc

Beed wire is the first step of tyre building process its made from steel and rubber on proper weight and size.

IL & cheffer : 1 Machine

Schedule is required which created by pmc

These both are used in inside the tyre both of above are used together

There is small spool required in il because required low space

PLY A :

Schedule is required which created by pmc

Ply a is used after il & cheffer from bottom

PLY B :

Schedule is required which created by pmc

Ply b is used after ply A

Breker :

Breker may be used as per tyre requirement

TR : 2 Machine

Schedule is required which created by pmc

TR is top and hardest part of tyre

There is die used for tyre shape

Bit spool required for TR because that’s required big space.