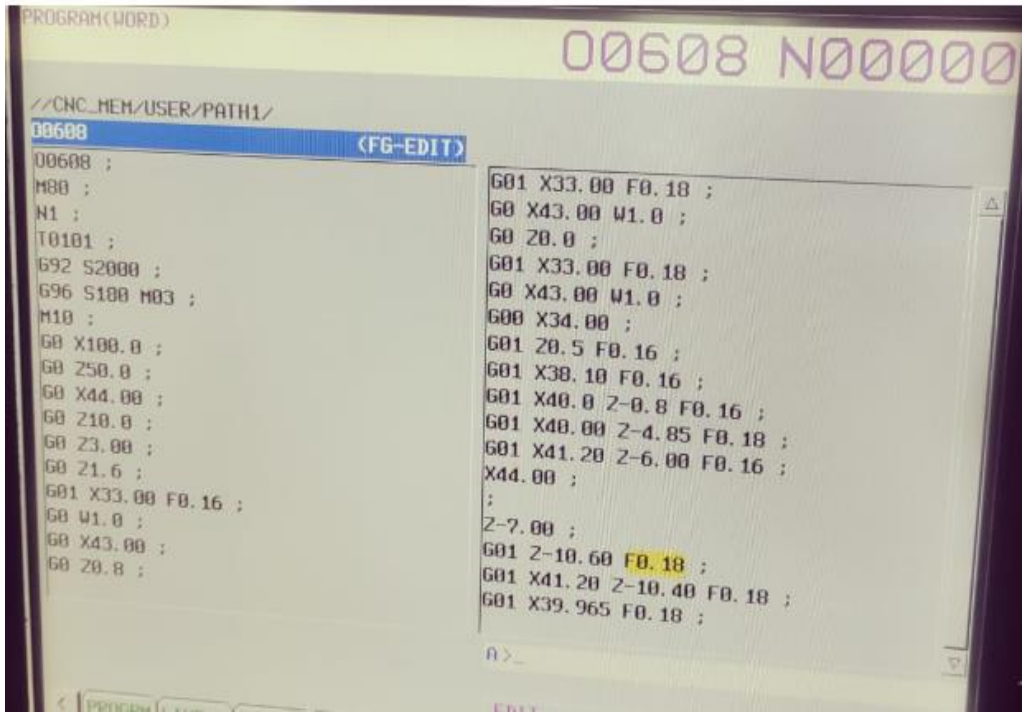
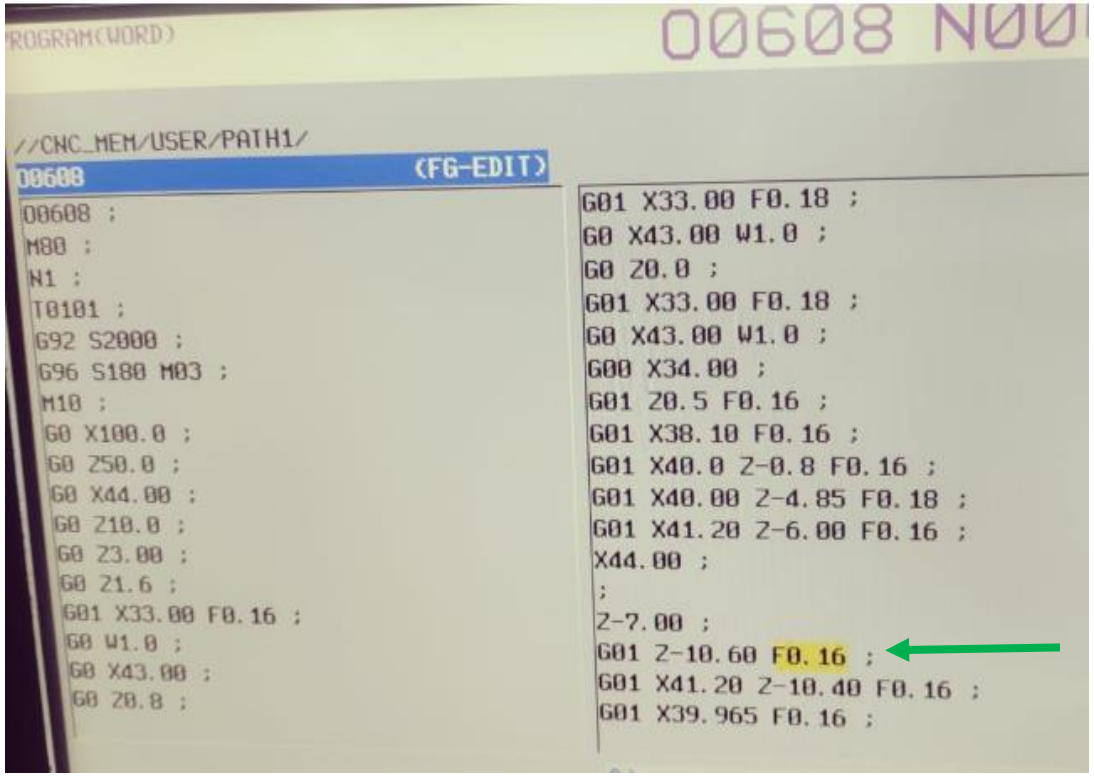
ACTION EVIDENCIES---Occurrence

BEFORE



Erlier Feed Value was defined 0.18 Inch/Min

AFTER



Feed Value Changed 0.16 Inch/Min

ACTION EVIDENCIES---Occurrence

BEFORE

FIRST FIVE PIECE CUM INSPECTION CHECK SHEET (Before)

Machine :	22	Date :	12-3-24	Format no	F/QA/02
Drg. Rev	XE	Shift :	A	Rev. date	01.12.23
Part No :	F2FA10933M	Part	J1A	Rev. no	02
Operator Name :					

Sr. No	Product Parameter	Spec.	Measurement Method	First Five Piece					Remark	Process Parameter	Specification	Observation
				1	2	3	4	5				
1	Total Length	555 ±0.2	Height Gauge	555.08	555.06	555.09	555.12	555.18	OK	Spindle RPM	2000 to 2600	2500
2	Coulking ID	37 -0.05	Plug gauge	Ok	Ok	Ok	Ok	Ok	Ok	Cutting speed	220 to 240	240
3	Coulking ID depth	47.9 +/- 0.1	PPG Depth Gauge	Ok	Ok	Ok	Ok	Ok	Ok	Feed rate - mm/ revolution	0.18	0.18
4	Threading	M38X1-6H	Thread Gauge	Ok	Ok	Ok	Ok	Ok	Ok	Hydraulic Pressure	28 ~ 30 Bar	29
5	Caulking Side Run Out	0.1 max	Dial gauge with fixture	0.09	0.08	0.1	0.1	0.1	Ok	Clamping pressure	18~20 kg/cm2	20
6	Caulking Side OD	39.94 to 39.97	Snap Gauge/Micrometer	Ok	Ok	Ok	Ok	Ok	Ok	Spindal assymbly runout RH side	0.05max	0.05
7	Caulking Side groove OD	39.8 -0.1	Snap Gauge/ vernier	Ok	Ok	Ok	Ok	Ok	Ok			
8	Dimn	8.5+0.5	Height Gauge	8.56	8.59	8.52	8.56	8.52	8.56			
9	width	20 .00 -0.15 / -0.05	Vernier/SANP GAUGE	Ok	Ok	Ok	Ok	Ok	Ok			
10	Deo bush od Run out	0.1	Dial gauge with fixture	0.09	0.1	0.08	0.09	0.1	0.09			
11	Treading side Run out	0.1	Dial gauge with fixture	0.09	0.1	0.08	0.1	0.09	0.1			
12	ID	38.2+0.1/-0.05	plug gauge/Bore Gauge	Ok	Ok	Ok	Ok	Ok	Ok			
13	ID Depth	20.00 +0.5	Depth Plug Gauge/Vernier	20.14	20.18	20.12	20.19	20.16	20.12			
14	Threading depth	24 +1	vernier	24.36	24.32	24.61	24.52	24.51	24.61			
15	Rusty, damage, burr	Visual	Eye	Ok	Ok	Ok	Ok	Ok	Ok			

Sr.no	Rev. ditails	Rev. No	Rev date
1	Spindal assymbly runout inspection	01	01.08.22
	Du Bush Od Ra inspection added	02	10.05.23
2	Caulking ID Ra inspection added		

Operator sing | Supervisor sir | QC Engineer

Erlier Feed Value was defined 0.18 Inch/Min

ACTION EVIDENCIES---Occurrence

AFTER

FIRST FIVE PIECE CUM INSPECTION CHECK SHEET (After)

Machine :	CNC - 22	Date :	26/07/24	Format no	F/QA/02
Drg. Rev	XE	Shift :	I st	Rev. date	01.08.24
Part No :	F2FA10933M	Part	J1A	Rev. no	03
Operator Name :					

Sr. No	Product Parameter	Spec.	Measurement Method	First Five Piece 1	2	3	4	5	Remark
1	Total Length	555 ±0.2	Height Gauge	555.16	555.14	555.18	555.18	555.20	
2	Coulking ID	37 -0.05	Plug gauge	OK	OK	OK	OK	OK	
3	Coulking ID depth	47.9 +/- 0.1	PPG Depth Gauge	OK	OK	OK	OK	OK/48.00	
4	Threading	M38X1-6H	Thread Gauge	OK	OK	OK	OK	OK	
5	Caulking Side Run Out	0.1 max	Dial gauge with fixture	0.070	0.060	0.070	0.080	0.060	
6	Caulking Side OD	39.94 to 39.97	Snap Gauge/Micrometer	39.954	39.964	39.950	39.959	39.961	
7	Caulking Side groove OD	39.8 -0.1	Snap Gauge/ vernier	39.74	39.76	39.78	39.76	39.72	
8	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	OK	OK	OK	OK	OK	
10	Deo bush od Run out	0.1	Dial gauge with fixture	0.050	0.040	0.050	0.040	0.040	
11	Treading side Run out	0.1	Dial gauge with fixture	0.090	0.090	0.080	0.090	0.080	
12	ID	38.2+0.1/-0.05	plug gauge/Bore Gauge	OK	OK	OK	OK	OK	
13	ID Depth	20.00 +0.5	Depth Plug Gauge/Vernier	20.32	20.84	20.38	20.30	20.31	
14	Threading depth	24 +1	vernier	24.74	24.76	24.64	24.70	24.80	
15	Rusty, damage, burr	Visual	Eye	OK	OK	OK	OK	OK	

Process Parameter	Specification	Observation
Spindle RPM	2000 to 2600	2400
Cutting speed	220 to 240	232
Feed rate - mm/ revolution	0.16	0.16
Hydraulic Pressure	28 ~ 30 Bar	29
Clamping pressure	18~20 kg/cm2	19
Spindal assymbly runout RH side	0.05max	0.05

Sr.no	Rev. ditails	Rev. No	Rev date
1	Spindal assymbly runout inspection	01	01.08.22
	Du Bush Od Ra inspection added	02	10.05.23
2	Caulking ID Ra inspection added		
3	CNC Feed rate Revised- 0.16 mm/ Revolution	03	25-7-24

Supervisor sir

QC Engineer

Feed Value revised in FPA Report defined 0.16 Inch/Min