

WORK INSTRUCTION

Document No.	WI-QA-004
Section	Fabric Inspection
Revision No.	00
Effective Date	Feb. 15, 2021
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Process Name	Fabric Inspection Process - STT (STT-IP100)	Objective	To guide the operator in operating STT (STT-IP100) machine for fabric (knits) inspection operation.
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User
Fabric Inspector (QC)

Previous Process

Inbound

Next Process

Unrolling

PPE



Legend



TOTAL CYCLE TIME

904 sec

Prepared by:
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GME Manager

1

Task:

TT TIME:
3 sec

Description:
Press the red switch button to turn on the power source of the machine (located at the left side of the machine).

Pinduton ang pula nga switch button para sa pag ON sa power source sa makina (makita kilid sa walang bahin sa makina).

2A

Task:

TT TIME:
43 sec

Description:
(A) Check BEC, Machine Inventory Logsheet and Machine Fabric QC checklist. (B) Switch the toggle upward to turn on the front and back light of the slanted machine table.

(A) I-check ang BEC form, Machine Inventory Logsheet ug Machine Fabric QC checklist. (B) I-switch paibabaw ang toggle para sa pag On sa atubangan ug luyo nga suga sa slanted nga table sa makina.

3

Task:

TT TIME:
41 sec

Description:
(A) Get the rolled fabric from the rack. (B) Secure the roll sticker.

(A) Magkuha ug rolyo nga fabric gikan sa rack. (B) E-secure ang sticker sa rolyo.

4

Task:

TT TIME:
35 sec

Description:
(A) Unpack the roll to be inspected and place it in the rollers located at the bottom of the machine. (B) Place plastic on the platform ready for repack.

(A) Ablihi ang rolyo para ma-inspekyon ug ibutang sa rollers nga naa sa ubos sa makina. (B) Magbutang ug plastic sa platform para ready sa pag repack.

5

Task:

TT TIME:
35 sec

Description:
(A) Open computer and click "MES" on the desktop. (B) Fill in account, password and factory to log in.

(A) I-open ang kompyuter ug i-klik ang "MES" sa desktop. (B) I-fill ang account, password ug factory aron mag log-in.

6

Task:

TT TIME:
21 sec

Description:
Enter the SP # of the roll to be inspected indicated on the roll sticker.

E-encode ang SP # sa kasam-tangan nga rolyo nga e-inspect nga naa makita sa roll sticker .

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User
Fabric Inspector (QC)

Previous Process

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PPE



Wear hairnet



Wear facemask



Wear gloves

Legend



Find / search / reading



Inspection



Safety Point



Attach Information



Storage

TOTAL CYCLE TIME

904 sec

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7

Task:

TT TIME:
23 sec

Description:

(A) Click the reference number and color of the current inspected roll. (B) Click "INSPECT" to start.

(A) I-klik ang reference number ug kolor sa kasamtangan nga ge inspeksyon nga rolyo. (B) I-klik ang "INSPECT" aron magsugod.

8

Task:

TT TIME:
55 sec

Description:

Pull the end of the fabric then cut (6" x full width) fabric sample for beginning continuity card.

Biraha ang tumoy sa fabric dayun mag putol ug (6" x full width) para sa beginning continuity card.

9

Task:

TT TIME:
7 sec

Description:

(A) Ensure that the fabric lays flat on the slanted table. (B) Press "For" forward button (C) Rotate speed setting clockwise to start inspection.

(A) Siguraduhon nga ang fabric naka flat sa slanted table, pinduton ang "For" forward button. (C) Tuyukon ang speed setting padung tuo para sa pagsugod ug inspeksyun.

10

Task:

TT TIME:
13 sec

Description:

(A) Measure fabric width at the beginning of inspection. (B) Record the actual Cut Width in the system.

Note: If discrepancy is found inform QA TL/QA Supervisor.

(A) Sukda ang gilapdon sa panapton sa sinugdanan sa pag inspect. (B) I-rekord ang aktwal nga Cut Width sa system.
Timan-e: Kung naay kalainan/kulang ipahibalo sa QA TL/QA Supervisor.

11

Task:

TT TIME:
396 sec

Description:

(A) Proceed inspection, then cut (6" x full width) fabric sample in the middle and end of inspection for continuity (also cut 4"x4" fabric sample for shade band). (B) Measure the fabric width when reached at the middle and end of inspection.

(A) Padayun sa pag inspect, dayun magputol ug (6"x full width) nga fabric sampol sa tunga2x ug kataposan sa inspeksyun para sa continuity (Mag putol ug 4"x4" fabric sampol para sa shade band). (B) Sukda ang gilapdon sa fabric kung maabot na sa tunga2x ug kataposan sa inspeksyun.

12

Task:

TT TIME:
41 sec

Description:

(A) If defect found, put QC sticker on defects for light fabrics and chalk for dark fabrics. (B) Record the defect in MES.

(A) Kung naay makit-an nga defect, butangan ug QC sticker ang defect para sa light nga fabrics ug chalk kung dark nga fabrics. (B) I-rekord ang defect sa MES.

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Unrolling				
PPE				
 Wear hairnet  Wear facemask  Wear gloves				
Legend				
 Find / search / reading  Inspection  Safety Point  Attach Information  Storage				
TOTAL CYCLE TIME				
904 sec				

13

Task:

  

TT TIME:
14 sec

Description:
(A) After inspection, check actual yards based on the counter. (B) Fill-in comment if there is a discrepancy between yards indicated in the roll sticker and actual.

(A) Igkahuman ug inspect, e-check ang aktwal nga yarda sa counter. (B) Butangan ang komento kung naay kulang tali sa yarda nga makita sa roll sticker ug sa aktwal.

16

Task:

 

TT TIME:
10 sec

Description:
Place the inspected fabric to its original rack.

Ibutang og balik ang gi inspect nga fabric sa rack.

14

Task:

  

TT TIME:
41 sec

Description:
(A) Fill-in sticker (roll#, dye#, qty.) and put it on the shade band fabric sample. (B) Fill-in QA Checked-A Grade.

(A) Igkahuman ug inspect, suwatan ang sticker (roll#, dye#, qty.) ug ibutang sa shade band fabric nga sampol. (B) Suwatan ang QA Checked-A Grade.

17

Task:

 

TT TIME:
55 sec

Description:
Forward the sample fabrics and form for shade band and continuity to sewer for sewing (4"x4") and pasting on the form. Then sewer will forward the report to in-charge for bulk approval for color evaluation.

Ihatag ang sampol fabrics ug form sa shade band ug continuity sa sewer para sa pagtahi ug (4"x4") ug sa pagpapalit ngadto sa form. Dayun ihatag sa sewer ang report ngadto sa in-charge para sa bulk approval para sa pag evaluate sa kolor.

15

Task:

  

TT TIME:
71 sec

Description:
Repack the inspected fabric then re-attach the roll sticker together with QA Checked Form.

E-repack ang ge-inspect nga fabric ug ipapalit ug balik ang roll sticker kauban ang QA Checked Form.

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