

Change point (abnormality), reporting rule

Manufacturing Deptt

MAP-ID Rule No: ISD-QA-021

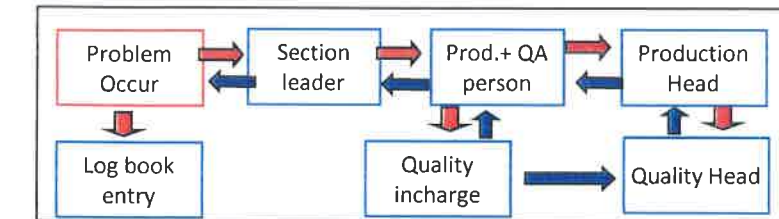
Changed point (abnormality) is:-

Occurrence of something which is not natural or proper disposal with respect to the operation standards, procedures & fixed control points or standards.

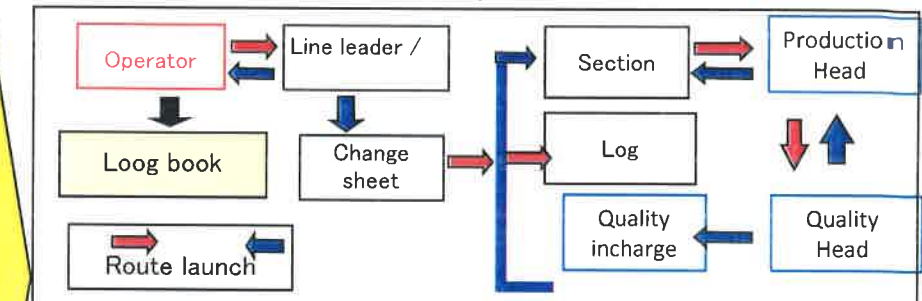
Change point (abnormality) Action

If any major issue (Customer will effect) reported from mfg. process , them immediate call required to production head .

Reporting route in case of abnormality occurs



Recording route in case of change point / abnormality occurs, follow the procedure ISD-QA-021 A

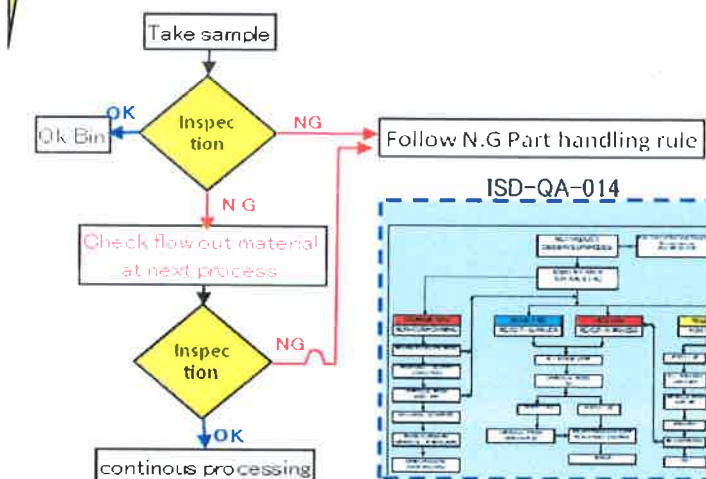


Operator → record in log book
Line leader/engineer → Record in change sheet

Daily check of log book and change sheet

if any abnormality change point , then fix it

Use Internal IPP in case of any change point and after correction of abnormality



Non compliance in machines/jigs etc

- Machines
 - Vibration, abnormal noise occurrence, play, leakage (water/air/oil/cutting oil/operational oil)
 - Wrong movement (different to that of usual), wrong operation (opposite machining), non illumination of indication
 - Abnormality during work start (difference in instructed pressure, oil dripping is fast)
 - During occurrence of dimensional differences
 - Machine stoppage during machining (power failure, breaker movement)
 - During alarm break out
 - In case of stoppage for a moment (power breakdown)
 - In case of occurrence of small time stoppages
 - During changeover in equipments (quality check/3 lots)
 - In case of changes in the machining parameters (Quality check, tool life / 3 lot check)
 - Incomplete clamp, chuck wear out damage, wear out of hit area
- Jig
 - Loosening ,wear/tear, damage of jig
 - Detection in Jig
 - In case of jig changes
- Tools
 - In case of difference in the normally used inserts/cutters (test)
 - Accuracy not achieved inspite of changing tool / tool life is
 - Roughness of machining surface/coming of chips/difference in profile
 - Any change in existing tool
 - In case of tool damage/chip off
- Inspection tools
 - During fall of inspection tool / Unusual working of the measuring device
 - While using temporary tools / In case of using inspection tools other than the specified ones
- Raw
 - Difference in profile in comparision to normal part/color difference/stock is more (less)/occurrence of mill

The inprocess parts in the machine to be disposed off by treating them as NG parts. (request for treating NG part)

Regarding component flow prior application to be given to quality section. The approval for flow to be judged by mass prod evaluation incharge.

Detection of defective quality

- Tools
 - Accuracy is not achieved if the lot changes/change in tool life
 - If No Instructions , for counter action of test & trial parts/occurrence of fallen parts
- Inspection tools
 - Gloss is different / profile is different
- Raw
 - Chamfering profile, difference in R profile (big/small/with step/impression)
 - Deformation, un processed, crack, dents, rust, chattering, scratch marks, burrs
 - In case of detecting abnormal parts with plane roughness
- Aesthetics
 - Feeling is different
- Feeling
 - Everytime huge difference in measured value .
- Measurement
 - In case of detecting "out of tolerance"

After counter preparation is over the machining to be done by setting "0", or till the shift is over the setting should not be changed.

Others (abnormality)

- New Equipment - not approved /not proven out
- Setting not done in the mounting jig
- During segregation and rework of the parts → To record in QUALITY TROUBLE ACTION SHEET
- While doing the machining of previous process segregated parts → To keep records in log book
- In case the part falls → All the fallen parts are to be disposed off considering rejection

New employee

- In case new employees does the machining
- In case an employee does machining whose experience is not more than 3 months
- Day time work (back up)

Note -

- 1) Use Internal IPP tag in case of any change point and after correction of abnormality
- 2) In case of any segregation or rework use Quality trouble action sheet.
- 3) After inspection , if N.G part found then also check all parts flow out on next operation
- 4) All the fallen parts are to be disposed off considering rejection

5) Daily log book and change point sheet checks by line engineer/section manager.

0	12.12.2014	Reviewed & Included ISD-QA-021 A			
Rev.	Date	Description	Prepared	Checked	Approved