



Abnormal conditions	Reaction of operator	Reaction of shift in-charge(supervisor)	Reaction of maintenance & Tool room engineer	Reaction of inspector -In process QA	Reaction of HOD
Escalation system time line (Information to next level when problem not solving at each level)	If failure not solved within 5 to 15 minutes inform to respective dept, shift in charge)	If failure not solved within 15 to 25 Minutes inform to respective dept-HOD.			If failure not solved within 25 to 40 minutes inform to plant head.
1. In case of power cut	1.Stabilizer ON . 2 .Machine ON . 3.Check the tool position in machine. 4.Inform the shift in-charge (supervisor/Experience operator).	1. See the cutting tool position . 2. Check the cutting tool <u>or</u> insert condition. (Tool broken or tool ok). 3. If the part found damaged, mark defect and put in rejection bin .	System related failure call the service engineer.	1. Check the first off. 2.Change point recorded in 4M check sheet. 3.Reactions recorded in 4M check sheet. 4.Rejection (scrap) parts Qty, recorded in 4M check sheet.	Check the problem condition ,if not solved within 25 to 40 minute inform to plant head.
2.Component fallen on floor.	1. If fallen part <u>found damaged</u> mark defect and put in rejection bin. .	NA	NA	1.Change point recorded in 4M check sheet. 2.Reactions recorded in 4M check sheet. 3.Rejection (scrap) parts Qty, recorded in 4M check sheet.	NA
3.Gauge / Measuring instrument failure.	1.Inform the shift in-charge (supervisor) .	1.Suspected parts segregation and tagging. 2.Inform the Q.C.Inspector.	NA	1.Reset the measuring gauges (Air plug gauge and Bore gauge,TPG). 2.Reset is not possible, replace the new gauge. 3.Gauge repair & calibration out source. 4. Suspected parts check 100% with new gauge. 5.Change point recorded in 4M check sheet. 6.Reactions recorded in 4M check sheet. 7.Total checked Qty / Rework / Rejection (scrap) parts Qty, recorded in 4M check sheet.	1.In case stock level of measuring gauges not available in house , Inform the plant head re-ordering the failure gauge.
4.Poka yoke failure.	1.Inform the shift in-charge (supervisor) .	1.Stop the line till the failed poka yoke get corrected & verified. 2.Suspected parts segregation and tagging. 3. Affected product characteristic are identified & verified. 4.Inform the maintenance engineer.	1.Check the machine (identified the problem). 2.Repair the machine parts / Replace the parts if required. 3.If not able to correct,call the service engineer to solve the problem. 4.After correction of abnormality ,take preventive action and implement to avoide reoccurrence.	1.Verification with GO-NOGO master conducted after correction (5 times each) 2.Suspected parts check 100%. 3.Change point recorded in 4M check sheet. 4.Reactions recorded in 4M check sheet. 5.Total checked Qty / Rework / Rejection (scrap) parts Qty, recorded in 4M check sheet.	Check the problem condition ,if not solved within 25 to 40 minute inform to plant head.

