

MAP ALLOYS

Action plan for CALIPER BODY INTEGRAL

TYPE PULSAR blow hole and dent

"Damage



Part Name: - CALIPER BODY INTEGRAL TYPE PULSAR

Part No:- 520BK01573

Defect:- Blow hole, Dent and Damage observed at ETL end.

Qty :- 1258 Nos.



Caliper body integral type pulser-Blow hole



Date: 14.08.2024

Endurance Technologies Ltd. (Disc Brake Division) K-226/2, M.I.D.C., WALUJ, AURANGABAD

Action Plan - 6W2H

								Н	eu te De					Kemark:- (Aplicable
5.		ULATA	ra Which	Why Hou Mack		Tarqet	Inspection Side		Caura Sida		VL.	¥1		ty of IPP, lot
H=				,	/ Heay		Bafara	After	Bafura	After				handling, ak/MG lay traciabilit
1	Blow hole	At ETL	Caliper	Why 1- Blow	548 Nos	Zero	Blow holw in	Limit sample	Blow hole in casting.	1. Pouring height	1	1.13.08.2024	1.Completed	
		end	body	hole observed in			casting (No	displayed and		corrected by	Mr. P.D			
			integral	casting.			Limit sample	100% inspection		pouring bowl	Patil			
			type	Why2: Air			displayed)	with dot mark		leveling done				
			pulser	intruption in				for 3		to			2.ICompleted	
				cavity during				consecutive lot.		avoid turbulence		2.14.08.2024		
				metal pouring .						during metal	2.			
										pouring inside	Mr.			
				Why3:						cavity and	P.N.Patil			
				Turbulence						standardised .				
				during metal						2.On job trainiing				
				pouring						provided and				
				Why4:						Monitoring				
				Pouring height						started for				

pouring height.

Reviewed By CET	HOD-ME	θV	PURCHASE	MAINT	PROD
Signature	Mr S K Dach	Mr.Manish Kolte	Mr.Sonu	Mr.Rakesh	Mr.B.S.Mandape

Note- Check whether applicable documents are reviewed after taking actions

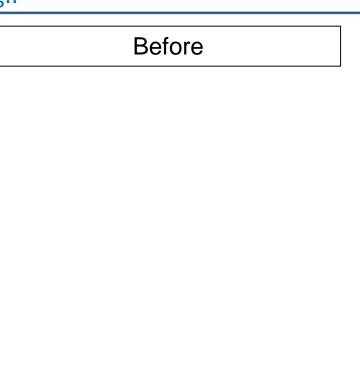
is excess.

Documents Review) (Process Flow Diagr	PFMEA	Control Plan	ork Instructio	Other Documents
States				I .	Quality Alert displayed

Approved BY						
Criteria	Approving Authorite	Sign				
Safety Concern	Plant Head	Mr.S.K.Dash				
Dim. Concern other than safety	cern QA Head	Mr.Manish Kolte				
Appearance.	Asst Mgr	Mr.Rajesh Pandey				



For Blow hole metal pouring height corrected to avoid turbulence during metal pouring..





Pouring height corrected to avoid turbulence during metal pouring

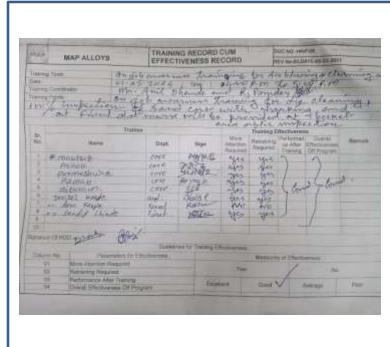




On job training provided to operator for maintain pouring height

On job training record





Action Plan - 6W2H

			Ho	₩ to Do					Remark:-
How Much /	Target	Inspecti	on Side	Caus	e Side	Who	When	Status	(Aplicablity of IPP, lot
Ману		Before	After	Before	After				handling. ok/NG loy traciability)
1258 Nos	Zero	No limit sample displayed at final and Fettling area.	Limit sample displayed at Final and Fettling area.	Dent and Damage all around casting.	training provided to shop floor working person 2. Storage method improved . 3.PP sheet and New trollies will	2. Mr. P.D. Patil/Mr.P N Patil 3.Mr. P.D.		1.Completed 2.Completed 3.Inprocess	Improved lot to be dispatch to ETL 22.08.2024

QA	PURCHASE	MAINT	PROD	
Mr. Manish Kolte	Mr.Sonu	Mr. Avinash	Mr.P.D.Patil	

ents are reviewed after taking actions

PFMEA	Control Plan	rk Instructio	ther Documents

Approved BY					
Criteria	Approving Authority	Sign			
Safety Concern	Plant Head	Mr.SK Dash			
Dim. Concern other than safety	QA Head	Mr. Manish Kolte			
Appearance.	Asst Mgr	Mr.Rajesh Pandey			



Casting handling for Dent and Damage after on job training.

Before Casting handling before on job training

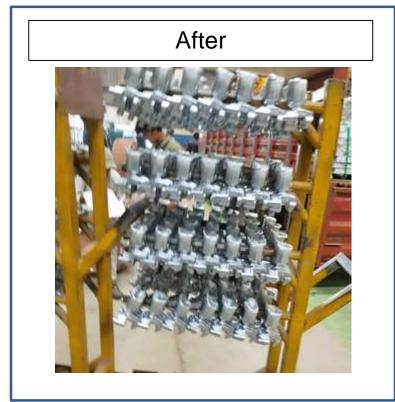


Material handling as well as material storage improve at fettling area.



Casting handling after on job training.





Casting handling before

Casting handling after



THANK YOU