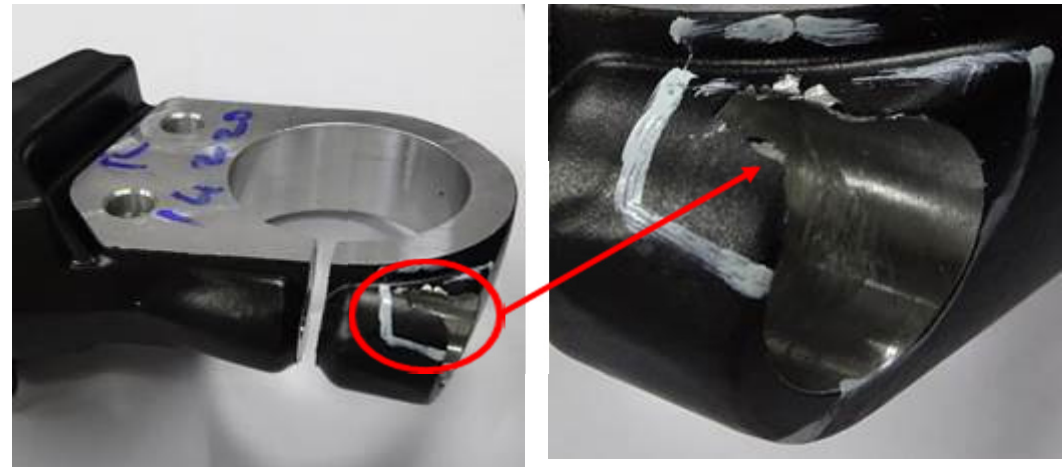


➤ **Background:-**

Wall thickness variation at Counter dia 14.0 mm in XF1C1 upper bracket

➤ **Component details:-**

As shown in image



➤ **Following process analysis carried out**

- | |
|-----------------------------|
| ▪ Casting process mapping |
| ▪ Buffing process mapping |
| ▪ Machining process mapping |
| |



WHY - WHY ANALYSIS

Step	Why-1	Why-2	Why-3	Why-4	Why-5
Occurrence	Wall thickness less due to machining shift	Machining reference taken from casting moving half.			
Out flow	Wall thickness not verified	No product knowledge	Lack of awareness	Lack of training	


Conclusion

Wall thickness getting shift due to Counter machining reference taken from moving half of casting.

Inspector not aware about wall thickness due to lack of training.

Stage	Action	Trg date	Status
Occurrence	- Machining fixture modification done.	24/3/2023	Completed
Out flow	-Training given to inspector to verify wall thickness	24/3/2023	
	- Wall thickness verification added in hourly inspection report.	24/3/2023	
	-		

Proposed action

Stage	Proposed action	Trg date	Status
Occurrence	Outer wall thickness will be increase by 0.5 mm (for safer side)	24/3/2023	

Training given to Inspector

Part Name: XF 101 / ~~XXXXXX~~ Upper 8144 Venue: Final inspection

Training subject: वैश्वविज्ञान परीक्षा

Sr.No.	Training given for	Operator Name	Sign	Effectiveness
1	XF का ब्रैकेट नोटिफिकेशन करने वाला पार्ट 2, 3 को	कुमारी निवेदी	निवेदी	
2	माला कोटिंग के लिए डिफेक्ट नोट करे।	ताम्रिष्य खन्ने	खन्ने	
3	कार्टर के वैल्यूजिफिकेशन का विशेष ध्यान रखना	कृष्णाश्याम	Krishna	
4	मार्किंग ऑपरेशन सेवे - ड्राइंग, रेडिंग, चेकर निक करे।			

Trainer: [Signature]

InFocus

Wall thickness dimension added in hourly inspection report

HOURLY INSPECTION REPORT

Part no :- F2PD021070															Date :-		
Part Name :- XF-1D1 BRACKET															Shift :-		
Parameters	Width	Width	ø41.0	ø41.0	ø22	ø28.0	ø32.0 ^{+0.1}	Counter depth	ø14.0	M8x1.25	M6x1.0 (3	ø6.647	ø4.917	Sitting 3.0	RELATIONG GAUGE	Wall 7.9	REMARK
	20.5 ±0.2	16.0 ±0.2	+0.02+0.12	+0.02+0.12	+0.140 +0.192	+0.2		5.0		(6 no's)	no's)	/6.912	/5.153	±0.3		±0.2	
Instrum ents	D.Vernier	D.Vernier	Bore Gauge	Bore Gauge	Plug Gauge	Plug Gauge	Plug Gauge	D.Vernier	D.Vernier	T.P.G	T.P.G	Pin Plug Gauge	Pin Plug Gauge	D.Vernier		D.Vernier	D.Vernier
8:00																	
9:00																	
10:00																	
11:00																	
12:00																	
1:00																	
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3:00																	
4:00																	
5:00																	
6:00																	
7:00																	

Operator Name& Sign :-

Part no :- F2PD021070															Date :-		
Part Name :- XF-1D1 BRACKET															Shift :-		
Parameters	Width	Width	ø41.0	ø41.0	ø22	ø28.0	ø32.0 ^{+0.1}	Counter depth	ø14.0	M8x1.25	M6x1.0 (3	ø6.647	ø4.917	Sitting 3.0	RELATIONG GAUGE	Wall 7.9	REMARK
	20.5 ±0.2	16.0 ±0.2	+0.02+0.12	+0.02+0.12	+0.140 +0.192	+0.2		5.0		(6 no's)	no's)	/6.912	/5.153	±0.3		±0.2	
Instrum ents	D.Vernier	D.Vernier	Bore Gauge	Bore Gauge	Plug Gauge	Plug Gauge	Plug Gauge	D.Vernier	D.Vernier	T.P.G	T.P.G	Pin Plug Gauge	Pin Plug Gauge	D.Vernier		D.Vernier	D.Vernier
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Operator Name& Sign :-

Outer wall thickness at defective area has been increase by 0.5 mm to avoid less wall thickness issue.



Thanks.....