

# TREND MONITORING RULE FOR DISTORTION MANAGEMENT OF LEAD AND PROFILE (4W)

Modified Rule		ISSUE#	Rev.	Date	Detail
		07	00	30.05.2018	New Rule Made
<b>ISD-MS-013</b>					
Production machine shop	Produce part and Hand over part to Std Room for inspection.				
Standard Room	1-Etching marking and inspect the part. 2-Hand over to production machine shop with judgement.				
Production machine shop	1-Production put part in Jig with wire at define location (7th location for gears and 5th location for shaft) 2-Hand over to production heat treatment.				
Production HT	Heat treatment process				
	<b>Gears</b>		<b>Shaft</b>		
	Broach Gears: HT will Hand over part to std room for Lead profile inspection. Honing gears: HT will hand over to Machine shop for honing and inspection at STD room.		HT will hand over main shaft and counter shaft to Machine shop for straightening and inspection.		
Standard Room	Std room inspect the part for LP and Hand over to HT Production/Machine shop accordingly.				
PRODUCTION HT	HT move the part with Full Lot with inspection details of BHT & AHT Inspection of Lead profile graph /Spline Major dia/OBD etc with lot control sheet and HT inspection report.				
Production machine shop	Plot BHT & AHT trend on trend monitoring sheet by hand written copy .BHT/AHT Trend chart review and signed by section head on daily basis. 1-If trend is towards UCL or LCL continue , correction will be done to make soft towards mean side. 2-If abnormal distortion is coming inform to ME for target setting.				
(CFT REVIEW MEETING ) LEAD ROLE:-PROD MC SHOP MEMBER 1:-1-PROD HT 2-M.E 3- INPROCESS QA	1-CFT will analyze trend chart on fortnightly basis summarize the study. if any abnormality is observed in distortion following activity to be done. 1-Trial to be taken as per input of CFT MEMBERS. 2-Inprocess QA will share trail result to CFT Members. 3-ME will share the data to PE for target setting.(MOM to be done.) 4-On the basis of MOM PE will do modify target value in process sheet and release modified process sheet to concern process owner.				
DIV HEAD PRODUCTION	DO REVIEW ON MONTHLY BASIS AND SHARE THE SUMMARY IN MONTHLY MRM.				
Prepared By		Checked By		Approved By	
				Released By	