

Defect Details

NC No.	8000794827
NC Date	11/07/2022
NC Submission Date	
Part No.	F800506307
Part Name	STEERING SHAFT WELD ASLY. P/C
Supplier Name & Code	100066-MARATHWADA AUTO COMPO PVT. LTD
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	DIAMETER OVER SIZE-O D O/S LINGTH O/SIZE

1. Problem Description

Defect Description	Dia/Threading/Total Length Over size
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	98
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qaunderbkt@macpl.com
Plant Head/CEO Email ID	sdkulkarni@macpl.com
MD Email ID	ajit.macpl@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	300	0	0	100	100	500
Check Qty	300	0	0	100	100	500
NG Qty	98	0	0	0	0	98

Action taken on NG part

Scrap	98
Rework	0
Under Deviation	0

Containment Action

CHECK 100% JOB AT ETL & MACPL END

3. Process Flow

Process Flow Description

4. Process Details

Process / Operation	CNC TURNING
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	CNC

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	TOTAL LENGTH GAUGE WEAR OUT	CMM (CMM REPORT FOUND GAUGE WEAROUT)	O

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	ST.SHAFT TOTAL LENGTH O/S AT ETL END
Why 2	SKIF AT FINAL INSPECTION OR CAUGE CALIBRATION NOT DONE
Why 3	FINAL INSPECTION MARKING AVAILABLE ON JOB BUT FOUND OVER SIZE AT CUSTOMER
Why 4	TOTAL LENGTH GAUGE FOUND OVER SIZE AT CNC MACHINE .
Why 5	
Root Cause (Occurance)	TOTAL LENGTH CHECKING GAUGE FOUND OVER SIZE

Root Cause Analysis (Outflow)

Why 1	ST.SHAFT TOTAL LENGTH O/S AT ETL END
Why 2	SKIF AT FINAL INSPECTION OR CAUGE CALIBRATION NOT DONE
Why 3	FINAL INSPECTION MARKING AVAILABLE ON JOB BUT FOUND OVER SIZE AT CUSTOMER
Why 4	TOTAL LENGTH GAUGE FOUND OVER SIZE ON FINAL INSPECTION
Why 5	
Root Cause (Outflow)	TOTAL LENGTH GAUGE FOUND OVER SIZE ON FINAL INSPECTION

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
------	------------------------	----------------	-------------	-------------	--------

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	1.)BEFORE START PRODUCTION WILL CHECK TOTAL LENGTH ON HEIGHT GAUGE.2) TOTAL LENGTH GAUGE CHECK ON CMM EVERY MONTH.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	CMM GAUGE NOT DONE 197_Occurance_Before.jpg
Occurance (After)	GAUGE CORRECTION 197_Occurance_After.jpg
Outflow (Before)	CMM GAUGE NOT DONE 197_Outflow_Before.jpg
Outflow (After)	GAUGE CORRECTION 197_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	InspCheckSheet
Specify Other Document	na

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	Issue Resolved