

Defect Details

NC No.	7000829339
NC Date	02/04/2022
NC Submission Date	
Part No.	F2DZ08810B
Part Name	K0PG FORK BOLT
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	DIMETER UNDERSIZE-Grove Dia 22.45-0.1 found Under Size

1. Problem Description

Defect Description	Grove Dia Under NG (Under Size & Over Size)
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	2400
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	maheshmishra@sangkaj.com
Plant Head/CEO Email ID	steel@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4800	0	0	2000	2000	8800
Check Qty	4800	0	0	2000	2000	8800
NG Qty	4800	0	0	0	0	4800

Action taken on NG part

Scrap	0
Rework	4800
Under Deviation	0

Containment Action

Pipeline material 100% checked with DVC

3. Process Flow

Process Flow Description

Inward-Parting-CNC 1st -CNC 2nd -Palting -final inspection -Dispatch

4. Process Details

Process / Operation	CNC MACHINING
Outsource	No
Machine / Cell	CNCN CELL
Machine / Cell No.	38

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Insert plunge 2 time	Not ok	X
Man	New manpower	Manpower is old	O
Machine	Machine under maintenance	Machine found ok	O
Tool	Tool life is not maintain	Tool life is maintain	O
Material	Material change	Material is not changed	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

7. Root Cause Analysis (Occurance)

Why 1	Groove OD observed undersize due to insert is plunge 2 times
Why 2	Insert plunge 2 times because of that taper is observed in groove OD.
Why 3	standard insert is not available for size 3.00+0.2 mm .
Why 4	
Why 5	
Root Cause (Occurance)	standard insert is not available for size 3.00+0.2 mm .

Root Cause Analysis (Outflow)

Why 1	Groove OD observed undersize
Why 2	Sampling inspection
Why 3	Material checked with snap gauge
Why 4	
Why 5	
Root Cause (Outflow)	Material checked with snap gauge

8. Countermeasure (Occurrence , Outflow & System side Actions)

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	3 mm insert plunge in one time and linear 0.1 mm machining then step is not found and taper also not observed.	Santosh raut	26/04/2022	26/04/2022	Completed
Outflow	100% material checked with snap gauge. Also sampling with DVC out of 100/1000. In in process inspection hourly inspection with only DVC	Mahesh Mishra	28/04/2022	28/04/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% material checked with snap gauge. Also sampling with DVC out of 100/1000. In in process inspection hourly inspection with only DVC
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	00

10. Evidance of Countermeasure

Occurance (Before)	insert plunge 2 times 39_Occurance_Before.jpg
Occurance (After)	insert plunge 1 time and linear machining 39_Occurance_After.jpg
Outflow (Before)	Material 100% inspect with snap gauge 39_Outflow_Before.jpg
Outflow (After)	material inspect with DVC 39_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity

0

Reason for submission

ETL Return Material stock details and actions are not given. All 4m to be addressed and fact verification to be corrected. Root Cause is not adequate (both Flow and Occurrence) i.e. why not detected at Setup inspection, Petro inspection sheet, PDIR etc. ? If tool double plunged then why 4M change not followed ? Occurrence side corrective action is given but preventive action is not defined i.e. How to avoid repeating of use of Non Standard tool. All Updated or Reviewed Documents to be uploaded (OPL, Training records, Control Plan etc.)