

## Defect Details

<b>NC No.</b>	8000795961
<b>NC Date</b>	18/07/2022
<b>NC Submission Date</b>	
<b>Part No.</b>	520FL03012
<b>Part Name</b>	HEX NUT
<b>Supplier Name &amp; Code</b>	100165-SAPTAGIRI INDUSTRIES
<b>ETL Plant</b>	1116-ETL K-120 Suspension
<b>Defect Details</b>	TAPPING U/SIZE.-TAPPING UNDERSIZE.

## 1. Problem Description

<b>Defect Description</b>	Go gauge not answer. Major quantity rejected after segregation at ETL end.
<b>Detection Stage</b>	Receipt
<b>Problem Severity</b>	Fitment
<b>NG Quantity</b>	3068
<b>Is Defect Repeatative?</b>	Yes
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality@saptagirigroup.in
<b>Plant Head/CEO Email ID</b>	production@saptagirigroup.in
<b>MD Email ID</b>	argandhi@saptagirigroup.in

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

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	15500	0	0	2000	2000	19500
<b>Check Qty</b>	15500	0	0	2000	2000	19500
<b>NG Qty</b>	3472	0	0	0	0	3472

## Action taken on NG part

<b>Scrap</b>	0
<b>Rework</b>	3472
<b>Under Deviation</b>	0

## Containment Action

100 % verify all material by thread plug gauge

## 3. Process Flow

**Process Flow Description**

RM receipt , RM Inspection ,Blanking ,Piercing , Both side chamfer ,Tapping , Plating , Final inspection , Packing

**4. Process Details**

<b>Process / Operation</b>	Tapping
<b>Outsource</b>	No
<b>Machine / Cell</b>	Tapping machine
<b>Machine / Cell No.</b>	Tapping Machine no 2

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Tool	Chamfer tool ware out	Burr observed at ending of thread	O
Method	NA	NA	O

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

<b>Inspection Method</b>	Gauge
<b>Other Inspection Method</b>	
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	Sampling
<b>Sampling</b>	No
<b>Sample Size</b>	10 NOS

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

<b>Why 1</b>	GO not passing through out into the thread
<b>Why 2</b>	Burr observed at ending of thread
<b>Why 3</b>	Step mark on chamfer
<b>Why 4</b>	Chamfer angle more that is 55 degree against 45 degree
<b>Why 5</b>	Chamfer tool warn out
<b>Root Cause (Occurance)</b>	Chamfer tool warn out

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	GO not passing through out into the thread
<b>Why 2</b>	Sample inspection
<b>Why 3</b>	
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	Sample inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Chamfer angle corrected as require 45 degree	Mr. kiran Jadhaw	20/07/2022	20/07/2022	Completed
Outflow	thread inspection sampling increases by 100 nos per 1000 nos lot	Mr. Kiran Jadhaw	20/07/2022	20/07/2022	Completed

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	100% inspection started by thread plug gauge
<b>Inspection Method</b>	Gauge
<b>Other Inspection Method</b>	
<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>	Burr observed at ending of thread Step mark on chamfer Chamfer angle more that is 55 degree against 45 degree Chamfer tool warn out <a href="#">205_Occurance_Before.pdf</a>
<b>Occurance (After)</b>	No burr on chamfer No Step mark on chamfer angle . Chamfer angle corrected as require 45 degree . Chamfer angle verified on profile projector <a href="#">205_Occurance_After.pdf</a>
<b>Outflow (Before)</b>	Sample inspection by thread plug gauge <a href="#">205_Outflow_Before.pdf</a>
<b>Outflow (After)</b>	100 % inspection started by thread plug gauge <a href="#">205_Outflow_After.pdf</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	Other Parts of threading

## 12. Document Review

<b>Documents</b>	ControlPlan
<b>Specify Other Document</b>	control plan

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	1000
<b>Reason for submission</b>	Completed.