



Defect Analysis Report

W/O- 967/0 (K19)

Part Name: Plate Clutch

Part Number: C2JT042020

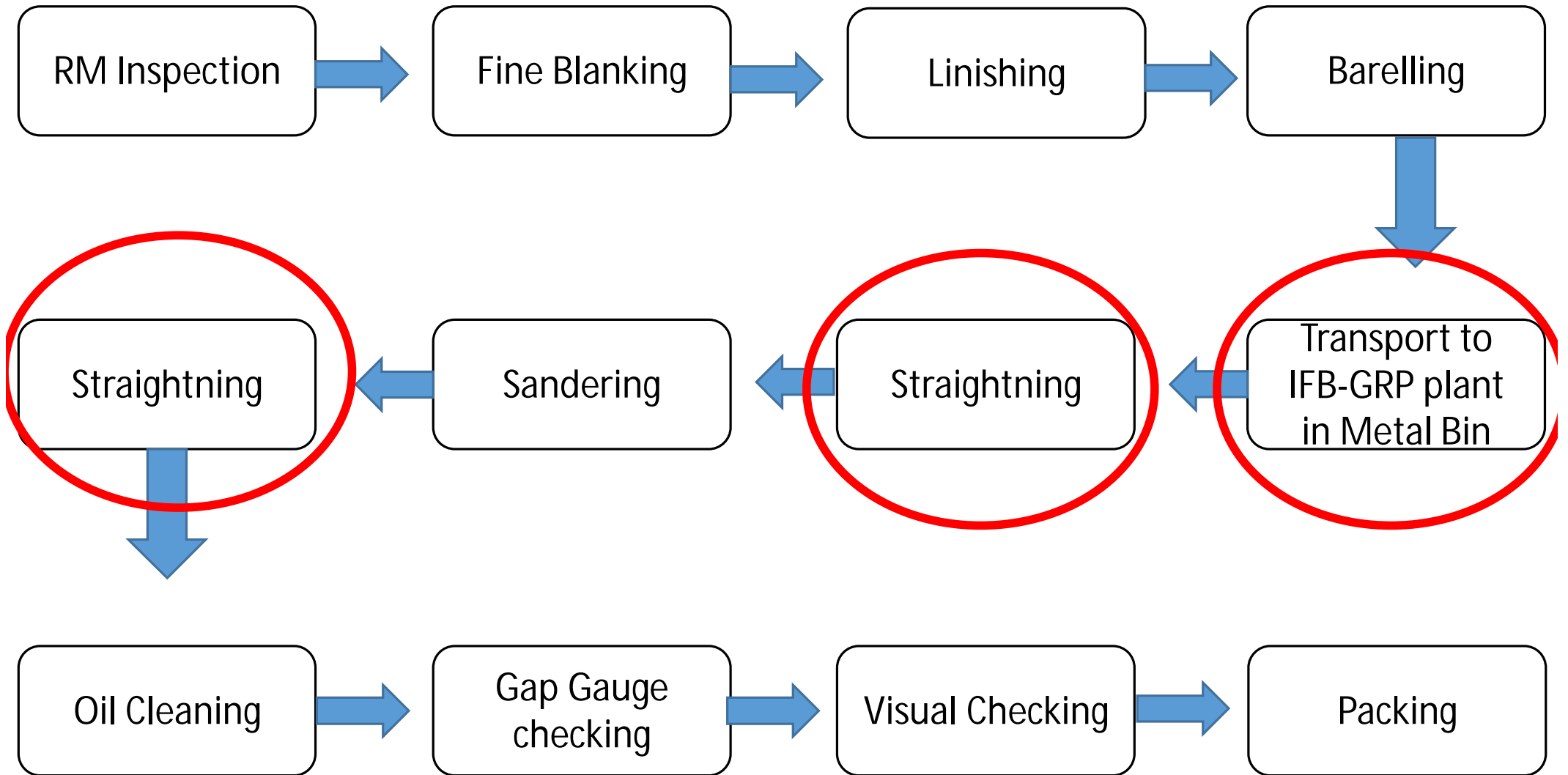
Issue detail: Teeth ID not
OK- Fitment Issue

Detail of defect



Fitment issue

Process Flow Chart



Containment Action detail

	Component Name	Total checking	Fitment issue
	PLATE CLUTCH K19	4000	1
	PLATE CLUTCH K19	3800	0
	PLATE CLUTCH K19	4000	1
	PLATE CLUTCH K19	5700	0
	PLATE CLUTCH K19	6000	0
	PLATE CLUTCH K19	6000	0
	PLATE CLUTCH K19	6000	0

Total Ware house stock and transit stock inspection running as per fitment part

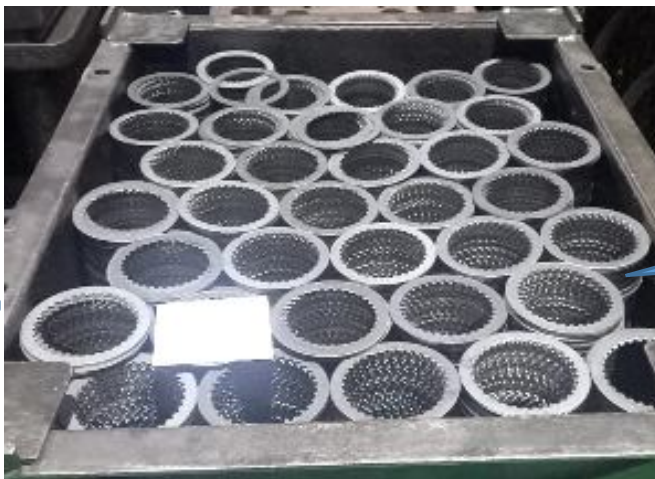
Cause of Generation

Inter plant Material movement in bin






Possibility of material bend during transportation → After getting bend same material getting straight in next straightening operation but ovality will generate at ID and OD

Action plan:- Material will be stack in bin and loose material should not be kept over.



Possibility of material bend during transportation → Eliminated

Cause of Outflow

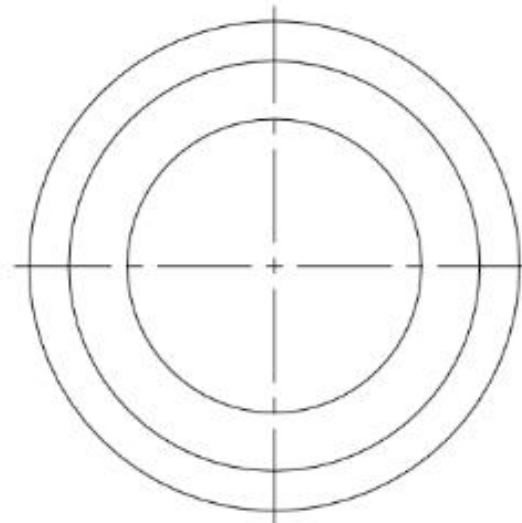
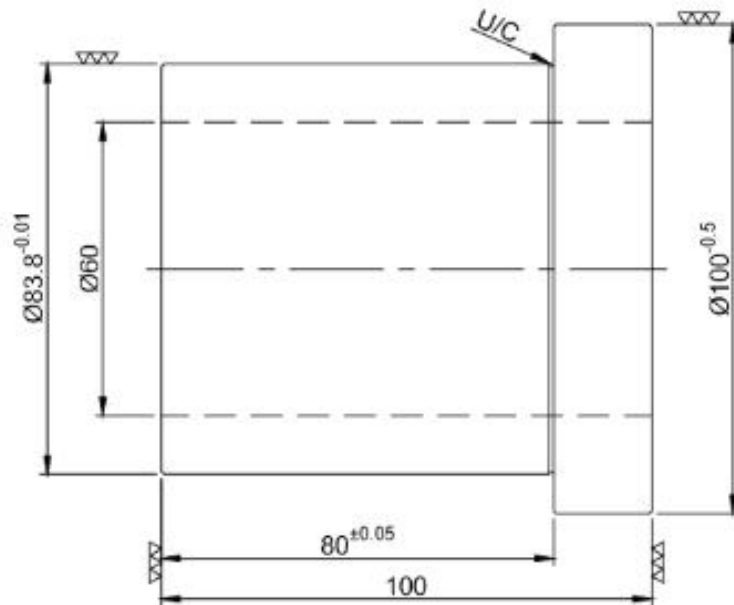
50	OILING	MANUAL	1	VISUAL DEFECTS	CLEAN WITH RP OIL	FREE OF THICK DIRTY OIL, JUST BURR, ETC.	VISUAL CHECK	10 PCS	EVERY LOT	EVERY LOT	OPERATOR	QUARANTINE THE LOT IF NOT OK	
60	STRAIGHTENING	STRAIGHTENING MACHINE	1	ROLLER CLEARANCE		FREE OF DIRT, DIRTY OIL ETC.	VISUAL CHECK	5 PCS	BEFORE SETUP / STARTING OF SHIFT / WHENEVER NECESSARY	PROCESS CONTROL SHEET	OPERATOR	QUARANTINE THE LOT IF NOT OK	
			2	LUBRICANT OIL LEVEL		AS PER OIL LEVEL INDICATOR	VISUAL CHECK		EVERY WEEK	MACHINE CHECK SHEET	MAINTANANCE		
			3	ROLLER GAP SETTING		AS PER WORK INSTRUCTION BY TRIAL METHOD	Dial Gauge		DURING MACHINE SETUP	PROCESS CONTROL SHEET	OPERATOR		
			4	FLATNESS (BOTH SIDE)		0.07	LEVER TYPE DIAL / GAP GAUGE NO: DA-890/07	5 PCS	1st OFF SAMPLE & EVERY 30 MIN INTERVAL	PROCESS CONTROL SHEET	OPERATOR		
			5	THICKNESS		1.60 ± 0.05	MICROMETER, RANGE : 0 - 25, L.C : 0.01	5 PCS	1st OFF SAMPLE		OPERATOR		
			6	OUTER DIAMETER		Φ 110 ± 0.30	DIGITAL CALIPER, L.C : 0.01	5 PCS	1st OFF SAMPLE		OPERATOR		
			7	INNER DIAMETER OF SPLINE		Φ 85.20 ± 0.30 / 0.00	DIGITAL CALIPER, L.C : 0.01	5 PCS	1st OFF SAMPLE		OPERATOR		
			8	VISUAL CHECK		FREE OF DENT, DAMAGE & ANY OTHER SURFACE DEFECT	VISUAL CHECK	5 PCS	1st OFF SAMPLE & EVERY 30 MIN INTERVAL		OPERATOR		
70	GAP GAUGING	MANUAL	1	FLATNESS (BOTH SIDE)		0.07	GAP GAUGE NO: DA-890/07	1	EVERY LOT	NO RECORD	OPERATOR	QUARANTINE THE LOT IF NOT OK	
			1		VFD SPEED	50 Hz	VISUAL CHECK	EVERY LOT	DURING SETUP & ONCE IN EVERY SHIFT				
			2		BELT GRADE (HEAD 1)		MAKE HERMES, TYPE-MERCURIT-RS 58BY, GRIT- 600	VISUAL CHECK	EVERY LOT	DURING SETUP & ONCE IN EVERY SHIFT			
			3		BELT GRADE (HEAD 2)		MAKE HERMES, TYPE-MERCURIT-RS 58BY, GRIT- 600	VISUAL CHECK	EVERY LOT	DURING SETUP & ONCE IN EVERY SHIFT			
			4		BELT LIFE		500 PCS (PRODUCT COUNTER- 2000 NOS)	VISUAL CHECK	EVERY LOT	DURING SETUP & ONCE IN EVERY SHIFT			
					BED GRINDING		FLATNESS-0.05 MAX		LEVER TYPE DIAL & HEIGHT GAUGE	AFTER 100000 PASSES	AFTER 100000 PASSES	PROCESS CONTROL SHEET	

NO control given in control plan for bend component

Cause of Outflow

New type gauge design made and 100 % inspection started in next lot production

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Why-Why Analysis- Generation

Why? Component not qualify at corresponding fitment part

Why? Component found oval

Why? Component storage by OD resting

Why? No standard defined for storage of material in bin

Action- OPL made and displayed over machine. Status- Done

Why-Why Analysis- Outflow

Why? Bend component found at customer end

Why? No inspection system defined in Control plan

Action Plan:- New type gauge need to be design and made for detection at final stage→
Status- Under process and will be implement by 8-7-2023

Temporary Action plan→ 100 % inspection by mating part started at Warehouse for in transit and warehouse stock and 100% inspection started at IFB end at final stage.



- 1> 100 % ID checking gauge to be made for Ovality checking in component → Under process →
T.Date- 7-07-2023
- 2> Component stacking system to be change from rolling to stacking → OPL to be made → Done

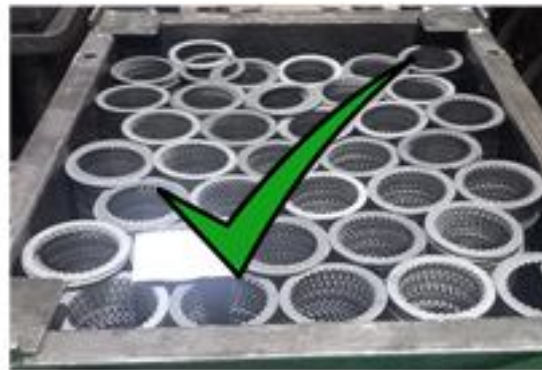
IFB

ONE POINT LESSON

COMPONENT STORAGE AFTER BARELLING



COMPONENT STORAGE AFTER BARELLING



M/C NO.	LESSON NO.	DATE		MADE BY	APPD. BY
Barelling Machine	9	06.01.2023		Giasuddin	Vijay

IFB

Thank you