


PCM INDEX						NAME:R.PARTHIBAN	
S.NO	DATE	SHIF	DESCRIPTION	ACTION PLN	PCM CLOSED (OR) NOT	STATUS	REMARKS
JANUARY							
1	03-01-2018	I	7th cross member erection bracket weld porosity		CLOSED	ok	
2	03-01-2018	I	Trap door plate hole incomplete		CLOSED	ok	
3	03-01-2018	I	9T ff mounting tube hole position wrong		CLOSED	ok	
FEBRUARY							
4	09-02-2018	II	5th cross member Floor support angle miss				
5	09-02-2018	II	2nd cross member bottom side weld miss				
6	09-02-2018	II	weld heavy spatter found				
7	09-02-2018	II	Erection bracket weld porosity				
8	23-02-2018	II	5th to 6th cross member center tube missing		CLOSED	ok	
9	23-02-2018	II	Mounting bracket dimension under size not ok spec-		CLOSED	ok	
10	23-02-2018	II	Main beam weld blow found		CLOSED	ok	
11	23-02-2018	II	Gas cutting mark		CLOSED	ok	
MARCH							
12	09-03-2018	II	Front erection B05-00761 bracket miss				
13	09-03-2018	II	UFA last angle mo5-08518 mouting hole not open				
14	19-03-2018	I	Floor support angle weld crack	increase the voltage	CLOSED	ok	
15	19-03-2018	I	Mounting bkt miss	we will avoid for final weld stage	CLOSED	ok	
16	19-03-2018	I	Erection bkt weld miss	traine the welder for visual weld inspection	CLOSED	ok	
17	19-03-2018	I	Both side gusset position wrong	we will avoid it in future	CLOSED	ok	

Problem Statement		Part Number :	620 UFA	Date	Issue No.	Responsible dept	Responsible Manager	Date:	17.03.17
Bracket Dimension NG and found oversize by 40mm	Part Name :	9T UFA	21.03.18	-	SEPL Quality & Production	Sai krishna	Issue observed at : DICV Line		20.03.18
	Supplier Name :	Spark line Equipments							

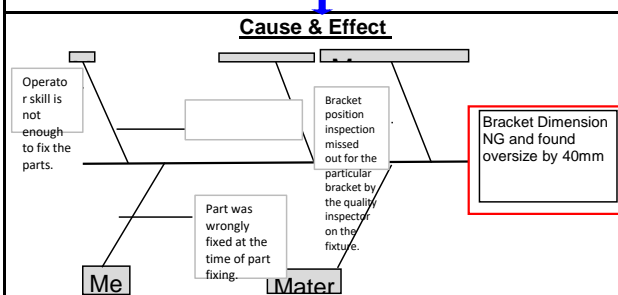
Problem Description		Defect Photo
<p>ocket Dimension NG and found oversize by 40r</p>		
Inspection Lot:	3	
Affected / Blocked Quantity :	1	

Probable root cause:

- |   |
|---|
| 1-Unaware of the dimension and criticality of the dimension.                                  |
| 2-Part was wrongly fixed at the time of part fixing.  |
| 3- Bracket position inspection missed out for the particular bracket by the quality inspector |
| 4-Operator skill is not enough to fix the parts.  |

### Interim containment action

When(Date)	Containment	OK Quantity	Rejected Quantity
<u>At DICV :</u>	SEPL Representative	2	1
<u>At SEPL :</u>	Quality inspector	3	3



Cause validation      symbols for results: O= no direct cause    X= direct

No.	Investigation method	Weight age
1-	Unaware of the dimension and criticality of the	
2-	Part was wrongly fixed at the time of part fixing.	
3-	Bracket position inspection missed out for the particular	
4-	Operator skill is not enough to fix the parts.	

WHY?

Bracket Dimension NG and found oversize by 40mm

WHY?

Part fixing was done wrongly.

WHY?

At the time of holding the measuring tape dimension should

WHY?

Bracket position inspection missed out for the particular

WHY?

5 Why analysis

**Root cause**

1-Part was wrongly fixed at the

2-Bracket position inspection missed out for the particular

### Corrective action

No.	Countermeasures	Who	When	Status	Validation
1	Training program is conducted and	SEPL	20.03.18	Completed	Will be monitored for next 10
2	All brackets must be inspected and	SEPL	21.03.18	Started	Continuously followed

Horizontal deployment process - Preventive action

Will be applicable for all models of 9T Under frames