

Defect Details

NC No.	8000787300
NC Date	12/05/2022
NC Submission Date	
Part No.	520FG07802
Part Name	GEAR PRIMARY DRIVEN (JZ)
Supplier Name & Code	100987-FLASH VIVEN MACHINING TECHNOLO
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	MIX UP OTHER MODEL-MIXUP GEAR 74 TEETH AGAINST 75 TEETH

1. Problem Description

Defect Description	MIX UP OTHER MODEL-MIXUP GEAR 74 TEETH AGAINST 75 TEETH
Detection Stage	Customer End
Problem Severity	Fitment
NG Quantity	7
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	sgn.quality@flashgroup.in
Plant Head/CEO Email ID	dkj.mfg@flashgroup.in
MD Email ID	sv.md@flashgroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	1000	0	2000	800	5800
Check Qty	2000	1000	0	2000	800	5800
NG Qty	10	0	0	0	0	10

Action taken on NG part

Scrap	10
Rework	0
Under Deviation	0

Containment Action

Check pipeline material with White dot marking on gear Face

3. Process Flow

Process Flow Description

CNC-Hobbing-HT-Bore Honning-Teeth Honning-Final Inspection-Packing-Dispatch

4. Process Details

Process / Operation	Dispatch
Outsource	No
Machine / Cell	Dispatch
Machine / Cell No.	Dispatch

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Part Mix up	Yes	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	100%

7. Root Cause Analysis (Occurance)

Why 1	Mix-up of two parts JE551427 & JZ551400. During Final packaging operation
Why 2	Packing of part no JE551427 & JZ551400 at the same location .
Why 3	Separate location not defined
Why 4	
Why 5	
Root Cause (Occurance)	Partwise separate location not defined

Root Cause Analysis (Outflow)

Why 1	Part not capture at Packing area
Why 2	No awareness
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	1. Visual Inspection & Input inspected Parts not identified.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	1.Partwise separation location to be defined to avoided part mix-up.	RBP/AD	12/05/2022	12/05/2022	Completed
Outflow	1. After Inspection identification will be provided (color code) 2. Inspection table separately, similar part inspection are defined different location. 3. OPL & Q alert Displayed	AD	10/05/2022	12/05/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection table separately, similar part inspection are defined different location.
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)	1. Partwise separate location not defined 108_Occurance_Before.xlsx
Occurance (After)	1.Partwise separation location to be defined to avoided part mix-up. 108_Occurance_After.xlsx
Outflow (Before)	1. Visual Inspection & Input inspected Parts not identified. 108_Outflow_Before.xlsx
Outflow (After)	1. After Inspection identification will be provided (color code) 2. Inspection table separately, similar part inspection are defined different location. 3. OPL & Q alert Displayed 108_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	JZ & PF model

12. Document Review

Documents	ProcessFlowChart, PackingStd
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	5000
Reason for submission	ok