

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.



Action plan for blow hole ,dent and damage in caliper body integral type pulser

Caliper body integral type pulser-Blow hole

 Endurance Technologies Ltd. (Disc Brake Division) K-226/2, M.I.D.C., WALUJ, AURANGABAD														
Action Plan - 6W2H														
Date: 14.08.2024														
S. No	What	Where	Which	Why	How Much / Many	Target	How to Do				Who	When	Status	Remark:- (Applicability of IPP, Int handling, M/MG lay traceability)
							Inspection Side		Course Side					
							Before	After	Before	After				
1	Blow hole	At ETL end	Caliper body integral type pulser	Why1- Blow hole observed in casting. Why2: Air intrusion in cavity during metal pouring . Why3: Turbulence during metal pouring Why4: Pouring height is excess.	548 Nos	Zero	Blow hole in casting (No Limit sample displayed)	Limit sample displayed and 100% inspection with dot mark for 3 consecutive lot.	Blow hole in casting.	1. Pouring height corrected by pouring bowl leveling done to avoid turbulence during metal pouring inside cavity and standardized . 2.On job training provided and Monitoring started for pouring height.	1. Mr. P.D Patil 2. Mr. P.N.Patil	1.13.08.2024 2.14.08.2024	1.Completed 2.ICompleted	

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

Note- Check whether applicable documents are reviewed after taking actions

Documents Review	(Process Flow Diagram)	PFMEA	Control Plan	Work Instruction	Other Documents
Status					Quality Alert displayed

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

Action plan for blow hole ,dent and damage in caliper body integral type pulser

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

Before

After



Pouring height corrected to avoid turbulence during metal pouring

Action plan for blow hole ,dent and damage in caliper body integral type pulser

On job training provided to operator for maintain pouring height

On job training record



MAP ALLOYS		TRAINING RECORD CUM EFFECTIVENESS RECORD		DDO NO. /HR/08 REV. No. 03/DATE: 05-05-2011		
Training Topic:		Single operator training for maintaining & cleaning a				
Date:		21-05-2012				
Training Coordinate:		Mr. Anil Thande and R. Pandey				
Training Dept:		No. of operators training for this cleaning & 11% inspection of sand cover with 0.1mm sieve and at least 0.1mm sieve will be provided at 1 packet and after inspection				
Sl. No.		Trainee		Training Effectiveness		Remarks
Name	Dept.	Sign	More Attention Required	Performance of After Training	Quality of Program	
1	Mr. Anil Thande	core	[Signature]	Yes	Yes	Good
2	Mr. R. Pandey	core	[Signature]	Yes	Yes	
3	Mr. Anil Thande	core	[Signature]	Yes	Yes	
4	Mr. R. Pandey	core	[Signature]	Yes	Yes	
5	Mr. Anil Thande	core	[Signature]	Yes	Yes	
6	Mr. R. Pandey	core	[Signature]	Yes	Yes	
Signature of HOD:		[Signatures]				
Satisfactory to Training Effectiveness						
Sl. No.	Parameters for Effectiveness			Maturity of Effectiveness		
01	More Attention Required			Yes		
02	Maintaining Required			No		
03	Performance After Training			Excellent	Good <input checked="" type="checkbox"/>	Average
04	Overall Effectiveness of Program			Poor		

Action Plan - 6W2H

How Much / Many	Target	How to Do				Who	When	Status	Remark:- (Applicability of IPP, lot handling, ok/NG log traciability)
		Inspection Side		Cause Side					
		Before	After	Before	After				
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.	1.For material handling on job training provided to shop floor working person . 2. Storage method improved . 3.PP sheet and New trollies will be provided to improve material handling.	1. Mr. R.Pandey /Mr.P.D Patil 2. Mr. P.D. Patil/Mr.P N Patil 3.Mr. P.D. Patil/Mr.P N Patil	1.14.08.2024 2.14.08.2024 3.31.08.2024	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

Plans are reviewed after taking actions

PFMEA	Control Plan	Work Instructions	Other Documents

Approved BY		
Criteria	Approving Authority	Sign
Safety Concern	Plant Head	Mr. S.K 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

After



Casting handling after on job
training

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

Action plan for blow hole ,dent and damage in caliper body integral type pulser

Casting handling after on job training.

Before



Casting handling before

After



Casting handling after

THANK YOU