

Defect Details

NC No.	7000891491
NC Date	20/01/2023
NC Submission Date	
Part No.	F1LG00902B
Part Name	SEAT PIPE -K86A
Supplier Name & Code	100538-NARINDER PARKASH AND CO
ETL Plant	1136-ETL Suspension Sanand
Defect Details	MIX UP OTHER MODEL-Mix up Other model

1. Problem Description

Defect Description	Other model Mixing .
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	250
Is Defect Repeatative?	Yes
Defect Sketch / Photo	tj5qkjazjfglq5x4xctoxy0m.png

Supplier Communication Details

Quality Head Email ID	quality@npcindustries.in
Plant Head/CEO Email ID	anand@npcindustries.in
MD Email ID	ajay@npcindustries.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4000	1250	0	0	0	5250
Check Qty	4000	1250	0	0	0	5250
NG Qty	250	0	0	0	0	250

Action taken on NG part

Scrap	250
Rework	0
Under Deviation	0

Containment Action

Segregated all parts at ETL, at Warehouse & at NPC Nabha.

3. Process Flow

Process Flow Description

1.Raw Material 2.Cutting & Chemfering 3. Multistation Draw 4.Head Formation 5.Rough Grinding 6.Punching 7.CNC Head Turning 8.CNC Boring & Facing 9.Tapping 10. Chemfering 1&2 11.Finish Grinding 12.Final Inspection 13.Cleaning 14.Oiling 15.Packing &Dispatch

4. Process Details

Process / Operation	Final Inspection
Outsource	Yes
Machine / Cell	ST-01
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	skipped at final inspection	it was observed that parts skipped during sampling at final inspection.	O
Method	wrong part mixed during material handing	After verification we found material handling properly as per std.	O
Machine	tempered program run in CnC machine	it was observed that no program	O
Man	Packing person negligence at in packing	Packing person was not aware	X
Tool	Tap Wear Out	after verification we found tap was wear out	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Mix up Other model
Why 2	other model box mixed at dispatch station
Why 3	Dispatch helper was not aware
Why 4	different model boxes were placed at same places
Why 5	No identification point was not available for particular model
Root Cause (Occurance)	No identification point was not available for particular model

Root Cause Analysis (Outflow)

Why 1	Mix up Other model
Why 2	other model box mixed at dispatch station
Why 3	No checkpoint was available after packing
Why 4	
Why 5	
Root Cause (Outflow)	No checkpoint was available after packing

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Give the awareness training for dispatch department	Mr. Gurpreet singh	25/01/2023	23/01/2023	Completed
Outflow	New checkpoint to be added as temporary basis in warehouse	Mr. Ratness	25/01/2023	24/01/2023	Completed
Occurance	identification point should be available for particular model	Mr. Ankush	22/01/2023	21/01/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	new checkpoint add at warehouse
Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	No identification point was not available for particular model 336_Occurance_Before.jpeg
Occurance (After)	Place is define by identification tag for perticular moidel. 336_Occurance_After.png
Outflow (Before)	No any check point available after packing. 336_Outflow_Before.png
Outflow (After)	New check point establish in warehouse for material check befor dispatch in GIL Sanand Plant. 336_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	K-86 Seat pipe

12. Document Review

Documents	
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	0
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Reason for submission

Provide evidence for training record and check point sheet added in warehouse