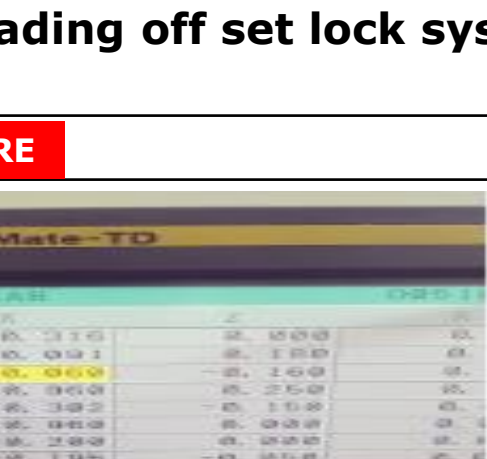
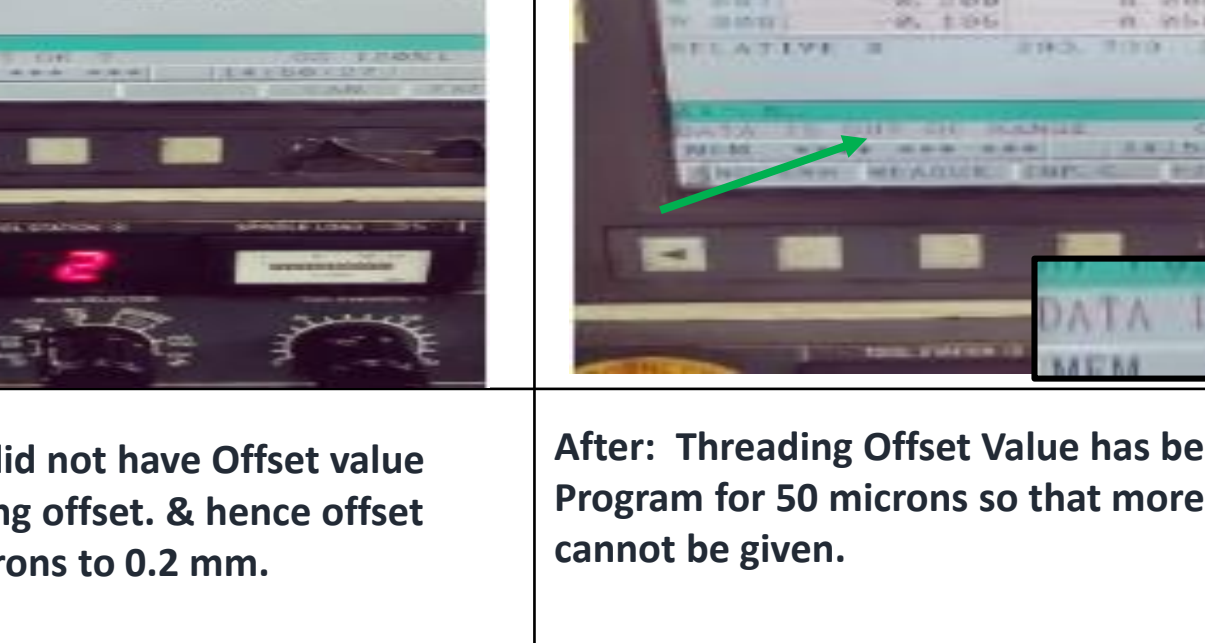


Action Plan Evidence – Threading minor dia.under size

Plant/Shop : M/s Accrete Pvt. Ltd. (T I)

Implementation—03-07-2024

Impl.-CNC Program threading off set lock system.

BEFORE	AFTER																																																																								
 <table border="1"><thead><tr><th>NO.</th><th>X</th><th>Z</th><th>Q</th></tr></thead><tbody><tr><td>W 001</td><td>0.310</td><td>0.000</td><td>0.0000</td></tr><tr><td>W 002</td><td>0.001</td><td>0.100</td><td>0.0000</td></tr><tr><td>W 003</td><td>0.000</td><td>-0.100</td><td>0.0000</td></tr><tr><td>W 004</td><td>0.000</td><td>0.200</td><td>0.0000</td></tr><tr><td>W 005</td><td>0.300</td><td>-0.100</td><td>0.0000</td></tr><tr><td>W 006</td><td>0.000</td><td>0.000</td><td>0.0000</td></tr><tr><td>W 007</td><td>0.200</td><td>0.000</td><td>0.0000</td></tr><tr><td>W 008</td><td>0.100</td><td>-0.000</td><td>0.0000</td></tr></tbody></table> <p>560 INPUT OK ?</p>	NO.	X	Z	Q	W 001	0.310	0.000	0.0000	W 002	0.001	0.100	0.0000	W 003	0.000	-0.100	0.0000	W 004	0.000	0.200	0.0000	W 005	0.300	-0.100	0.0000	W 006	0.000	0.000	0.0000	W 007	0.200	0.000	0.0000	W 008	0.100	-0.000	0.0000	 <table border="1"><thead><tr><th>NO.</th><th>X</th><th>Z</th><th>Q</th></tr></thead><tbody><tr><td>W 001</td><td>0.310</td><td>0.000</td><td>0.0000</td></tr><tr><td>W 002</td><td>0.001</td><td>0.100</td><td>0.0000</td></tr><tr><td>W 003</td><td>0.000</td><td>0.100</td><td>0.0000</td></tr><tr><td>W 004</td><td>0.000</td><td>0.200</td><td>0.0000</td></tr><tr><td>W 005</td><td>0.300</td><td>0.100</td><td>0.0000</td></tr><tr><td>W 006</td><td>-0.100</td><td>0.000</td><td>0.0000</td></tr><tr><td>W 007</td><td>0.200</td><td>0.000</td><td>0.0000</td></tr><tr><td>W 008</td><td>0.100</td><td>0.000</td><td>0.0000</td></tr></tbody></table> <p>DATA IS OUT OF RANGE</p>	NO.	X	Z	Q	W 001	0.310	0.000	0.0000	W 002	0.001	0.100	0.0000	W 003	0.000	0.100	0.0000	W 004	0.000	0.200	0.0000	W 005	0.300	0.100	0.0000	W 006	-0.100	0.000	0.0000	W 007	0.200	0.000	0.0000	W 008	0.100	0.000	0.0000
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<p>Before: The CNC Program did not have Offset value interlocking to give threading offset. & hence offset could be given from 10 microns to 0.2 mm.</p>	<p>After: Threading Offset Value has been locked in the CNC Program for 50 microns so that more than 50 micron offset cannot be given.</p>																																																																								