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| **Daily Shift Report CP/TB - Setup** | | | | **A picture containing text, clipart  Description automatically generated** | | |
| **Date/Schedule** | **7/13/2023 // 07:00-19:00** | | | | |  |
| **Team** | **Yellow Shift** | | | | |
| **Setup Technician** | **Troy New/Chris Leak** | | | | |
| **SAFETY** | | | | | | |
|  |  | | | | | |
| **Concern** |  | | | | | |
| **Concern** |  | | | | | |
| **Concern** |  | | | | | |
| **Machine Issues** | | | | | | |
| ***Machine*** | ***Duration (Min)*** | ***Description of Problem*** | | | ***Resolution*** | |
| TBAM1 |  | Investigated cause of scrap tires due to chafer issues from prior builds. Shaping drum 1 fault during GT removal step. (2x) Maintenance adjusted the beadlock regulator air pressures and requested we make changes to HMI pressure settings as well. | | | Found pressure added to multidisc rollers on BP application to compensate for dry material were causing the chafer to shift. Pressure was removed from rollers. Manually removed tire for inspection. Put machine back in step for production. Lowered beadlock high and low pressures to mirror regulator settings adjusted by maintenance. | |
| TBAM2 |  | Forced article change due to lack of material. | | | Changeover to 4900. | |
| TBAM3 |  |  | | |  | |
| TBBM3 |  | Forced article change due to lack of material. Breaker 4 knife making bad cuts. | | | Changeover to 4800. Assisted maintenance & resent the order to correct issue with knife. | |
| TBBM2 |  | Found 2 bead fingers out of tolerance. | | | Maintenance notified to set the bead finger distance. | |
| BACC2 |  |  | | |  | |
| BACC3 | 8min | Called to troubleshoot open apex splices. Validation issues had to be resolved and material was scrapped at order change. Maintenance & process assisted with troubleshooting. Called back for open splices. | | | Adjusted operator offsets for apex length, lay on position, pick & place lay on position, and splice roller pressures. Requested maintenance to check splice roller bladder for defects. Adjusted multiple offsets with fresh material & bead splices began to close consistently with apex lay on position set to 0.8 and apex length shortened to around 2. | |
| BACC1 |  |  | | |  | |
|  | | | | | | |
| 5S Good/Bad |  | | | | | |
| Good |  | | | | | |
| **SHIFT COMMENTS** | | |
| **Assisted Operators with issues/adjustments that didn’t require set up loss code. Article changeovers. Restocked bead bladders in set up shop. Forced article change from breaker cutter 2 to breaker cutter 1 due to ongoing issues with BC2.** | | |
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| --- | --- | --- | --- |
| **MACHINE NAME** | **HEIGHT** | **ANGLE** | **GAP** |
| TBAM1 | 25MM | OK | OK |
| TBAM2 | 25MM | OK | OK |
| TBAM3 | 25MM | OK | OK |
| TBBM2 | 25MM | OK | OK |
| TBBM3 | 20MM | OK | OK |