VKS TECH vkstech.com	💥 WEB BREAK — OPERATOR CARD Hinglish · 5 Tear Patterns · Machine ke Paas Laga Lo	Doc No: VKS/MET/AC/02-OP Issue: 01 Rev: 00 Print: A4 Landscape + Laminate Location: Har metalliser ke paas

🛑 **E-STOP MAT DABAO** E-Stop sirf emergency ke liye — aag, koi fas gaya. Web break emergency nahi hai. **Machine khud auto-stop karegi** — drives ruk jayenge, boats standby pe, vacuum aur cooling ON rahenge. Aap bas confirm karo auto-stop complete hai, fir aage badho.

🎯 SABSE PEHLE 3 KAAM — KUL 2 MINUTE

1 Auto-stop ruk gayi? Time note karo. (30s) **2** Haath na lagao — **phone se photo lo** phati film ka. (1 min) **3** Tear pattern dekho — niche match karo. (30s)

👀 TEAR PATTERN DEKHO — REASON MILEGA

PATTERN 1



Seedhi Saaf Tear

Horizontal lakir, jaise kaenchi se kaata

➤ **Reason:** Film zyada tight thi (tension zyada)

➤ **Karo:** Tension display dekho. Jump kar raha? Dancer roller haath se push karo. Chipka hua to supervisor ko batao.

PATTERN 2



Tircha + Jhurriyan

Diagonal tear, wrinkles pehle aa rahe the

➤ **Reason:** Web side me slide ho raha (alignment bigadi)

➤ **Karo:** EPC sensor (kinare wala red LED) saaf karo. Slow speed pe 50m chalao. Phir bhi slide = Mechanical ko call.

PATTERN 3



Ek Kinare Se Shuru

Left ya right edge se tear shuru hui

➤ **Reason:** Unwind roll ke edge pe damage tha

➤ **Karo:** Woh roll waapas stores bhejo. Aage mat chalao. Next roll mount se pehle flashlight se edges check karo.

PATTERN 4



Jali Hui + Kala Dhabba

Burn mark + aluminium ka chota splatter

➤ **Reason:** Boat splash — molten aluminium giri film pe

➤ **Karo:** Boat turant retire karo — next cycle me hi. Supervisor ko batao. Boat 80% life cross kar chuki hai to splash karti hi rahegi.

PATTERN 5

Uljhi Hui (Jagged)

Uneven tear, scratch marks ya dust

➤ **Reason:** Gande roller ya film me hi defect

➤ **Karo:** Saare idler rollers IPA + cloth se wipe karo. Same roll pe dubara tear = batch hold, supervisor ko dikhao.

📞 KAB SUPERVISOR / ENGINEER KO CALL KARO

E&I	Tension display fluctuating, dancer chipka, load cell calibration chahiye, anti-static bar kaam nahi kar raha
Mechanical	EPC sensor replacement, roller bearing awaaz, web side me slide kar raha
Supervisor + Quality	Same batch ke 2+ rolls pe break, boat splash suspect, supplier NCR
Shift Incharge	Ek shift me 3+ break same cause se — production halt ka call

📝 F/16 CAUSE CODES — YAAD RAKHO

T Tension • **E** Edge damage • **A** Alignment • **D** Dirty roller
S Speed change • **St** Static • **F** Film defect • **B** Boat splash • **O** Other

Example: *"03:47, Met-2, Jumbo GMB26D0047, 480m pe break, Pattern 2 (Diagonal), Cause: A (Alignment), Downtime 52 min, Waste 65m, EPC sensor clean kiya."*