

Defect Phenomenon-ID Oversize-JZ551400



Problem description:
ID Oversize up to 0.020 mm against spec:36.00/36.016

Part No.:
JZ551400, Qty: 17 no's

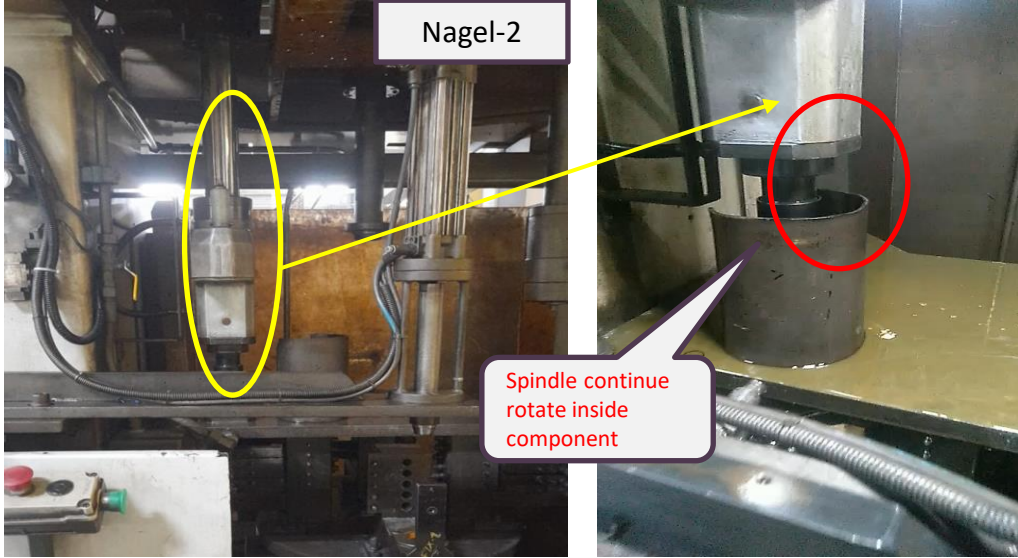
Machine: Nagel-2

6W2H Action plan																		
S,N	Part Number	Process / MC	Defect Phenomena	Defect Type	Qty	4MTGF Condition							WHY-WHY Analysis	Actions Plan	Resp	Target Date	Sustenance	Status
						Material	Man	Machine	Method	Tooling	Gauge	Fixture						
1	JZ551400	ID Honing Nagel-2	ID Oversize by 0.020 Spec:36.00 /36.016	A	17			✓					W1: Excess material removed from ID. W2: Ledges not retract to original position after expansion. W3: Spindle not retract to up, and continuously rotating inside component. W4: Spindle relay malfunctioning	Inspection side: 100 % Inspection with Air gauge. Cause Side: 1.Spindle relay replaced and machine under observation. 2. Check point added in TBM Check sheet	ADK	14.12.2023	PM	Under Observation

Defect



Observations



Action

1.Spindle relay replaced.

Effectiveness

Effectiveness under monitoring