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| SR # | Process Name | Characteristics to be controlled | Standard  Responsibilities | Person Responsible. | Measuring Tool | Recorded On | Frequency |
| 1 | Breaking Process | 1.No hammering impression | No hammering impressions should be on the cartons | M/C Operator and Breaker | Visually | **QRCCFG / CL/04** | Regular |
| 2.Stripping | No Stripping Remain in carton | M/C Operator and Breaker | Visually | **QRCCFG / CL/04** | **Every Pile** |
| **3.Waste Carton** | **Separate waste carton marked from OP and CC** | **Breaker** | **Visually** | **QRCCFG / CL/04** | **Every Pile** |
| 2 | Window Patching Approval | 1. Type of Glue | SPCCFG/PS/ 03 | Supervisor | - | QRCCFG / CL/24 | Before Starting |
| **2. Length Of Poly -lcd** | **-** | Operator | **Visually** | **QRFG/BUFC/24** | **Before Starting** |
| **3. Size of Poly Cut-lcd** | **SPCCFG / BUC /07** | **Operator** | **Measuring Tape** | **QRCCFG / CL/24** | **Before Starting** |
| 4. Position of Cut in  **Carton** | SPCCFG / BUC / 07 | **Operator** | Measuring Tape | QRCCFG / CL/ 24 | Before Starting |
| 5. Gluing of Poly | Fiber should be delaminate with poly on Tearing | **Operator** | Visually | QRCCFG / CL/24 | Before Starting |
| **6.Slit** | **Ok/not Ok** | **Operator** | **Visually** | **QRCCFG / CL/24** | **Before Starting** |
| SR # | Process Name | Characteristics to be controlled | Standard  Responsibilities | Person Responsible. | Measuring Tool | Recorded On | Frequency |
| 3 | Window Patching Process | 1. Type of Glue | SPCCFG/PS/ 03 | Supervisor |  | QRCCFG / CL/24 | Before Starting |
| **2. Length Of Poly -lcd** |  | Operator | **Visually** | **QRFG/BUFC/24** | **Before Starting** |
| **3. Size of Poly Cut-lcd** | **SPCCFG / BUC /07** | **Supervisor** | **Measuring Tape** | **QRCCFG / CL/24** | **Before Starting** |
| 4. Position of Cut in  **Carton** | SPCCFG / BUC / 07 | Supervisor | Measuring Tape | QRCCFG / CL/ 24 | Before Starting |
| 5. Gluing of Poly | Fiber should be delaminate with poly on Tearing | Supervisor | Visually | QRCCFG / CL/24 | Before Starting |
| **6.Slit** | **Ok/not Ok** | **Operator** | **Visually** | **QRCCFG / CL/24** | **Before Starting** |
| 4 | Folding & Gluing Approval | 1.Type of Glue | SPCCFG/PS/03 | Supervisor |  | QRCCFG/ CL / 05 | Before Starting |
| 2. Folding of carton | Crease should bend on the desired place and should not crack | Supervisor | Visually | QRCCFG / CL/05 | Before Starting |
| 3. Gluing of carton | Glue flap should delaminate the board on Tearing | Supervisor | Visually | QRCCFG / CL/05 | Before Starting |
| 4. Crease Effectiveness | Crease should be uniform and prominent | Supervisor | Visually | QRCCFG / CL/05 | Before Starting |
| 5. Cut to Print |  | Supervisor | Visually | QRCCFG / CL/05 | Before Starting |

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| SR # | Process Name | Characteristics to be controlled | Standard  Responsibilities | Person Responsible. | Measuring Tool | Recorded On | Frequency |
| 5 | Folding & Gluing Process | 1.Folding of carton | Crease should bend on the desired place and should not crack | Operator | Visually | QRCCFG / CL/05 | 1 Hour |
| 2.Gluing of carton | Glue flap should delaminate the board on Tearing | Operator | Visually | QRCCFG / CL/05 | 1 Hour |
| 3.Quantity in Bundle | QRCCFG / CL / 04 | Operator | Counting | QRCCFG / CL/05 | 1 Hour |
| 4. No Bundles in CWC | QRCCFG / CL / 04 | Operator | Counting | QRCCFG / CL/05 | 1 Hour |
| 5.Quantity of cartons in CWC | QRCCFG / CL / 04 | Operator | Counting | QRCCFG / CL/05 | 1 Hour |
| 6.Printing of cartons | Printing & shade of cartons should be according to the requirement of customer | Operator | Visually | QRCCFG / CL/05 | 1 Hour |
| 7. Cut to Print | Panels of printing should be center | Operator | Visually | QRCCFG / CL/05 | 1 Hour |
| 8. Embossing | Embossing should be prominent | Operator | Visually | QRCCFG / CL/05 | 1 Hour |

AMENDMENT HISTORY

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| --- | --- | --- | --- | --- |
| REV # | DATE | PART/ SECTION | NATURE OF AMENDMENT | DONE BY |
| 7 | July 2024 | First page | Incorporation of review history | Aayesha |