

Defect Details

NC No.	8000790797
NC Date	10/06/2022
NC Submission Date	
Part No.	F1DZ00902B
Part Name	FORK BOLT K86A
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	OIL LEAKAGE-OIL LEAKAGE DUE TO FORK BOLT CENTER HOLE

1. Problem Description

Defect Description	K0YA Fort fork oil leakage through fork bolt compliant came from HMSI -3F because K86 fork bolt center hole available
Detection Stage	Customer End
Problem Severity	Function
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	maheshmishra@sangkaj.com
Plant Head/CEO Email ID	pardeshinr@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5000	0	0	2300	0	7300
Check Qty	5000	0	0	2300	0	7300
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action

All pipeline material 100% sagrigated and material keep aside for with identification marking.

3. Process Flow

Process Flow Description

1.RM INWARD & INSPECTION - 2.TRAUB MACHINE CUTTING AND DRILL - 3.CNC 1ST SETUP - 4.CNC 2ND SETUP - 5.ACROSS FLAT MILLING - 6.DEBURRING - 7. PLATING -8.FINAL INSPECTION -9.DISPATCH

4. Process Details

Process / Operation	TRAUB MACHINING
Outsource	No
Machine / Cell	TRAUB SECTION
Machine / Cell No.	52

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Machine condition is not ok	Machine condition is ok daily check sheet verified	O
Man	New manpower	Operator skilled and skill matrix verified.	O
Man	New operator	Operator is old	O
Man	Not aware about process	Manpower aware about process	O
Machine	Adjustment nut worn out & Loose	Adjustment nut worn out & Loose Found	X
Machine	Machine is not in working	Machine is in working condition	O
Method	Wrong judgment during visual	Judgement is wrong because marking is provided on centre of the fork bolt	X
Material	RM Damages	Material checked and found ok	O
Method	Wrong training	Correct training is provided	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Through hole observed in Fork Bolt K-86
Why 2	Excess depth of material cut
Why 3	Drill travels more than its limit.
Why 4	Adjustment nut of stopper was loose
Why 5	Adjustment nut worn out
Root Cause (Occurance)	Adjustment nut worn out

Root Cause Analysis (Outflow)

Why 1	Through hole observed in Fork Bolt K-86
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Why 2	Skipped from final inspector during inspection
Why 3	Judgement is wrong because marking is provided on center of the fork bolt.
Why 4	
Why 5	
Root Cause (Outflow)	Judgement is wrong because marking is provided on center of the fork bolt.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Stopper Adjustment nut replaced with new one.	Mr. Raut santosh	13/06/2022	13/06/2022	Completed
Occurance	Stopper double lock nut used for tightening.	Mr. Raut santosh	13/06/2022	13/06/2022	Completed
Outflow	Skip from inspection due to wrong judgment so awareness given to inspector.	Shende P	10/06/2022	13/06/2022	Completed
Occurance	Step drill used at semi finish stage to maintain drill depth size	Mr. Raut santosh	11/06/2022	13/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NA
Inspection Method	Other
Other Inspection Method	Visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

10. Evidance of Countermeasure

Occurance (Before)	Adjustment nut worn out 169_Occurance_Before.pptx
Occurance (After)	Stopper double lock nut used for tightening. 169_Occurance_After.pptx
Outflow (Before)	Judgement is wrong because marking is provided on centre of the fork bolt . 169_Outflow_Before.xlsx
Outflow (After)	Skip from inspection due to wrong judgment so awareness given to inspector. 169_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan, PMCheckSheet, WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	