

Defect Details

NC No.	7000911552
NC Date	26/04/2023
NC Submission Date	
Part No.	S2AB01907B
Part Name	ADJUSTER POWDER COATED
Supplier Name & Code	100973-TESMO MOTORCAST PRIVATE LIMITE
ETL Plant	1116-ETL K-120 Suspension
Defect Details	EXCESS MATERIAL-excess material at spring resting face

1. Problem Description

Defect Description	Major power coating defects observed with casting concern also.
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	1200
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rkhare@tesmomotorcast.com
Plant Head/CEO Email ID	harish.bala@tesmomotorcast.com
MD Email ID	svkallani@tesmomotorcast.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3200	0	4200	3000	6000	16400
Check Qty	3200	0	0	3000	6000	12200
NG Qty	1200	0	0	0	0	1200

Action taken on NG part

Scrap	1200
Rework	0
Under Deviation	0

Containment Action

Check point added in final stage.

3. Process Flow

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	PDC-350 Ton
Machine / Cell No.	PDC-5

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Ejector Pin dia oversize	pin bend dia oversize & excess Flash generated	O
Tool	pin jam in die	pin dia oversize due to heat generation	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	visual checking
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1

7. Root Cause Analysis (Occurance)

Why 1	PIN FLASH ON SPRING RESTING FACE
Why 2	EJECTOR PIN DIE INCREASE ON INSERT
Why 3	DIE RUNNING WITH UNBALANCE EJECTION
Why 4	SETTING NOT DONE CORRECTLY
Why 5	POOR SKILL LEVEL
Root Cause (Occurance)	EJECTOR SETTING SKILL LEVEL NOT GOOD

Root Cause Analysis (Outflow)

Why 1	PIN FLASH ON SPRING RESTING FACE
Why 2	PIN FLASH CHECKING MISSED BY INSPECTOR
Why 3	IMPROPER TRAINING TO INSPECTOR
Why 4	VISUAL DISPLAY NOT AVAILABLE
Why 5	
Root Cause (Outflow)	VISUAL DISPLAY OF PIN FLASH NOT AVAILABLE

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Outflow	VISUAL DISPLAY AT INSPECTION WITH PROPER TRAINING	ANKUSH	30/06/2023	30/06/2023	Completed
Occurance	PIN AND INSERT DIAMETER CHECKING	SACHIN	01/07/2023	01/07/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	VISUAL DISPLAY IN INSPECTION TABLE WITH SAMPLES
Inspection Method	Other
Other Inspection Method	VISUAL
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1

10. Evidence of Countermeasure

Occurance (Before)	PART WITH PIN FLASH 442_Occurance_Before.jpeg
Occurance (After)	EJECTOR PIN DIA INCREASE 442_Occurance_After.jpeg
Outflow (Before)	PART WITH PIN FLASH 442_Outflow_Before.jpeg
Outflow (After)	SAMPLE PLACED ON FINAL STAGE 442_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	InspCheckSheet
Specify Other Document	PART DISPLAY

13. Effectiveness Of Action

Reviewed Quantity	10
Reason for submission	Corrective action parts submission.