


ACTIONS FOR NG THREADING (Hex NUT 520FL03012)


Supplier: **Saptagiri Industries.** Operation: **Press shop / Machine shop** Implementation Date: **20.07.2022**

BEFORE


Problem/Present Status: GO not passing through out into the thread




Burr observed at ending of thread



Step mark on chamfer



Chamfer angle more that is 55 degree against 45 degree



Chamfer tool warn out

Material flow

RM RECEIPT

RM Inspection

Blanking

Pressing

Both side chamfer

Threading

Plating

Final Inspection

Packing

AFTER

- No burr on chamfer





- No Step mark on chamfer angle .

- Chamfer angle corrected as require 45 degree

- " Chamfer tool replace with new one and started

- Chamfer angle verified on profile projector

Tthread inspection sampling increases by 100 nos per 1000 nos lot

Material flow

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Both side chamfer

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Final Inspection

Packing

- Burr observed at ending of thread
- Step mark on chamfer
- Chamfer angle more that is 55 degree against 45 degree
- Chamfer tool warn out

- No burr on chamfer
- No Step mark on chamfer angle .
- Chamfer angle corrected as require 45 degree .
- Chamfer angle verified on profile projector
- thread inspection sampling increases by 100 nos per 1000 nos lot