

Defect Details

NC No.	7001062684
NC Date	11/10/2024
NC Submission Date	
Part No.	530BU00302
Part Name	Stricker Cap
Supplier Name & Code	100144-AURANGABAD PRESSINGS
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	DIMETER UNDERSIZE-I/D U/SIZE SPE=43.60-0.30 GAUGE NOT PASS

1. Problem Description

Defect Description	DIMETER UNDERSIZE-I/D U/SIZE SPE=43.60-0.30 GAUGE NOT PASS
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	900
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
Plant Head/CEO Email ID	aurangabadpressings@apw3.co.in
MD Email ID	shashikant@apw3.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5139	0	0	0	2500	7639
Check Qty	5139	0	0	0	2500	7639
NG Qty	2511	0	0	0	1100	3611

Action taken on NG part

Scrap	0
Rework	1700
Under Deviation	0

Containment Action

Segregation all material

3. Process Flow

Process Flow Description

blanking+ piercing +forming Turning Notching +Dimpling Plating

4. Process Details

Process / Operation	Notching +Dimpling
Outsource	No
Machine / Cell	Press Shop
Machine / Cell No.	Machine No 9

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
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6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

7. Root Cause Analysis (Occurance)

Why 1	Striker cap Mono m Dimn 43.6 -0.3 ID undersize up to 43.2 mm
Why 2	Notch Depth oversize
Why 3	Notch punch pressure excess
Why 4	Dimple punch stroke is completed but of rod (cam) stroke stroke pressure is excess.
Why 5	Rod (cam)punch Length more then Dimple punch
Root Cause (Occurance)	Dimple punch & rod (cam) Length maintain. .

Root Cause Analysis (Outflow)

Why 1	Gauge Worn out Required 43.3 mm
Why 2	Observed 43.25
Why 3	Worn-out
Why 4	
Why 5	
Root Cause (Outflow)	Gauge checking fequriency not define

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Notching punch length excess	Deepak	18/10/2024	21/10/2024	Completed

Outflow	Gauge correction	P D Kulkarni	18/10/2024	21/10/2024	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection by Gauge
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)	Press shop 1141_Occurance_Before.pptx
Occurance (After)	Quality 1141_Occurance_After.pdf
Outflow (Before)	Press Shop 1141_Outflow_Before.pdf
Outflow (After)	Inspection 1141_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Press shop

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	WI

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	