

## WI FOR ABNORMAL SITUATIONS

S.No.	Definition Abnormal Situation	Action Taken	Activities to be done			
			Set-Up Approval	Retroactive Inspection	Containment Action	Remarks
1	Machine producing defective parts continuously	Stop production. Take corrective action and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced since last inspection & keep record of 05 Pcs.
2	Repeated breakage of production equipment (m/c, tool & fixture)	Stop production. Take corrective action and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced since start of production & keep record of 05 Pcs.
3	Operator produces defective parts continuously (Operator carelessness/mistake)	Stop production. Educate the operator and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally s produced by that operator & keep record of 05 Pcs.
4	Operator detects defects produced by previous process	Stop production. Take corrective action in previous process, educate the operator of previous process and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced by that previous operator & keep record of 05 Pcs.
5	Poka Yoke does not detect defective parts ( Poka Yoke not working)	Stop production. Take corrective action and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced since last Poka Yoke check & keep record of 05 Pcs.
	Inspector fail in Poison test	Stop inspection by the inspector & provide training. Then take retest of inspector.	No	Yes	Yes	1. Recheck all the parts checked by the inspector. 2. Provide training
6	Poke yoke by passed	Stop production. Take corrective action and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally s produced since last Poka Yoke check & keep record of 05 Pcs.
7	Absenteeism more than Attrition rate	New Person to be recruited & trained.	Yes	No	Yes	1. Take set up approval 2. Check all parts 100% & record 05 pcs on that day
8	Parts fallen down	Shift all the fallen parts to suspected part area	No	No	Yes	1. Put fallen down part in yellow bin.
9	Bin fallen down	Shift whole bin material to suspected part area	No	No	Yes	1. Check all the parts 100% visually & 10% dimensionally falled down & keep record of 05 Pcs.
10	Instrument fallen down	Put red sticker till calibration & Re-calibrated the instrument	No	No	No	Don't check any part with that fallen down Instrument
11	Instrument showing error	Put red sticker till calibration & Re-calibrated the instrument	No	No	Yes	Put all material in suspected area since last check
12	Gauge fallen down	Put red sticker till re-validation & done re-validation of that gauge	No	No	No	Don't check any part with that fallen down gauge
13	Power Failure (Projection/Spot)	Re- Start the machine	No	No	Yes	Marking to be done on part produced during power failure & keep part in suspected bin.
14	Machine parameters found out of spec during routine checking	Stop production. Start production after resetting the parameters	Yes	Yes	Yes	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced since last check of parameters & keep record of 05 Pcs.
15	Different grade material used	Stop production. Move all the parts to suspected parts area and start production with ok material after first piece approval.	Yes	No	Yes	1. Take set up approval 2. Keep all the material in suspected area & discuss with Top mgt & Customer

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16	Production run on Lower Tonnage	Shift whole bin material to suspected part area	Yes	No	Yes	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced through lower tonnage m/c & keep record of 05 Pcs.
17	Production run on temporary Fixture/ tool/ die.	Shift whole bin material to suspected part area	Yes	No	Yes	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally that produced through temporary Fixture/ tool/ die & keep record of 05 Pcs.
18	Operator of Under Skill deputed	Shift whole bin material to suspected part area	Yes	No	Yes	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced by under skill operator & keep record of 05 Pcs.
19	Overtime (Working more than Shift hours)	Provide the separate Bins	No	No	Yes	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced during over time.
20	Machine producing abnormal noise.	Stop production. Take corrective action in the machine and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced since last machine parameters check & keep record of 05 Pcs.
21	Machine consuming excessive oil/collant etc.	Stop production. Take corrective action in the machine and restart the production after set up approval.	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced since last machine parameters check & keep record of 05 Pcs.
22	Machine takes the stroke without pushing the paddle	Stop production. Take corrective action in the machine and restart the production .	Yes	Yes	No	1. Take set up approval 2. Check all the parts 100% visually & 10% dimensionally produced since last machine parameters check & keep record of 05 Pcs.
<b>Rev.No.</b>	<b>Rev. Date</b>	<b>Amendment Detail</b>	<b>Done By</b>		<b>Approved By:</b>	
<b>Note :</b> Suspected material lot will be identified with the identification tag and kept separately in Yellow Bins						
<b>PREPARED BY:</b>			<b>APPROVED BY:</b>			