VKS TECH
Industrial Knowledge for Packaging Pros

SHOP FLOOR CARD
Doc: VKS-MET-OD-01 | Rev: 01
Print & Laminate

LOW OD DEFECT — ACTION CARD

Metallization Coating Thickness Recovery Plan | Low OD ठीक करने की Action Plan

⏱ Total Time: ~5 min | 🎯 Solves 80% of Cases | 🏭 For: Met-1 / Met-2

🎯 THE 5-STEP ACTION PLAN | 5-Step कार्य योजना

1 — CONFIRM
Check OD reading vs target on sensor
30 sec

2 — WIRE FEED
Spool, jam, groove, springs, spout
⚡ 80% HERE

3 — BOATS
Glow, contacts, current >500A
1 min

4 — SENSOR
AUTO mode? Window clean?
1 min

5 — VERIFY
200 m/min, sample L/C/R measure
2 min

📊 TOP 5 CAUSES RANKED | Top 5 कारण

#	Cause	Freq	Action
1	Worn drive wheel groove	35%	Turn 2nd groove
2	Blocked / damaged spout	25%	Remove + clean
3	Sensor in Manual mode	15%	Switch to AUTO
4	Boat crack / cold spot	12%	Plan changeover
5	Wire spool ending	8%	Load new spool

🌳 QUICK DECISION TREE | जल्दी निर्णय

- **All probes low?** → System issue
  - Sensor AUTO? → Switch to AUTO
  - Recipe OK? → Reload recipe
  - Speed high? → Reduce 50 m/min
- **Only 1-2 probes?** → Local issue
  - Boat dark? → Plan changeover
  - Feeder slow? → Groove + spout
  - Contact dirty? → Sand + graphite

🛡 PREVENTION CHECKLIST | रोकथाम

📅 MONTHLY PM
Turn drive wheel to next groove • Replace worn spouts • Check spring tension

📅 WEEKLY PM
Clean copper contacts • Apply fresh graphite tape • Inspect wire path

🔄 PER SHIFT
Wipe sensor window during changeover • Check OD trend at start of shift

📦 SPARE STOCK
10-20 ceramic boats ready • Springs, spouts, drive wheels in store

KEY RULE — Wire Feed First!
80% of Low OD cases are solved in the wire feed system. ALWAYS check groove + spout BEFORE blaming boats or sensor. हमेशा पहले wire feed देखो — 80% problem यहीं हल होती है।