

APPENDIX "G"
(Refer Para 10.3.4)

GUIDELINES FOR
PROCESS AUDIT OF TYRE FLAP MANUFACTURING FIRM

1. INTRODUCTION:

These guidelines have been prepared for the purpose of carrying out process audit of the Flap manufacturing firms. The team of officers nominated for carrying out process audit shall refer this document for ease of conducting an audit. However, the officers, may also include additional check points in the report, if found necessary while carrying out the audit.

2. CHECK POINTS FOR PROCESS AUDIT:


Stage wise check points are given in succeeding paras. The weightage (Marks) for various parameters are given at relevant para. The team of officers will allot the marks as per Supplier's Process Audit Report (SPAR) attached at Appx. 'H'. The firm should get minimum 80 % marks to qualify as supplier.

3. ESSENTIAL EQPTS FOR MFG PROCESS & TEST EQPTS FOR QUALITY ASSURANCE OF RAW MATERIAL & FINISHED TYRE FLAP

3.1 Before carrying out process audit, one should examine the capability of machines/ equipments, their functional accuracy and calibration record maintained by the firm. In case the firm do not have any one of the essential machineries and test equipments, process audit will not be carried out. List of equipments is given below:

a) Essential plant machineries

- (i) Ban bury/Kneader/Mixing mill
- (ii) Cracking mills.
- (iii) Two roll mills.
- (iv) Steam generator/Electric Heater.
- (v) Flap trimming facilities.
- (vi) Ageing ovens.
- (vii) Splicing machine.
- (viii) Bias cutter
- (ix) Hydraulic presses with on-line controls for curing parameters.
- (x) Digital weighing Machine.


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b) Desirable plant machineries

- (i) Strainer
- (ii) Mould Cleaning Machine
- (iii) Dust collector
- (iv) Automated material handling system.

c) Essential Testing Facilities

- (i) Universal tensile testing machines with computer interface
- (ii) Sp. gravity tester.
- (iii) Rheometers.
- (iv) Moony Viscometers.
- (v) Hardness Tester.
- (vi) Muffle Furnace
- (vii) RHC Tester
- (viii) Ash Content Tester
- (ix) Dumble / Sample cutter
- (ix) Ageing Oven
- (x) Digital weighing Machine

d) Desirable Testing Facilities

- (i) Low Temp Tester
- (ii) Anti ageing element analyser
- (iii) Ozone resistance tester.
- (iv) Dispersion analyzer
- (v) Sulphur analyser

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