

Defect Details

NC No.	7001052680
NC Date	11/09/2024
NC Submission Date	
Part No.	S1AB00612B
Part Name	ADJUSTER PLATED
Supplier Name & Code	100782-NICE STEEL INDUSTRIES
ETL Plant	1136-ETL Suspension Sanand
Defect Details	DIAMETER OVER SIZE-ID Oversize

1. Problem Description

Defect Description	ID oversize observed 31.70 mm against specification 30.50~30.70 mm
Detection Stage	Receipt
Problem Severity	Safety
NG Quantity	8000
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	ppc.nice@batragroup.biz
Plant Head/CEO Email ID	ho.nice@batragroup.biz
MD Email ID	hitesh@batragroup.biz

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	8000	2000	0	2000	2000	14000
Check Qty	8000	2000	0	2000	2000	14000
NG Qty	2034	122	0	96	98	2350

Action taken on NG part

Scrap	0
Rework	2034
Under Deviation	0

Containment Action

1-Go and No Go gauge to be made 2- Part to be checked by DVC during setup and in-process for the ID

3. Process Flow

Process Flow Description

10 RECEIVING INSPECTION 20 STORAGE 30 BLANKING 40 1st BENDING (`U` BENDING) 50 FINAL BENDING (ROUNDING) 60 MIG WELDING 70 FLAIRING 1st 80 FLAIRING 2nd 90 ID SIZING 100 SIDE GRINDING & BUFFING 110 REROUNDING 120 BROACHING 130 HEAD GRINDING 140 OUTSIDE MOVEMENT FOR PLATING 150 STORAGE & RQC INSP. OF PLATED MATERIAL 160 FINAL INSPECTION 170 PACKING & DISPATCH

4. Process Details

Process / Operation	Re-rounding
Outsource	No
Machine / Cell	PP
Machine / Cell No.	10 to 30 Ton

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Untrained operator	Operator is skilled but not regular on this part	O
Man	Unskilled operator	Skill matrix available	X
Machine	Machine capacity was lower side used	Machine checked and found ok	X
Method	Part was not properly rest in mandrel	mandrel length was same as part length	O
Tool	Mandrel size	Mandrel check and found length was same as part length	O
Material	wrong material used	Material checked and found ok	X
Machine	Machine capacity was higher side used	Machine checked and found ok	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Dia over size observed at customer end
Why 2	Id not maintained at leg area due to Part leg was not properly
Why 3	3 mm part leg area was in the air due to part not properly rest at re-round mandrel
Why 4	Mandrel length and part resting length was same
Why 5	Mandrel length was defined as per past experience according to other similar process/part
Root Cause (Occurance)	1- 3 mm part leg area was in the air due to part not properly rest at re-round mandrel 2-Madral length and part resting length was same

Root Cause Analysis (Outflow)

Why 1	Defective part not found ok PDI area
Why 2	Inspection was doing with plug gauge
Why 3	Plug gauge was defined for inspection

Why 4	
Why 5	
Root Cause (Outflow)	Inspection was doing with plug gauge

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Mandrel length increased 33±3 mm from 24.0±2	Nimit	10/09/2024	10/09/2024	Completed
Occurance	Re-rounding to be started at 2 location on part by 2 stroke	Nimit	15/09/2024	12/09/2024	Completed
Outflow	OPL displayed	Prahlad	10/09/2024	09/09/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Part to be checked by DVC during setup and in-process for the ID
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	Revers

10. Evidance of Countermeasure

Occurance (Before)	NA 1085_Occurance_Before.png
Occurance (After)	SHEET ATACHED 1085_Occurance_After.png
Outflow (Before)	NA 1085_Outflow_Before.png
Outflow (After)	SHEET ATTACHED 1085_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	ID oversize observed 31.70 mm against specification 30.50~30.70 mm