

ANANT ENTERPRISES

ABNORMAL SITUATION HANDLING PROCEDURE

AE/PRO/ASHP REV - 01

DATED :- 15/03/2024

| 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 w | 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). | See the cutting tool position. Check the cutting tool or insert condition. (Tool broken or tool ok). If the part found damaged, mark defect and put in rejection bin . | System related failure call the service engineer. | Check the first off. Change point recorded in 4M check sheet. Reactions recorded in 4M check sheet. 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</u> <u>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 | | | | |
| | 1.Inform the <u>shift in-charge</u> (supervisor). | 1.Suspected parts segregation and tagging.2.Inform the Q.C.Inspector. | NA | Suspected parts check 100% with | Inform the plant head re-ordering | | | | |
| 14 Poka voke failure | 1.Inform the <u>shift in-charge</u> (supervisor). | Stop the line till the failed poka yoke get corrected & verified. Suspected parts segregation and tagging. Affected product characteristic are identified & verified. Inform the maintenance engineer. | 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 | naster 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, | Check the problem condition ,if not solved within 25 to 40 minute inform to plant head. | | | | |

| 5.Tool or Fixture part breakage or damaged during oparation. | 1.Inform the shift in-charge (supervisor). | 2. Suspected parts segregation and tagging. 3. Broken tool & fixture part is removed from line & scrapped. 4. Replace the cutting tool & fixture parts. 5. Verification with GO/NOGO master | Fixture part available replace the fixture part. 3.Not available of fixture parts ,immediate material ordered and | 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. |
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| _ | 1.Inform the <u>shift in-charge</u> (supervisor). | 1.Stop the line till the machine breakdown get corrected . 2.Suspected parts segregation and tagging. 3.Breakdown machine/test rig have "Breakdown" tag attached. | 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 reoccurance. | correction (5 times each) 2. Suspected parts check 100%. 3. Change point recorded in 4M | Check the problem condition ,if not solved within 25 to 40 minute inform to plant head. |
| Iner quality alert rule & Daily | 1.Inform the shift in-charge (supervisor). | 1.Stop the machine. 2.Inform the HOD. | NA | 1. All CFT Analysis the causes & take required action. 2. Conduct SPC. | Check the problem condition ,if not solved within 25 to 40 minute inform to plant head. |
| 8.Unplaned / unexpected operator deployed on line due to regular operator got sick/absent suddenly | NA | 1.Training given to operator,part loading /unloading ,explain process sequence,work instruction,check points,critical product characteristics. | NA | • | 1.Observe,verify& approve operator's understanding/working. |