ACTION EVIDENCIES---Occurrence

BEFORE

AFTER

	E.		JH	Che	ckshe	90	11	0	r	C	N	C	N	18	10	h	in	0								1	W/C	NO			į	FACTOUS Flow D1		
21.160	Fat	Stanzant	N	lethod .	Responsibility	feq				-			· ·													+		Mor	th:	Sep	- !	Few The	ra 51 34	43
nspect	on			1		-		2	1.3	4	3	1 0	1	1	19	10	11	12	13-	14	15	6 17	18	15	20]	21 2	2 21	18	IN	28	77	20 3	9 m	i
1	All Houses pipe condition	No Exercise	î	Visual	Supervisor	0	1	V	V	lu lu	VI		V	y.	1	V		1	J	J	1	12				l.								
1	All Prients & Mounting Botts	No Danage & Brakage		Vius	Supervisor	D	1	V	V	V	U	V		1	N/	V.	V	-	V	V	+	12	V	V	V	V		V	V	V	V	1	V	-
2	All there Genning nut to be change everywher 10 Nos.	Ni Carego & Bokaye	•\	Wux	Superviser	D	1	V	V	V	V	V	V	1	./	0	V	7	V	1	V	U+	V	V	V	VA	٧	V	V	V	V	1	V	
1	Hy Potture	23 to 30 ftm	(0)	Vine	Superviser	0	1	V	-	1	V	10	V	1	V	V	V	U	4		4	12	V	7	4	V	V	٧	V	V	V	V	V	-
4	Labelcotton processes	Orion mark	(6)	Violi	Operator	0	1	V	V	1	V		V	Y	V	V		V		V	1	1	V	Y	V	V 1	Y	V	٧	-	V	1	tv	1
i	clamping Fredrice	16 to 20 East	19	Value	Springer	Þ	1	V	V	V	10	-	V	7	V	V	V	V	V	1	1	1	V	V	1	1	V	٧	V	V	V	1 7	V	1
1	Coolent Flow	Marinus	(1)	Vital	Operator	0	7	V	V	100	-2	V	V	X	V	1	V	1	1	V	VV	A	×	V	V	7	V	V	V V	V	V	1	V	-
ighting									-						Y	V	V	M	4	4	1.	13	V	М	N		K		V	Y	V	4	V	
Daily 6	Oce (Tellow), VI - Weskly , V	I. Marint			Аррго	ves by			-1	J.L							1	1	T	T	T	T		1	1	-					1	12	N V	7
100	Net Oope -	- anning	-				2	3	1				+			-	_			_					-					-		110	11.0	
pecial ()	bservation if any is					8	-	=			_		27	-	_		_																	

Y.	7.K		VIII	Olici	cksh	30		JI	1	2	V	9	1	IC	L	il	11	C								M	CNO		2	Res. I	01 Danc 01 D4	N24
8z. No.	Part	Standard	N	Anthod	Acquisitely	Parq.	11	-	31	-						-	4770						MIN	100			Month	-Nov-	24	-		_
nspection	ori	_		VI I		Trace		4	0	* 1	7.1	8	4	0	-	1 10	101	17	31	4 1	5 16	17	18	19 7	21	72	23 24	25	24 3	7 28	29	30
1	All Haves page condition	No Leokage	10	Viscal	Spevie	D	4	4	* 4	1	V	V	V	1	V	14	V			T	T				F		T	П	T	T		
1	All tenerous & Mounting Boils	No Cornage & Brokuge		Visual	Supervisor	0		X	1	y	V	V	V	V	V	۰	1			1												
1	All hearts Charging nut to be change every after 10 Aco.	No Darroge & Brokage	8	Visual	Spewin	ō			y V	¢	V	V	V	V	V	X	V													1		;
3	Hy Pressure	28 to 30 Ber		Visual	Supervisor	n			1	¥	V	V	V	V	V	X	V													+		
4	Lubrodien proxim	Cireen mark	9	Visual	Operator	0			1	+	/	V	V	V	V	X	V			-								H	-			-
5	clanging Prossure	16 to 20 Bar		Visual	Supervisor	0		1	XX	1	1	V	V	V	V	X	1		1					-			1					
ē.	Coolertr Flow	Navnum	•	Veuil	Operation	p		1	× ×	-	V	V	V	V	V	X	V										+					
7	Countries	Movemen		Visual	Operator	3000	¥	XX	1	7	/	V	V	V	V	×	V	1		-					-		-		-			
lighting											+						1			-	-		+	-				П	1			
					Again	gred by										П				T	T		T	T					-			
Name and Address of the Owner, where	Once (Yellow), W - Fleekly , N	I - Monthly	, b			in the same							_							+	-			-	-	-	-	-	+	-	-	
Done +			Con	1	4																											
petial D	baervation if any (-	10	2/	-												Ī					T				Ī							

Before: Drill Re-sharpening Frequency Not defined

After: Re-Sharpening Frequency defined As to be done after every 3000 Nos.

TE:	PRO	OCESS VALIDATION		Doc No: F/PR Rev No : 01 Date : 01/05/	•	
	Name : Drill Hole Burr					
	e : CNC Machine me : J1A,J1C,J1D				Date:- 25.1	0.2024
viouei Nai	iiie : j1A,j1C,j1D	Fix Paramete	ers		Date 23.1	0.2024
Sr No				o .c		
1	Parameters RPM			Specification		
2	Cutting Speed			400 to 2000		
3	Coolant			Ianual		
			Y	es		
		Trial -360	00 Qty.			
				Observati	on	
Sr. No.	Process Condition	Specification	Visual	ID line mark	Part to part Variation drill hole Burr.	Remark
1	RPM	1400 to 2000			urm note Burr	
2	Cutting Speed	Manual	ОК	ОК	3600 Out Of 3562 OK	Obseved part 38 Part Hole burr
3	Coolant	Yes				
		Trial -34(00 Qty.			
				Observati	on	
Sr. No.	Process Condition	Specification	Visual	ID line mark	Part to part Variation drill hole Burr.	Remark
1	RPM	1400 to 2000				
2	Cutting Speed	Manual	ОК	ок	3400 Out Of 3386 OK	Obseved part 14 Part Hole burr
3	Coolant	Yes				
		Trial -320	00 Qty.			
C N	Process Constitution	Constitution		Observati	on	Dl.
Sr. No.	Process Condition	Specification	Visual	ID line mark	Part to part Variation drill hole Burr.	Remark
1	RPM	1400 to 2000				
2	Cutting Speed	Manual	ОК	ОК	3200 Out Of 3198 OK	Obseved part 2 Part Hole burr
3	Coolant	Yes				
		Trial -300	00 Qty.			
Sr. No.	Process Condition	Specification		Observati	on	Remark
31. NO.	Process condition	Specification	Visual	ID line mark	Part to part Variation drill hole Burr.	Kemark
1	Spindel RPM	1400 to 2000				
2	Cutting Speed	Manual	ОК	ОК	3000 Out Of 3000 OK	Obseved part all Part ok
3	Coolant	Yes				
Result : 1) T	he range is decided for Drill re	esharping 3000				

Verified by:

Format No : F/PROD/13, Rev No :00, Date : 01/09/2020

Approved by: