ACTION EVIDENCIES---Occurrence

BEFORE

AFTER

```
ROGRAM(WORD)
                                          00608 N00000
//CNC_HEM/USER/PATH1/
                          (FG-EDIT)
00608 ;
                                     601 X33.00 F0.18 ;
M88 :
                                     G0 X43.00 W1.0 ;
                                     GØ ZØ. Ø ;
T0101 :
                                    601 X33.00 FO.18 ;
692 52000 :
                                    G0 X43.00 W1.0 ;
696 S188 MB3 ;
                                    G00 X34.00 ;
                                    601 20.5 FO. 16 ;
68 X100.0 ;
                                    601 X38. 10 FO. 16 ;
GB 250.8 :
                                    601 X40. 0 Z-0. 8 F0. 16 ;
 60 X44.00 ;
                                    601 X48.00 Z-4.85 FB.18 ;
 60 Z10.0 ;
GB Z3.88 ;
                                    601 X41. 20 Z-6. 00 F0. 16 ;
GB Z1.6 ;
                                    X44.00 ;
601 X33, 00 FB. 16;
GB W1. 8 :
                                    2-7.00 ;
68 X43.00 ;
                                    601 2-10.60 FB. 18 ;
68 28.8 :
                                    G01 X41, 28 Z-10, 48 F0, 18 ;
                                    601 X39, 965 F0, 18 ;
```

```
ROGRAM(WORD)
//CNC_HEM/USER/PATH1/
                            (FG-EDIT)
                                        601 X33.00 FO.18 ;
09698 ;
                                        60 X43.00 W1.0 ;
H88 :
                                        GØ ZØ. Ø ;
 N1 :
                                        G01 X33, 00 F0, 18 ;
 T8181 :
                                        60 X43.00 W1.0 ;
 692 S2000 ;
                                        600 X34.00 ;
 696 S180 M03 ;
                                        601 20.5 FO.16 ;
 M10 ;
 G8 X100.0 :
                                        601 X38, 10 F0, 16 ;
  60 250.0 ;
                                        G01 X40.0 Z-0.8 F0.16 ;
  60 X44.00 :
                                         601 X40.00 Z-4.85 FO.18 ;
  G8 Z18.8 ;
                                         G01 X41. 20 Z-6. 00 F0. 16 ;
   60 23.00 :
                                         X44.80 :
   60 21.6 ;
   681 X33.88 FB.16 ;
                                         2-7.00;
   68 W1.8 ;
                                         601 Z-10.60 FO.16 :
   68 X43.88 ;
                                         601 X41. 20 Z-18. 40 F8. 16 ;
    68 28.8 ;
                                         601 X39, 965 F0, 16 ;
```

Erlier Feed Value was defined 0.18 Inch/Min

Feed Value Changed 0.16 Inch/Min

ACTION EVIDENCIES---Occurrence

BEFORE

Sankles :	. 70		RST FIVE PIEC						Date :	10 7.91	Format no	F/QA/02
Machine : Org. Rev	22 XE								Shift:	12-5-24	Rev. date	01.12.23
art No :	F2FA10933M								Part	J1A	Rev. no	02
perator lame :	First Five Piece											
Sr. No	Product Parameter	Spec.	Measurement Method	1 2 3 4 5				Remark	Process Parameter	Specification	Observation	
1	Total Length	555 ±0.2	Height Gauge	555.08	555.06	555.01	55512	55518	OK	Spindle RPM	2000 to 2600	2500
2	Coulking ID	37 -0.05	Plug gauge	OL	on	OIL	ou	on	OL	Cutting speed	220 to 240	240
3	Coulking ID depth	47.9 +/- 0.1	PPG Depth Gauge	OK	OK	Ou	OK	OL	04	Feed rate - mm/ revolution	0.18	0.18
4	Threading	M38X1-6H	Thread Gauge	OK	ou	ou	OK	OL	or	Hydraulic Pressure	28 ~ 30 Bar	29
- 5	Caulking Side Run Out	0.1 max	Dial gauge with fixture	0.09	80.0	01	01	011	Ok	Clamping pressure -	18~20 kg/cm2	20
6	Caulking Side OD	39.94 to 39.97	Snap Gauge/Micrometer	OŁ	OK	OL	Ok	ac	an	Spindal assymbly runout RH side	0.05max	0'05
7	Caulking Side groove OD	39.8 -0.1	Snap Gauge/ vernier	BL	OK	OK	OK	OK	04			
8	Dimn	8.5+0.5	Height Gauge	6.56	8.59	8.2	8:56	8.25	6.26			
9	width	20 .00 -0.15 / -0.05	Vernier/SANP GAUGE	6 K	DIL	OK	OK	OK	OK			
10	Deo bush od Run out	0.1	Dial gauge with fixture	0.09	0'1	800	0'09	3'1	009			
11	Treading side Run out	0.1	Dial gauge with fixture	0.09	0'1	30.0	01	0.09	0.1			
12	ID *	38.2+0.1/-0.05	plug gauge/Bore Gauge	OK	OK	OL	OK	OK	or			
13	ID Depth	20.00 +0.5	Depth Plug Gauge/Vernier	20:14	20.18	20.12	20'19	2016	2012	-		
14	Threading depth	24+1	vernier	24.36	24.32	24.61	2452	24.51	24-61			
15	Rusty, damage, burr	Visual	Eye	OK	OLL	OK	OL	OL	du			
Sr.no	Rev. ditails		Rev. No	Rev date								
1	Spindal assymbly runout inspection		01	01.08.22								
	Du Bush Od Ra inspec	02	10.05.23				. λ		2			
2	Caulking ID Ra inspection added		32	20.03.23				all		Showe	1	

ACTION EVIDENCIES---Occurrence

AFTER

(P)		FIRS	T FIVE PIEC	E CUN	INSF	ECTIC	N CHE	CK SH	IEET	(After)	
					· ·				Date:	26107124	Format no	F/QA/02
enabline t	C.N.C - 22								Shift:	Izr	Rev. date	01.08.24
Nachine :	XE								Part	JIA	Rev. no	03
Org. Rev	F2FA10933M								17.455			
Operator Name :				First Five Piece						Process Parameter	Specification	Observation
Sr. No	Product Parameter	Spec.	Measurement Method	1	2	3	4	5	Remark		2000 to 2600	2400
	T will swath	555 ±0.2	Height Gauge	555.16	555.14	555.18	555-18	555.20		Spindle RPM	220 to 240	232
1	Total Length	37 -0.05	Plug gauge	OK	OV	OVL	OL	01/2		Cutting speed Feed rate - mm/	0.16	0.16
2	Coulking ID Coulking ID depth	47.9 +/- 0.1	PPG Depth Gauge	OK	OL	OL	OV	04/480	0	revolution	28 ~ 30 Bar	29
3	Threading	M38X1-6H	Thread Gauge	OL	OL	ou	OY	OIL		Hydraulic Pressure	18~20 kg/cm2	19
4	Caulking Side Run Out	0.1 max	Dial gauge with fixture	0.070	0.060	0.070	0.080	0.060		Clamping pressure Spindal assymbly	0.05max	0.05
6	Caulking Side OD	39.94 to 39.97	Snap Gauge/Micrometer	39.954	39.964	89.950	39 959			runout RH side	U.USIIIax	
7	Caulking Side groove	39.8 -0.1	Snap Gauge/ vernier		39.76	39.78	39-76	39.72				
8	OD Dimn	8.5+0.5	Height Gauge	8.64	8.70	8.69	8.68	8.68				
9	width	20 .00 -0.15 / -0.05	Vernier/SANP GAUGE	XCO	OV	OV	OIL	OV.				
10	Deo bush od Run out	0.1	Dial gauge with fixture	0.050	0.040	0.050	0.040					
11	Treading side Run out	0.1	Dial gauge with fixture	0.090	0.090	0-080	0.090		0.			
12	ID	38.2+0.1/-0.05	plug gauge/Bore Gauge	OVL	on	OV	OV	OIL				
13	ID Depth	20.00 +0.5	Depth Plug Gauge/Vernier	20.32	30.84	20.38	2040	20.31				
14	Threading depth	24+1	vernier	24-74	24.76	5 24-62	,	0 24.8				
15	Rusty, damage, burr	Visual	Eye	OL	OK	ON	DIL	OV				
Sr.no	Rev. ditails		Rev. No	Rev date	2							
1	Spindal assymbly runout inspection Du Bush Od Ra inspection added		01	01.08.2	2							
			02	10.05.2	3			1		1)	,	
2	Caulking ID Ra inspection added			Tool of the second				A		and		
3	CNC Food rate Povis	ed- 0.16 mm/ Revolution	03	25-7	1-24			Superviso		QC Engine	er	