



SET UP No 621

OP-10	VACUUM FORM	Customer: JCB
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MATERIAL CODE: ABS154 SIZE 1000 x 600 X 4.0mm

NOTE: SETTING PARAMETERS ARE FOR GUIDE ONLY



PART	PART NO	DESCRIPTION	QTY	DATE STICKER
1	334/V7646MLDG	RH GUSSET MLDG	2	BOTTOM
OP NO	OPERATOR INSTRUCTIONS	QUALITY INSTRUCTIONS	METHOD / FREQUENCY	
10	Inspect the tooling and set-up on the machine.	Check that the tool is not damaged.	At set up.	
10.1	Check the material code is correct, and that it isn't damaged then load the material in the correct orientation.	Refer to the material code and check grain orientation. (If needed)	At set up.	
10.2	Using the set-up parameters produce a 1st off sample.	1st off sample to be approved by supervisor or QA.	1st off to master sample / known standard.	
10.3	Load the next sheet and commence the cycle.	Ensure that the machine is working correctly after gaining 1st off approval.	All.	
10.4	Unload the moulding, visually inspect and attach a date sticker on the inside.	Check for correct form, thinning and webbing etc.	All.	
10.5	Rough out the part with the bandsaw.	Ensure that no damage is caused to the moulding.	All.	
10.6	Dispose of scrap into the correct scrap bin.	Do not mix scrap. (ABS / PP / ACRY)	All.	
10.7	Store the parts safely separated by polythene ready for the next operation.	Ensure the part load is identified.	All.	
10.8	Attach a WIP label to the load.	Label with part number, quantity and date.	The load.	
ISS.	4	ISS BY A.Whelan	DATE 01/10/25	APPROVED
IF IN DOUBT ASK INSPECTION				