VKS TECH
Industrial Knowledge for Packaging Pros

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

HIGH OD DEFECT — ACTION CARD

Metallization Over-Coating Recovery Plan | High OD ठीक करने की Action Plan

⏱ Total Time: ~5 min | 💰 Saves ₹5-9 Lakh/year | 🏭 For: Met-1 / Met-2

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

1	2	3	4	5
CONFIRM	**WIRE FEED**	**SPEED**	**CALIBRATION**	**VERIFY**
Magnitude & trend Check on sensor	Rate, AUTO mode, target value	Actual vs recipe speed — KEY!	Inline vs offline match check	Sample L/C/R within ±0.1
30 sec	1 min	⚡ 40% HERE	2 min	2 min

📊 TOP 5 CAUSES RANKED | Top 5 कारण

#	Cause	Freq	Action
1	Line speed below recipe	40%	Restore speed
2	Wrong recipe loaded	25%	Re-load correct
3	Sensor in Manual mode	15%	Switch to AUTO
4	Sensor calibration drift	12%	Recalibrate
5	Target OD wrong	8%	Fix target value

🌳 QUICK DECISION TREE | जल्दी निर्णय

How bad? → Check magnitude
- └ **Gradual rise?** → Speed drift / Boat aging
- └ **Sudden jump?** → Mode / Recipe change

Mode check → AUTO or Manual?
- └ **Manual?** → Switch to AUTO
- └ **AUTO active?** → Check Step 3 (Speed)
- └ **Recipe OK?** → Verify ID vs PO
- └ **Still high?** → Calibrate sensor

💰 COST IMPACT CALCULATOR | लागत कैलकुलेटर

🔥 **Running +0.15 OD over target for a month = Silent Money Burn**

Extra wire consumption at +0.15 OD	~6.5%
Monthly aluminium wire (typical)	2,500 kg
Aluminium wire rate	₹341/kg
Monthly extra wire cost	₹55,400
Additional boat wear cost	₹20,000/month
ANNUAL INVISIBLE LOSS	**₹8.8 Lakh/year**

🛡 PREVENTION CHECKLIST | रोकथाम

🔄 **SHIFT HANDOVER**
Outgoing operator confirms current OD to incoming — catches drift early

📋 **RECIPE VERIFICATION**
Supervisor signs off on recipe ID before every new jumbo starts

⚡ **SPEED MONITORING**
Alert when actual speed drops >5% below recipe for >2 minutes

📅 **MONTHLY PM**
Calibrate inline sensor against offline standard; lock AUTO mode

💡 **KEY RULE — Check Speed First!**
40% of High OD = line speed below recipe. Fix speed BEFORE adjusting wire feed. हमेशा पहले speed check करो — 40% मामले यहीं हल।

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