

ICS 65.160
CCS X 85

YC

**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

YC/T 480-2013

**Implementation guideline for material consumption just-in-time
control of cigarette factory manufacturing process
(English Translation)**

Issued on: January 1, 1970

Implemented on: January 1, 1970

Issued by: State Tobacco Monopoly Administration

Table of Contents

Introduction	
1 Scope	
2 Normative references	
3 Terms and definitions	
4 Cigarette factories manufacturing process management system for real time control of material consumption framework model	
General requirements 5	
5.1 Organization and responsibilities	
5.2 Approach and Objective	
5.3 Standard and System	
5.4 Human Resources	
5.5 Information System	
6 Immediate control of the manufacturing process and material consumption Example	
6.1 Implementation Process	
6.2 Identification Process	
6.3 Process Definition	
6.3.1 Direct material cost index weights in cigarette materials in heavy Definition	
6.3.2 Process indicators standard values and tolerances defined	
6.3.3 Process indicators defined instant of	
6.3.4 Process indicators defining the main responsibility	
6.4 Process Analysis	
6.4.1 Process indicators controllability analysis	
6.4.2 Analysis of process indicators to measure	
Process indicators 6.4.3 Correlation Analysis	
6.4.4 Process indicators influencing factors	
6.4.5 Process capability analysis	
5 6.5 Process Control	
6.5.1 Standard job control	
6.5.2 Key process indicators control	
6.6 Measurement Process	
6.7 Statistics Analysis	
6.8 Process Improvement	

7 Immediate control of material consumption cigarette factory information systems

7.1 Information System Design Principles

7.2 Information System functional requirements

7.3 Principle 7 material consumption information collection

7.4 Principle 7 material consumption information analysis

7.5 Information System Functional Model

8 Evaluation

Appendix A (informative) List of process indicators

Annex B (informative) evaluation form and methods of computation

Foreword

This standard was drafted in accordance with GB/T 1.1-2009 given rules.

This standard was proposed by the State Tobacco Monopoly Bureau.

This standard by the National Standardization Technical Committee on Tobacco Enterprise Technical Committee (SAC/TC144/SC4) centralized.

This standard was drafted. Hongyun Honghe Tobacco (Group) Co., Ltd., Jiangsu Tobacco Industry Co., Ltd., Sichuan Tobacco Industry Limited liability company, the Guangdong Tobacco Industry Co., Ltd., Guangxi tobacco industry limited liability company, Shaanxi tobacco industry limited liability company, the tobacco industry limited liability company Hebei, Longyan tobacco industry limited liability company.

1 Scope

This standard specifies the cigarette factory manufacturing process materials consumed immediate control of the work of the planning, organization and implementation.

This standard applies to the cigarette factory.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 18771.2 tobacco Terminology - Part 2. tobacco processing, tobacco products GB/T 18771.3 tobacco Terminology - Part 3. tobacco materials and additives GB/T 18771.4 tobacco Terminology - Part 4. Quality Assessment and testing YC/T 195 standard system of smokable material

3 Terms and Definitions

GB/T 18771.2, GB/T 18771.3, GB/T 18771.4 and YC/T 195 defined in the following terms and definitions apply this document.

Manufacturing process Cigarette production from raw material input to finished product output qualified cigarette manufacturing the entire process, including silk, cigarette and packaging. Several processes are Sub-process.

Process input Process activities necessary or related to the material or information.

Process output Conversion process results. Process output includes both physical output, but also includes information on other processes that affect output, an input process that usually enter other processes.

Note: The cigarette manufacturing process materials output includes output of qualified products, substandard goods output, the output of miscellaneous material and workmanship according to the requirements of the next process should not smoke Ash, tobacco dust, etc. stems sign.

Direct material indicator Statistics used directly in the production and constitute a part of the product material.

Loss process indicators processlossindicator it has been put into production, but can not become a statistic of finished products, the need to rework or direct reuse scrap material directly.