

Defect Details

NC No.	7000951520
NC Date	10/10/2023
NC Submission Date	
Part No.	F1LG00902B
Part Name	SEAT PIPE -K86A
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1136-ETL Suspension Sanand
Defect Details	LENGTH UNDERSIZE-Total length undersize

1. Problem Description

Defect Description	Seat pipe K86 total length found undersize 146.47 mm against specification 152 -0.2 mm
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	72
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	8000	0	0	0	0	8000
Check Qty	8000	0	0	0	0	8000
NG Qty	72	0	0	0	0	72

Action taken on NG part

Scrap	72
Rework	0
Under Deviation	0

Containment Action

Stock check 100% at our end.

3. Process Flow

Process Flow Description

Forging-Drilling& Flash Turning-Rough Grinding-CNC-1st-CNC-2nd-Punching-Filling-Reaming-Tapping-Final Grinding-Final Inspection-Packing

4. Process Details

Process / Operation	Packing
Outsource	No
Machine / Cell	01
Machine / Cell No.	02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Two types pf samples packed at same time & same place.	Yes	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Sampling
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	80

7. Root Cause Analysis (Occurance)

Why 1	Total length short pcs. reached at customer end
Why 2	The problem occurred at packing stage
Why 3	Two types of samples packed at same time same place
Why 4	Operator was unaware and some mix material packed in boxes
Why 5	So mixed material reached at customer end
Root Cause (Occurance)	Two types of samples packed at same time & same place.

Root Cause Analysis (Outflow)

Why 1	Total length short pcs. reached at customer end
Why 2	100% inspection is not done at packing stage
Why 3	Inspection is also as per sampling plan
Why 4	So final inspection person not caught this defect
Why 5	So NG parts dispatched to customer end
Root Cause (Outflow)	Two types of samples packed at same time & same place.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Single sample packed at a time	Quality Head	16/10/2023	16/10/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	as per pla

10. Evidence of Countermeasure

Occurance (Before)	Two types of samples packed at a time on same place 572_Occurance_Before.jpeg
Occurance (After)	some type material use deference bin 572_Occurance_After.jpeg
Outflow (Before)	Two types of samples packed at a time on same place not use different bin some types bin use 572_Outflow_Before.jpeg
Outflow (After)	Single sample packed at a time and deferent bin use 572_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Packing

12. Document Review

Documents	WISOP
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	Seat pipe K86 total length found undersize 146.47 mm against specification 152 -0.2 mm