

Defect Details

NC No.	8000785714
NC Date	29/04/2022
NC Submission Date	
Part No.	F2CK00403B
Part Name	CAP NUT XF1C1_1D1
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-CAP NUT M22 THREAD NOGO PASS

1. Problem Description

Defect Description	M22 X 1 X 6H THREADING NOGO PASS- CC FROM M/S SUZUKI
Detection Stage	Customer End
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	dca2kxp4ecj4q3wvwbonytym.pptx

Supplier Communication Details

Quality Head Email ID	quality@sharp-engineers.com
Plant Head/CEO Email ID	kurund.ma@sharp-engineers.com
MD Email ID	urkhandelwal@sharp-engineers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	500	0	0	500	900	1900
Check Qty	500	0	0	500	0	1000
NG Qty	112	0	0	97	0	209

Action taken on NG part

Scrap	209
Rework	0
Under Deviation	0

Containment Action

Segregation of pipeline material including ETL end material.

3. Process Flow

Process Flow Description

10 RM Inward Inspection 20 RM Storage 30 Parting & Drilling 40 CNC-1st Setup 50 CNC-2nd Setup 60 Plating 70 Inward Inspection 80 Final Inspection 90 PDI
100 Packing & Forwarding

4. Process Details

Process / Operation	CNC Machining
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	3

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Pre-Thread Dia O/S	Observed on Higher Side upto 22.10~22.20mm	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	As per Pla

7. Root Cause Analysis (Occurance)

Why 1	M22 Threading No-go Pass observed at Customer End.
Why 2	Observed Pre-Thread Dia on Higher side upto 21.10~21.20mm
Why 3	Due to plating Allowance
Why 4	
Why 5	
Root Cause (Occurance)	Pre-Thread Dia. On Higher Side (Due to Plating Allowance)

Root Cause Analysis (Outflow)

Why 1	M22 Threading No-go Pass observed at Customer End
Why 2	Not observed during final inspection stage
Why 3	No checkpoint at Final inspection
Why 4	Sample basis inspection at PDI Stage
Why 5	
Root Cause (Outflow)	Not Observed during Sample Basis Inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Pre-Thread Dia taken on lower side upto 21 mm & 100% inspection added for M22x1-6H Go Gauge at Final.	Mr. Dnyaneshwar	30/04/2022	Completed
Occurance	M22x1-6g threading gauge to be implemented on process side considering plating allowance.	Mr. Mohan Jadhav	03/05/2022	Completed
Outflow	100% Inspection at final stage.	Mr. Mohan Jadhav	30/04/2022	Completed
Outflow	Pre-Thread Dia. Checking started and Dimension added in setup approval.	Mr. Mohan Jadhav	30/04/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1) Pre-Thread Dia. Checking started and Dimension added in First piece approval. 2) M22x1-6g threading gauge to be implemented on process side considering plating allowance after trial. 3) 100 % inspection of NOGO from both side entry thread.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	-

10. Evidence of Countermeasure

Occurance (Before)	Pre-Thread Dia. on Higher Side. 79_Occurance_Before.jpeg
Occurance (After)	Pre-thread dia. taken on lower side & 100% Go gauge inspection started in final inspection. 79_Occurance_After.jpeg
Outflow (Before)	No Checkpoint at final stage/Sample basis inspection 79_Outflow_Before.xlsx
Outflow (After)	Checkpoint added & OPL displayed at work station 79_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CNC 9/Lock Nut/E92/93

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Next 3 lots found ok

