

Defect Details

NC No.	8000789394
NC Date	30/05/2022
NC Submission Date	
Part No.	S2BY03451B
Part Name	CANISTER SQR GROOVE LEAK TESTED
Supplier Name & Code	100465-PN DIE CASTINGS PVT LTD
ETL Plant	1126-ETL Pantnagar
Defect Details	DIMN.O/SIZE.-GR0OVE WIDTH OVERSIZE

1. Problem Description

Defect Description	Groove Dim. 4.10+0.10 observed upto 4.32,4.40,4.45 and the Step height 2±0.10 just below the Groove observed as 1.64,1.53,1.62. and Dim. 1.50+0.10 observed as 1.24,1.36,1.31
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1335
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qualityqh@bansaldiecastings.com
Plant Head/CEO Email ID	gm@bansaldiecastings.com
MD Email ID	piyush@bansaldiecastings.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1500	0	0	3000	100	4600
Check Qty	1500	0	0	3000	100	4600
NG Qty	1500	0	0	3000	100	4600

Action taken on NG part

Scrap	4600
Rework	0
Under Deviation	0

Containment Action

1.Segrigated all store ,wip & Assly area at customer end(1500 qty) by the leak testing machine and found All part not ok- Akshay 2.Segrigated all store & wip at BDC end(3100 qty) by the HG & VC 60 nos and 3040 nos by template ,found All part not ok- Bhuvan

3. Process Flow

Process Flow Description

10.RM receiving & inspection 20.Die casting & inspection 30.Fettling & Filing 40.Shot blasting 50.Drilling 60.VMC machining.....(Incident station) 70.Air cleaning 80.Impregnation 90.Pin Pressing 100.Leak Testing 110.Final inspection 120.Packing & storage 130.Dispatch

4. Process Details

Process / Operation	Machining/Grooving
Outsource	No
Machine / Cell	VMC09/Machining
Machine / Cell No.	VMC09/B03

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Groove tool not ok	Groove tool inspection not done	X
Machine	Vibration in machine, new machine, New Fixture	PM check sheet & 4M verified , Found ok	O
Material	Wrong grade	MTC & LTC verified , Found ok	O
Man	Untrained operator/ inspector	Skill matrix verified & found ok	O
Method	Groove inspection is not done during FPA	FPA report verified & found groove inspection point missing	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	First piece approval
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	0

7. Root Cause Analysis (Occurance)

Why 1	Leakage in Canister
Why 2	Groove O Ring loose
Why 3	Groove width over size
Why 4	Groove tool not ok
Why 5	
Root Cause (Occurance)	Groove tool not Ok

Root Cause Analysis (Outflow)

Why 1	Leakage in Canister
Why 2	Groove O Ring loose
Why 3	Groove width over size
Why 4	Groove width inspection Point miss in FPA report & PDI report

Why 5	
Root Cause (Outflow)	Groove width inspection Point miss in FPA report

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1.Quality alert 2. Tool incoming inspection report 3.Set up approval report	Abhay saxena & Akshay	02/06/2022	02/06/2022	Completed
Outflow	1.OPL 2.OJT 3.Point Add in FPA Report 4.Point add in PDI report	Akshay	03/06/2022	03/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1.1 no's groove width inspection in every shift(During FPA) by VC in every shift after parting of sample part . 2. 1 no's groove width inspection in every lot(During PDI) by VC in every lot after parting of sample part .
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1

10. Evidence of Countermeasure

Occurance (Before)	No tool Inspection report 156_Occurance_Before.xlsx
Occurance (After)	Tool inspection report available 156_Occurance_After.xlsx
Outflow (Before)	Groove width inspection Point miss in FPA report & PDI report 156_Outflow_Before.xlsx
Outflow (After)	Groove width inspection Point miss added in FPA report & PDI report 156_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	No

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, AuditCheckSheet, InspCheckSheet
Specify Other Document	FPA & PDI report

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	Found OK