

POKA-YOKE SHEET

PROBLEM:

HARDNESS VARIATION (LOW HARDNESS) IN SPRING PIN DURING INDUCTION HARDENING PROCESS HARDNESS OBSERVED 52 HRC INPLACE REQUIRED HARDNESS 55 HRC.

SEC:IND

DT.16.04.02



PREVENT ERROR

SHUTDOWN



CONTROL

DETECT ERROR

ALARM

BEFORE

LOW HARDNESS DUE TO NON UNIFORM WATER FLOW. DIFFERENT SCREW VALVES ARE PROVIDED TO ADJUST THE WATER FLOW, WHICH SOME TIMES LEADS TO NON UNIFORM WATER FLOW, RESULTS IN HARDNESS VARIATION.(INLET PIPES WERE FOUR)

AFTER

ALL PIPES ARE CONNECTED TO SINGLE SOURCE WATER SUPPLY AND TO CONTROL THE UNIFORM WATER FLOW WHEEL COCK REGULATOR IS PROVIDED, WITHIN THE OPERATOR REACH, GRADUATION MARKED ON WHEEL COCK TO CONTROL THE EXACT REQD. QTY.OF WATER.



WHEEL COCK REGULATOR