

Defect Details

NC No.	7001036712
NC Date	25/07/2024
NC Submission Date	
Part No.	F2FA19033M
Part Name	K0PG FORK PIPE MACHINED
Supplier Name & Code	101109-TUBE INVESTMENTS OF INDIA LIMI
ETL Plant	1136-ETL Suspension Sanand
Defect Details	LENGTH UNDERSIZE-Short Lenght (287.43)

1. Problem Description

Defect Description	Specification 288.3+0.2/-0.2 observation 287.43 undersize.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	1005
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	anandms@tii.murugappa.com
Plant Head/CEO Email ID	girisha@tii.murugappa.com
MD Email ID	mukeshahuja@tii.murugappa.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1005	0	0	1000	500	2505
Check Qty	1005	0	0	1000	500	2505
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action

All available material at ETL end & In-house are re - inspected with Conventional Length Gauge.

3. Process Flow

Process Flow Description

INWARD - CNC MACHINING - DRILLING - DIBURRING - FINAL INSPECTION - PACKING - DISPATCH TO ETL.

4. Process Details

Process / Operation	CNC MACHINING
Outsource	No
Machine / Cell	CELL NO -5
Machine / Cell No.	CELL NO -5

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Raw tube length U/s	Verified Records & found ok	O
Man	Tube come back due to Back Pressure	Verified through Gamba & found Tube come back due to Back Pressure. Operator has to Judge for resting	X
Machine	Machine Parameter	Verified through Gemba observation and found all Machine Parameter as per Control Plan	O
Method	Wrong Setup	Verified Setup Reports & found OK.	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Length under size found at customer end (Specification 288.3+0.2/-0.2 observation 287.63 mm)
Why 2	Excess Material cut during Tube facing operation in CNC Machining.
Why 3	Tube hold away from Stopper.
Why 4	Tube come back due to Back Pressure. Operator has to Judge for resting on Stopper
Why 5	
Root Cause (Occurance)	Tube come back due to Back Pressure. Operator has to Judge for resting on Stopper

Root Cause Analysis (Outflow)

Why 1	Length under size found at customer end (Specification 288.3+0.2/-0.2 observation 287.63 mm)
Why 2	skip from proxy Sensor on Drilling M/c & 100 % conventional length gauge
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	skip from 100 % conventional length gauge

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	OK & Not OK Master sample made for verification of conventional length gauge.	Abishek Yadav	06/08/2024	05/08/2024	Completed
Occurance	Additional Tool added on CNC m/c Tool Head for Tube resting on Stopper on Cell No - 05.	Palak Shah	06/08/2024	05/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % Inspection with Conventional Length Gauge for Next 1 Month.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	Tube come back due to Back Pressure. Operator has to Judge for resting on Stopper. No Provision to ensure 965_Occurance_Before.pptx
Occurance (After)	Additional Tool added on CNC m/c Tool Head for Tube resting on Stopper 965_Occurance_After.pptx
Outflow (Before)	No Master samples of OK & NOT OK tube for Verification at Final Inspection 965_Outflow_Before.pptx
Outflow (After)	Master samples of OK & NOT OK tube made for Verification at Final Inspection 965_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	all Simians control Machines.

12. Document Review

Documents	InspCheckSheet
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	Specification 288.3+0.2/-0.2 observation 287.43 undersize

