

## Defect Details

<b>NC No.</b>	8000795498
<b>NC Date</b>	18/07/2022
<b>NC Submission Date</b>	
<b>Part No.</b>	550LG06202
<b>Part Name</b>	SEAT PIPE -K23A/PRFH-006
<b>Supplier Name &amp; Code</b>	100929-HARSHAD ENGINEERING COMPANY
<b>ETL Plant</b>	1146-ETL Suspension Narasapura
<b>Defect Details</b>	MIX UP OTHER MODEL-LENGTH LESS MIX UP NOT USING KON MODEL

## 1. Problem Description

<b>Defect Description</b>	KON front fork seat pipe total length less mix up repeated issue compression one through hole available
<b>Detection Stage</b>	Inprocess
<b>Problem Severity</b>	Fitment
<b>NG Quantity</b>	50
<b>Is Defect Repeatative?</b>	Yes
<b>Defect Sketch / Photo</b>	<a href="#">hy34ct1limjq3bxzroomdguv.xlsx</a>

## Supplier Communication Details

<b>Quality Head Email ID</b>	qaharshad@gmail.com
<b>Plant Head/CEO Email ID</b>	qaharshad@gmail.com
<b>MD Email ID</b>	auto.mitesh@gmail.com

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	4000	0	0	2150	5550	11700
<b>Check Qty</b>	4000	0	0	0	0	4000
<b>NG Qty</b>	20	0	0	0	0	20

## Action taken on NG part

<b>Scrap</b>	20
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

100 % sorting done for ETL End, HEC WIP & FG material

## 3. Process Flow

**Process Flow Description**

Cutting-Draw-Forging(Head Formation)-Rough Grinding-CNC (Head, Boring &amp; Tapping)-Punching-Finish Grinding-Final Inspection-Packing-Dispatch

**4. Process Details**

<b>Process / Operation</b>	Inspection & packing
<b>Outsource</b>	No
<b>Machine / Cell</b>	Packing & Inspection
<b>Machine / Cell No.</b>	120-A & B

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Man	Mix-up while packing & Inspection	Mix-up while polybag filling& Packing	O

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Visual Inspection
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100 %

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	Mix-up with other model
<b>Why 2</b>	Mix-up while packing
<b>Why 3</b>	No separate color identification to polybag
<b>Why 4</b>	use standard polybag for packing
<b>Why 5</b>	
<b>Root Cause (Occurance)</b>	No separate color identification to polybag

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	Mix-up with other model
<b>Why 2</b>	While polybag sealing manual parts counting done
<b>Why 3</b>	weight polybag & Box not done/Measured
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	weight polybag & Box not done/Measured

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Yellow color polybag used for PRFH	VAibhav	29/07/2022	27/07/2022	Completed

Outflow	Polybag & box weight done	Vaibhav	29/07/2022	27/07/2022	Completed
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## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	Box wt. done after packing on weighing scale & modelwise wt. chart displayed
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Manual Polybag fill
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100 %

## 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	standard color polybag used for all seat pipes <a href="#">202_Occurance_Before.jpg</a>
<b>Occurance (After)</b>	Yellow color polybag used for PRFH seat pipe <a href="#">202_Occurance_After.jpg</a>
<b>Outflow (Before)</b>	Box & polybag wt. not done <a href="#">202_Outflow_Before.jpg</a>
<b>Outflow (After)</b>	Box & polybag wt. done as per modelwise wt. chart <a href="#">202_Outflow_After.jpg</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	Packing & Dispatch section

## 12. Document Review

<b>Documents</b>	WISOP, ProcessFlowChart, PackingStd
<b>Specify Other Document</b>	NA

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	3000
<b>Reason for submission</b>	reviewed 3000 number found ok