

## Defect Details

<b>NC No.</b>	7000923677
<b>NC Date</b>	21/06/2023
<b>NC Submission Date</b>	
<b>Part No.</b>	S2DP02902B
<b>Part Name</b>	EXTENSION K55G
<b>Supplier Name &amp; Code</b>	100106-SHARP ENGINEERS.
<b>ETL Plant</b>	1136-ETL Suspension Sanand
<b>Defect Details</b>	RUSTY-Rusty

## 1. Problem Description

<b>Defect Description</b>	Material rusty
<b>Detection Stage</b>	Receipt
<b>Problem Severity</b>	Aesthetic
<b>NG Quantity</b>	1090
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality@apw3.co.in
<b>Plant Head/CEO Email ID</b>	kurund.ma@sharp-engineers.com
<b>MD Email ID</b>	urkhandelwal@sharp-engineers.com

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	5000	5000	0	1000	0	11000
<b>Check Qty</b>	5000	5000	0	1000	0	11000
<b>NG Qty</b>	1090	0	0	0	0	1090

## Action taken on NG part

<b>Scrap</b>	0
<b>Rework</b>	1060
<b>Under Deviation</b>	0

## Containment Action

Segregation done at WIP and FG and defective part removed from ok part.

## 3. Process Flow

**Process Flow Description**

10) RM Inward 20) Storage 30) Material Issue 40) Parting & Drilling 50) ID Chamfer 60) Tapping 70) OD grinding 80) Final Inspection 90) Pre-dispatch inspection 100) Packing & dispatch

**4. Process Details**

<b>Process / Operation</b>	Storage (Warehouse)
<b>Outsource</b>	Yes
<b>Machine / Cell</b>	NA
<b>Machine / Cell No.</b>	NA

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Machine	Improper preventive maintenance	Preventive maintenance plan evident as per P/MNT/01 and being followed as per F/MNT/07	O
Method	Material Handling( Material should be store on the pallet at warehouse)	Material kept on ground floor instead of pallet.	X
Tool	Insert/Tool/Drill worn out	Tool life monitoring as per defined tool life monitoring.	O
Material	Incorrect Raw Material	Material observed as per customer requirement Ø16.10 EN1A , MTC verified as per drawing specificatio	O
Man	Un-skilled Operator	Stage wise skill matrix and operator license are evident as per F/HR/06	O

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Warehouse storage
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	Bag to Bag

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	Extension K55 Rusty
<b>Why 2</b>	Material storage on the ground floor
<b>Why 3</b>	Pallet not available.
<b>Why 4</b>	Improper material storage by old transporter (Mumbai-Gujrat transport)
<b>Why 5</b>	
<b>Root Cause (Occurance)</b>	Material storage on the ground floor, Pallet not available. (Mumbai-Gujrat transport)

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	Extension K55 Rusty part reached to ETL
<b>Why 2</b>	RP oil dried after 20 days of oil application
<b>Why 3</b>	Rust preventive oil PANOL RP DW 68 being used
<b>Why 4</b>	Defined by system.

<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	Rust preventive oil PANOL RP DW 68 being used, less life of rust preventive oil(Only 15 days after oil application)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Rust preventive oil VORSTAB is being used, excess life of rust preventive oil. (@1 month)	Mr. Shaikh L.N.	04/07/2023	04/07/2023	Completed
Occurance	Proper storage identified at warehouse material and provided pallet for storage	Mr. Shaikh L.N.	04/07/2023	04/07/2023	Completed

### 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	RP oil has been changed
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Visually
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	1:1

### 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	Material storage on the ground floor, Pallet not available. (Mumbai-Gujrat transport) <a href="#">490_Occurance_Before.pptx</a>
<b>Occurance (After)</b>	Pallet made available. (Anjali logistic ) <a href="#">490_Occurance_After.pptx</a>
<b>Outflow (Before)</b>	Rust preventive oil PANOL RP DW 68 being used, less life of rust preventive oil(Only 15 days after oil application) <a href="#">490_Outflow_Before.pptx</a>
<b>Outflow (After)</b>	Rust preventive oil VORSTAB is being used, excess life of rust preventive oil. (@1 month) <a href="#">490_Outflow_After.pptx</a>

### 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	NA

### 12. Document Review

<b>Documents</b>	ControlPlan, PFMEA, WISOP, InspCheckSheet
<b>Specify Other Document</b>	NA

### 13. Effectiveness Of Action

**Reviewed Quantity**

1

**Reason for submission**

No rust observed in fresh lots.