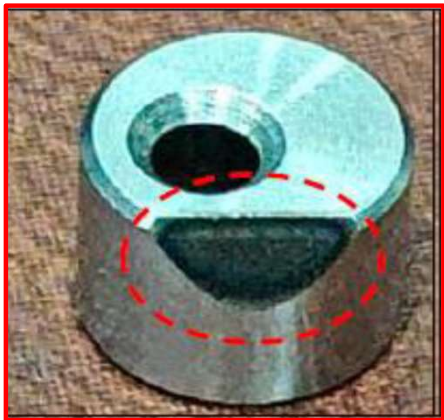


Motor Eccentric

Problem : **Surface Damaged**

- **Occurrence Cause :**
 - While Grinding process parts hit to grinding wheel caused to damaged from the holding cavity.
- **Detection Cause :**
 - Inspection method was in-adequate, group sampling inspection instead of individual parts.
 - Due to lack of awareness for visual inspection.



Action :

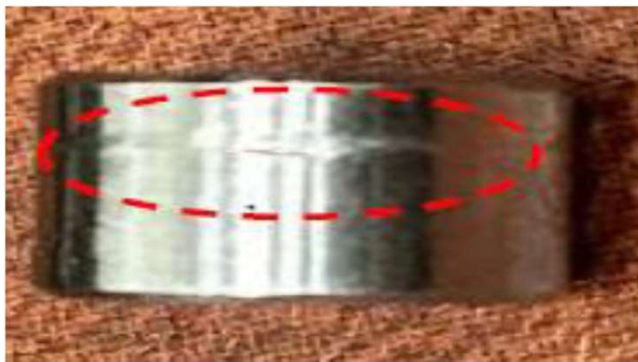
- **Occurrence Action :**
 - While grinding process top-stopper provided.
- **Detection Action :**
 - Inspection process improved with individual parts.
 - Checking method changed with magnifying glass instead of naked eye.
 - Parts V/s. Inspectors fixed.



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AB AUTO COMPONENTS

Piston Accumulator

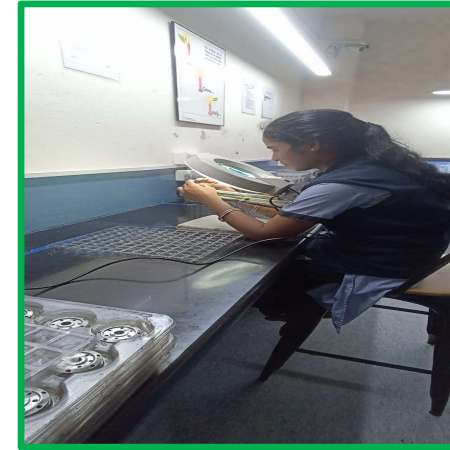
Problem : Face Unclear.

- Occurrence Cause :
- Improper facing for 1st piece of Rod, due to input rod face was uneven.
- Detection Cause :

No limit sample placed at work place as well as final inspection area.

Action :

- Occurrence Action :
- Facing process implemented to 'Rod' before loading on machine.
- Detection Action :
- Final inspection started with magnifying glass.
- Visual inspection done by dedicated person.
- 200% inspection started for visual inspection(Process stage & Final Stage).





AB AUTO COMPONENTS

Piston Accumulator

Problem : Loose Burr.

- **Occurrence Cause :**
 - Loose Burr captured during turning process.
 - Earlier using 1mm width insert
- **Detection Cause :**
 - Skipped from final inspection due to group parts inspection.

Action :

- **Occurrence Action :**
 - Existing insert planned with 2mm width to reduce process cycle time as well as such defects.
- **Detection Action :**
 - Final inspection started with magnifying glass.
 - Visual inspection done by dedicated person.
 - 200% inspection started fir visual inspection (Process Stage & Final Inspection Stage)

