

Manufacturing Operation Standard

Preparing Department		
Confirmed by	Checked by	Prepared by

Control No.
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Model	3AM	Process / Operation Name	Balancing (if required)
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PICTORIAL VIEW		No.	Operation	Quality Standard	Working Point	Tool & Material	Comments	Safety Points
01 02 03		1	Power On	-	By hand switch on 1) Power Braker 2) Power Switch 3) PC On	1) Breakers 2) Button	It is necessary to on these button to start machine & see the display is working	Gloves / Shoes
05 04		2	Program Call	Select Drum Program PP\FM\024 ISSUE 01 PAGE 11 of 17	Software ↓ Rotor ↓ Rotor Parameter ↓ S tool & L tool	Keyboard / Mouse	"If this activity is not performed, Right Program so the part may be checked against incorrect tolerances, leading to potential rejection."	Gloves / Shoes
08 07		3	Mount Jig on machine surface	Surface should be clean	By using air gun clean the surface before mounting Jig	Ln-Key Air Gun Socket Head Bolt	If this activity is not perform then it can cause calibration out/cause an Accident	Gloves / Shoes
09 10 11		4	Close the guard & verify calibration of jig on screen	1) Dialing Limit Maximum 0.1 mm 2) tolerance of unbalance 1 gm.mm Maximum	1)Dial the jig with lever dial gauge & reclamp the jig until Run out is within 0.1mm 2)Run Balancing till unbalance amount 9 gram maximum	Lever Dial Gauge Ln-Key weight Brass or Copper	If this activity is not perform then it can cause jig calibration out	Gloves / Shoes
12 13		5	Visually Check & clamp the /Drum on jig	1) No dust or burr allowed. 2) /Drum& jig should be cleaned 3) Nut Tightening	Visually check the Pcs. Mount /Drum then add spacer and tight Nut with Air Wrench	Wrench Nut Spacer	"The nut must be tightened within the specified range; otherwise, the result may not be accurate."	Gloves / Shoes
14 15 16		6	Run Balancing	1) All confirmation switch on reference. 2) RPM of machine should be 930 ± 10 Drawing Standard (150x10 ⁻³ kg.m) see chart unit conversion	1) Press Green button to start cycle 2) Press space button on keyboard 3) when result appears then press "H" button on keyboard 4) Stop cycle by pressing Red Button.	Green Button Keyboard Red Button Confirmation switch	If confirmation switch not ON reference then machine not start. If space button not Press during balancing it will not show machine RPM & result of on unbalance amount. To hold result for correction of unbalance amount press "H" button. if Result is in OK limit then process next operation # 10. if Result is in NG Limit then process operation # 10 OK 150x10⁻³ kg.m = 1500 gmm NG 151x10⁻³ kg.m =	Gloves / Shoes
17 18 19 20 21		7	Correction of unbalance amount	1)Depth 16mm MAX 2) Correction Diameter Ø217	a)Un balance degree aligned on arrow (1) and then move value of arrow (2) on arrow (1) and lock it. b)Now lock Drum with the help of locking nut c)Now press cutter motor button ON. d)Depth of cut should not more then 0.3 ~ 0.5mm on first time cutting unbalance amount from Drum. e)for cutting R100 please rotate radius cutting handle to stopper (2) f)for cutting radial in range of 30 degree rotate, Radial handle until the value of arrow (2) reach on a arrow (1) g)Again cutting R100 please rotate, radius cutting handle till seat on stopper (3) h)Now OFF Button Cutter Motor Switch and then rotate, radius cutting handle to its switch ref position on stopper (1)	Stopper 1,2,3 Radius cutting handle Radial Handle Cutter Dia 60 locking Cutter motor Button.	a)If not move value of arrow (1) on arrow (2) then value is not in range. b)If do not lock the Drum by rib profile gauge then unbalance can not cut from Drum. c)If motor button do not press ON before cutting then motor will not work. d)If depth of cut is not in define value range, part can be reject. e) If not rotate radius cutting handle to stopper (2) then Radius R100 is not shown on Drum./ work uncompleted. f) If cutting readily not in range of 30 degree then unbalance amount position will shift. g) If not rotate radius cutting handle to stopper (3) then Radius R100 is not shown on Drum./ work uncompleted. h) If do not OFF cutter motor switch then its cause of an accident and if do not rotate radius cutting handle to its switch ref position on stopper then M/c will not work	Gloves / Shoes

