

Action plan
Dt.: 30 JUN 2022

CONDITIONS FOR OCCURRENCE


- **Phenomenon:** Total length u/s
- **Supplier:** Saptagiri Industries
- **Model:** K0LA
- **Parts name:** Inner Tube
- **Part No.:** S1GD01726B
- **Date of Occurrence:** 30. 06.2022
- **Qty NG:** 01 Nos.

● Parts Stock check results

Action


Area	Total Stock	Checked	Checking Method	NG Qty	Status
ETL Narsapura	3000	3000	Check	0	All available stock qty. verified & found OK.

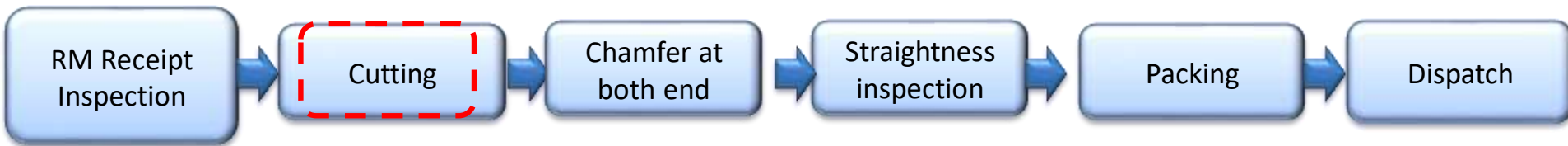
Trouble content

NG Part	OK Part
 <p>Specification: 173.3 ±0.2 mm</p>	

UNDERSTANDING OF ACTUAL CONDITION AND CONTROL

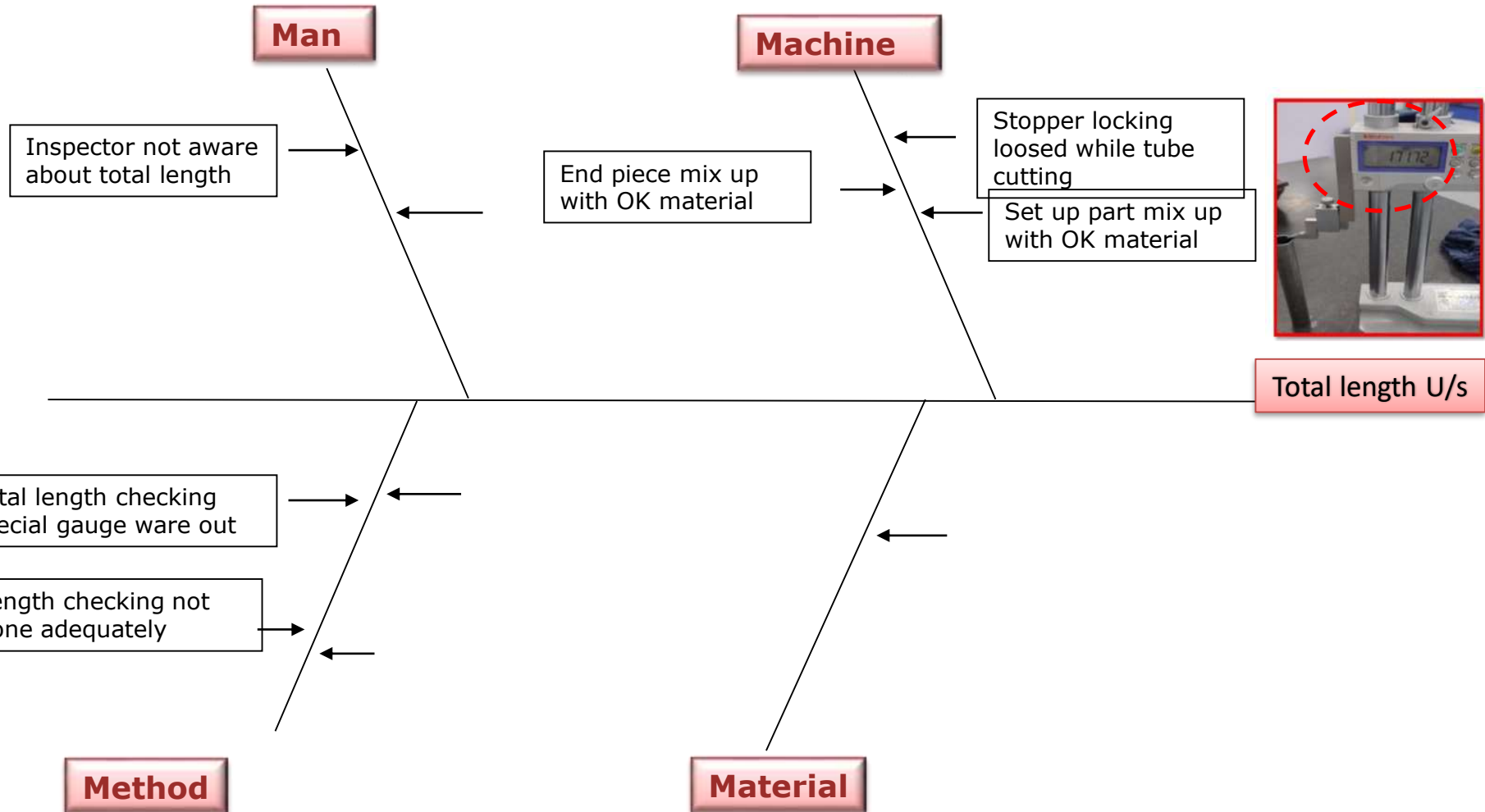
Process Flow

 Possible defect occurrence area.



UNDERSTANDING OF ACTUAL CONDITION

• Understanding the actual cause – (Factor analysis)



FACTS VERIFICATION



#	4M	PROBABLE CAUSES	FACTS VERIFICATION	Jud.
1	MAN	Inspector not aware about total length	Operator and inspector nor a aware about the total length special gauge and its operating	△
2	MACHINE	Set up part mix up with OK material	Red bin with lock and key it's missing at the machine	△
		End piece mix up with OK material	For storing end pieces one gunny bag available with identified	○
		Stopper locking loosed while tube cutting	Not loosed the stopper while tube cutting	○
3	METHOD	Total length checking special gauge ware out	Gauge verified by height gauge and its observed ok	○
		Length checking not done adequately	Length checking done adequality	○
				○
4	MATERIAL			○
				○

ROOT CAUSE ESTABLISHMENT

(WHY-WHY ANALYSIS)







• Root cause establishment (Why-Why Analysis)

	WHY – 1	WHY- 2	WHY -3	WHY-4	Why-5	Why-6
Occurrence	Total length U/s	Set up part mix up with OK material	Set up part storing bin missing	No Lock & Key for storing set up or rejected parts		
Outflow	Total length U/s	Operator not aware about total length				

Conclusion

- No Lock & Key for storing set up or rejected parts
- Operator not aware about total length

COUNTERMEASURES

	Cause	Countermeasure	Tgt. Dt.	Status
Supplier End	<Occurrence >	<ul style="list-style-type: none"> 1) Provide Lock & key Rejection storage bin. 	30-06-2022	Completed 
		<ul style="list-style-type: none"> 2) Awareness Training given to concern operator & Inspector 	30-06-2022	Completed 
		<ul style="list-style-type: none"> 3) Make SOP for Tube Cutting operation & its verification 	30-06-2022	Completed 
		<ul style="list-style-type: none"> 4) Provide the stopper slot on chamfer machine 	30-06-2022	Completed 
Supplier / ETL End	<Outflow>	<ul style="list-style-type: none"> 1) Started 100% inspection for length verification. 	30-06-2022	Completed 
		<ul style="list-style-type: none"> 2) Verify Gauge Length. 	30-06-2022	Completed 

Countermeasure taken

Operation: Chamfer

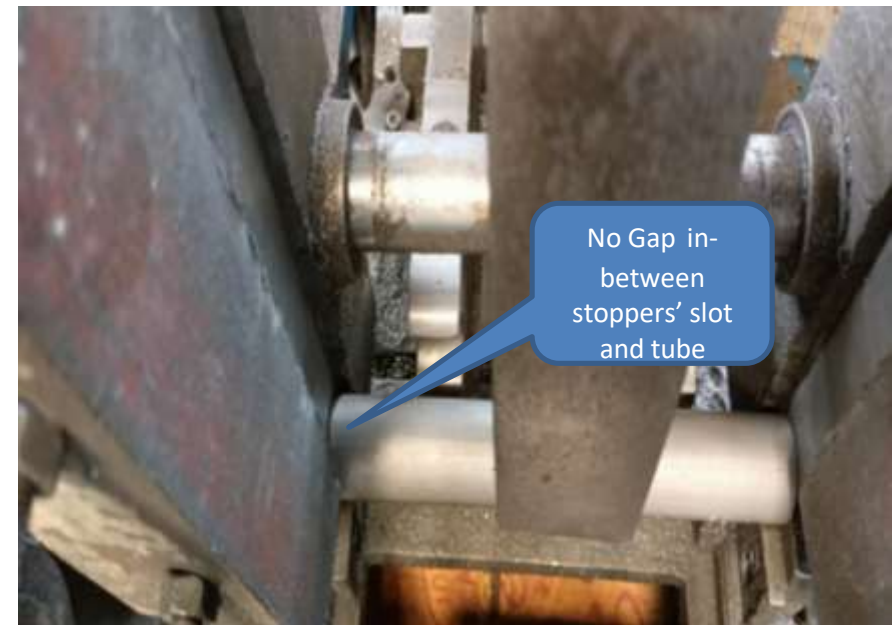
Target date: 02.08.2022

Short length tube



- Gap in-between stoppers' slot and tube

Ok length tube



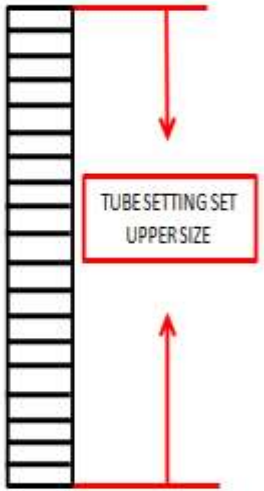
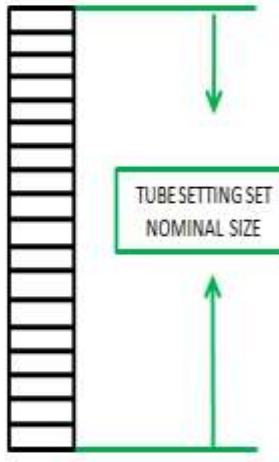
- No Gap in-between stoppers' slot and tube

OPL FOR TOTAL LENGTH VERIFICATION :

One Point Lessons

PART NAME :- INNER TUBE


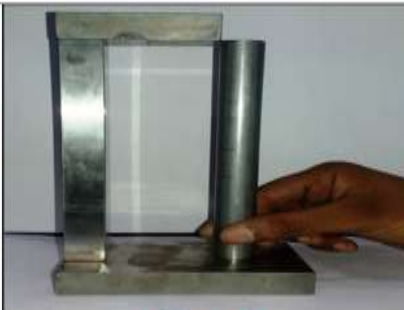

SOP

 <p>TUBE SETTING SET UPPER SIZE</p> <p>Wrong</p>	 <p>TUBE SETTING SET NOMINAL SIZE</p> <p>Correct</p>
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One Point Lessons

PART NAME :- INNER TUBE

SOP

 <p>Wrong</p>	 <p>Correct</p>
 <p>Don't push</p>	

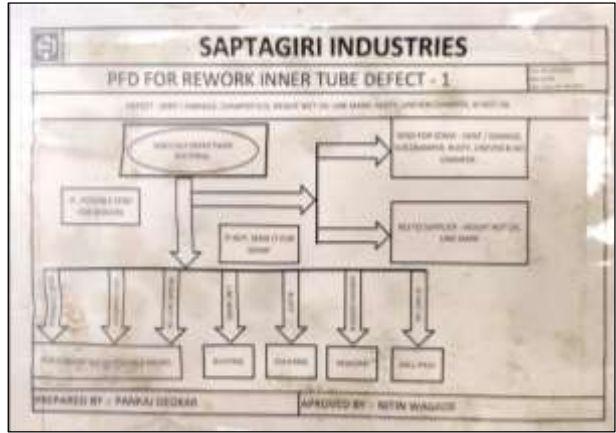
Don't push forcibly because oversize job upto 0.2 size pass when we push forcibly.



OPERATOR TRAINING RECORD:



Lock & Key bin provided at cutting machine for storing set up, & Rejected parts



SAPTAGIRI INDUSTRIES	
Sl. No.	WORK INSTRUCTIONS FOR TROUGH CUTTING
1	Ensure proper cleanliness of machine, spindle, jaw by removing burr & chips, coolant flow, setting support condition & plate
2	Set the cutting length as per model requirement mentioned in Length chart supplied on machine
3	Verify that 3 use the total length & diameter & measure observations in set up approval report
4	Remember cutting operation done on score card
5	Ensure insert tip to be changed after every 240 sec
6	Put red pieces & rejected parts in rejection bin available to machine
7	Ensure all job part to be drilled to PFD before changing work should be cutting with score card

Prepared by: _____ Approved By: _____



Made SOP of rework for the tube defects, Awareness training given to concern operator

Made SOP for Tube cutting stage, Awareness training given to concern operator

Provide the slot on chamfer machine as a poka yoke, If short length tube insert, It will not clamp and fall down at the below



THANK YOU