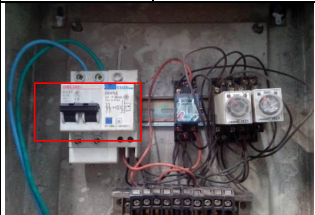









Standard Operation Sheet

No.: XTL/SOS-PD-005

Process Name		Air Pressure Test		Product Name		Prepared by										Reviewed by						
Group members		Approved by										Date										
Type	No.	JES NO.	Work Element	Element Time (Sec.)			Safe	Ergonomic	Technical skill	K	Check	Q	Key operate	Y	Impose Process	Qty of producing	Operator	Forward path	Return path	...		
				Works	Equipment	Run																
	1		Lifting, lifting the air tube to the air pressure	30		30																
	2		Check the logo on the process card and the strap to confirm that the product matches.	10																		
	3		Unpacking and removing the sling	10																		
	4		Confirm that the gas pressure of the pneumatic equipment meets the pressure requirements on the Process Card.	10		15																
	5		Confirm that the water is clean and clear. Otherwise, replace all the water, and replace the water with a tank and add 1kg/100kg of water to Na2No3.	30		20																
	6		Confirm that the water volume can down the production of steel pipes. Otherwise add water and add 1kg Na2No3	30		20																
	7	JES NO.1	Equipment adjustment	10		30																
	8	JES NO.2	In production		120																	
	9		Record the production record of the pneumatic process (production batch number, transfer card number, specifications, count, steel grade, product standard,	20																		
	10		Fill in the flow record part on the process card (corresponding to process, count, operator, production date, quality status), corresponding process	20																		
	11		The steel pipe is bundled and the steel pipe is lifted.	15																		
	12		Use a packing tape to bundle at both ends of the steel pipe	10																		
	13		Fill in the label on the packaging tape at one end (flow card number, steel grade, specification)	10																		
	14		Place a craft card	10																		
	15		Lifting, the air pressure test is completed until the steel pipe is lifted to the designated area.	30																		
Total Time 总计:				245	120	115																
Periodical Total time 周期总计:				480																		
Actual Time 实际节拍:																						
Countersign																						
Department				Date																		
Technical Dept.		崔杨		2019.7.20																		
QA Dept.		苏相辉		2019.7.20																		
Equipment Dept.		高银胜		2019.7.20																		
Production Dept.		田连营		2019.7.20																		

OTHER ITEM:

Operator guide(JES)NO.1										Product Name				Stainless steel straight pipe			
Element Name	Parameter Adjustment	Mandatory:√	Type	Safe	Key Operate	Quality Inspection	Necessary steps	ergonomics	Technical Skill	Prepared by:	Reviewed by:	Approved by:	Page: 1 of 1				
		Optional :															
				Type	Step #	Main Steps(What)			How		Why						
1. Turn on the power		2. Adjust air pressure control time		+	1、	Turn on the device			The power switch is turned up and must not be operated by wet hands.		Open gas time control device						
				+	2、	Adjust air pressure control time			Rotate the device until the pointer stays above the required air pressure time		Ensure that the air pressure time meets the process card requirements						
 		3. 1 Rotate the ferrule counter clockwise		3. 2 Take out the seal		+	3、	Change mold			Use molds that meet product specifications		Make sure the job is working properly				
						+	3.1	Take out the existing mold ferrule			Rotate counterclockwise until it falls off		Prepare to remove the head inside the mold				
						+	3.2	Remove the mold ferrule seal ring			Take out directly		Prepare to replace the seal				
						+	3.3	Take out the seal			Pull out the seal		Prepare to replace the seal				
						+	3.4	Replace the seal			Insert the seal into the bottom of the seal		Replace the seal ring				
						+	3.5	Replace the seal ring			Put the ring inward with a large circle		Replace the seal ring				
						+	3.6	Tighten the mold ferrule			Turn the sleeve back clockwise		Fixed mold				
						+	4、	The other end of the mold replacement according to the third point									
3. 1 Rotate the ferrule counter clockwise		3. 2 Take out the seal															
3.3Take out the seal		3.4 Take out the seal															
																	
3.5 Replace the seal		3.6 Tighten the head clockwise															
																	
Countersign																	
Department						Date		Alteration	Description		Sign						
QA Dept.		苏相辉		2019.7.20													
Equipment Dept.		高银胜		2019.7.20													
Production Dept.		田连营		2019.7.20													
Other Dept.																	

Operator guide(JES)NO.2

Product Name:

Stainless steel straight pipe

Element Name	Quantity Productiong	Mandatory :√	Type	Safe	Key Operate	Quality Inspection	Necessary steps	Ergonomics	Technical Skill	K
	Optional:									
				Type	Step #	What	How	Why		
<div>1. Steel pipe insert head</div> <div>2. Steel pipe into the water</div>			1、	Insert the steel pipe into the mold split	Insert until the top to the mold can not continue	Ensure air pressure test tightness				
			2、	Put the whole steel pipe into the water	The entire steel pipe containing the mold head is immersed in water	Ensure that the whole pipe is tested				
			3、	Start the pressure test	Slightly step on the starter	Ventilation start pressure test				
			4、	Observe whether there is a leak	The steel pipe begins to heat treatment,	Check for defective products				
			5、	Pull out the steel pipe and put to	Complete the stress test and wait for it to	Waiting to dry				
			6、	Repeat the above actions	Until the test of the whole bundle of steel pipes is	Waiting to dry				
			7、	Dry the outer surface of the steel pipe	The whole steel pipe is dried	For subsequent product inspection				
<div>3.Air pressure start</div> <div>4.Observe whether the steel pipe is leaking</div>										
<div>5.Steel pipe placed on the rack</div>										
<div>7. Dry steel pipe</div>										
Countersign										
Department			Date		Alteration	Description		Sign		
QA Dept.		苏相辉		2019.7.20						
Equipment Dept.		高银胜		2019.7.20						
Production Dept.		田连营		2019.7.20						
Other Dept.										