

Defect Details

NC No.	8000788179
NC Date	20/05/2022
NC Submission Date	
Part No.	F2DZ07712B
Part Name	FORK BOLT J1D Ni-Cr plated
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M38 THREADING NOT OK

1. Problem Description

Defect Description	M38 Threading Not ok- GO gauge not qualify
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	99
Is Defect Repeatative?	Yes
Defect Sketch / Photo	jq1zd3jwblx5fndf34ouof2.pptx

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	2500	0	1000	1500	7000
Check Qty	2000	2500	0	1000	1500	7000
NG Qty	1	1	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action

100% sorting done at warehouse and at supplier end 01 Ng piece found.

3. Process Flow

Process Flow Description

1.R.M INSPECTION 2. PART OFF 3. ANEALING 4. PHOSPHATING 5. FORGING 6. HEX BUFFING 7. CNC 1ST 8. CNC 2ND 9. BUFFING 10. SURFACE TREATMENT 11. FINAL INSPECTION 12. PACKING.

4. Process Details

Process / Operation	TRANSPORTATION
Outsource	No
Machine / Cell	WAREHOUSE
Machine / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	DURING TRANSPORTATION 1 PIECE FELL DOWN FROM BOX AND THREAD GOT DAMAGE	VALIDATED	O
Method	INSPECTION METHOD NOT EFFECTIVE	VALIDATED AND FOUND OK	X
Tool	ROLLING DIE WEAR	VALIDATED AND FOUND OK	X
Machine	NUT BOLTS MAY LOOSE	VALIDATED AND FOUND PROPERLY TIGHT	X
Material	RAW MATERIAL GRADE NOT OK	VALIDATED AND FOUND OK	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	50/1200

7. Root Cause Analysis (Occurance)

Why 1	M38 THREAD NOT OK
Why 2	THE PROBLEM OCCURED AT TRANSPORTATION STAGE
Why 3	DURING TRANSPORTATION 1 PIECE FELL DOWN FROM BOX AND THREAD GOT DAMAGE
Why 4	OPERATOR WAS NEW AND PUT THE NG PART ALONG WITH THE OK PART BIN.
Why 5	SO 1 PIECE OF THREAD DAMAGE GOT MIXED WITH FINISHED MATERIAL
Root Cause (Occurance)	DURING TRANSPORTATION 1 PIECE FELL DOWN FROM BOX AND THREAD GOT DAMAGE.

Root Cause Analysis (Outflow)

Why 1	M38 THREAD NOT OK
Why 2	OPERATOR WAS NEW AND NOT AWARE ABOUT THIS DEFECT
Why 3	THIS TYPE OF PROBLEM CAME FIRST TIME SO THE DEFECTED PART SKIPPED FROM INSPECTION
Why 4	SO FINAL INSPECTOR WAS NOT ABLE TO DETECT THE PROBLEM
Why 5	SO NG PART DISPATCHED TO CUSTOMER
Root Cause (Outflow)	OPERATOR WAS NEW AND NOT AWARE ABOUT THIS DEFECT.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	WORK INSTRUCTIONS GIVEN TO OPERATOR ABOUT THE DEFECT AND HANDLE THE MATERIAL WITH PROPER CARE.	RAJU	14/05/2022	21/05/2022	Completed
Outflow	WORK INSTRUCTIONS GIVEN TO OPERATOR ABOUT THE DEFECT AND TO CHECK THE MATERIAL WITH GAUGE BEFORE PACKING AND DISPATCH.	UMED	14/05/2022	21/05/2022	Completed
Occurance	EARLIER THE MATERIAL WAS PACKED IN BOX AND PIECES WERE IN LOOSE POSITION . NOW WE STARTED PACKING THE MATERIAL IN STANDARDS BINS. SO AS TO PREVENT THE MATERIAL FROM DENT AND DAMAGES	RAJU	13/05/2022	21/05/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NO CHANGE
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50/1200

10. Evidence of Countermeasure

Occurance (Before)	MATERIAL WAS PACKED IN LOOSE POSITION IN BOXES 131_Occurance_Before.jpeg
Occurance (After)	STANDARD BINS ARE STARTED FOR PACKING. 131_Occurance_After.jpeg
Outflow (Before)	NOT AVAILABLE 131_Outflow_Before.pdf
Outflow (After)	WORK INSTRUCTIONS 131_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NOT APPLICABLE

12. Document Review

Documents	WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok