

Defect Details

NC No.	8000802161
NC Date	29/08/2022
NC Submission Date	
Part No.	520FN04002
Part Name	HOLDER CLUTCH
Supplier Name & Code	100150-DHANANJAY ENTERPRISES
ETL Plant	1135-ETL 7/10 P Nagar
Defect Details	DIMN.O/SIZE.-ID OVERSIZE

1. Problem Description

Defect Description	ID OVERSIZE/UNDER SIZE ISSUE.
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	3
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qade@dhananjaygroup.com
Plant Head/CEO Email ID	gunjalvs@dhananjaygroup.com
MD Email ID	kandakuretn@dhananjaygroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	0	0	0	0	2000
Check Qty	2000	0	0	0	0	2000
NG Qty	3	0	0	0	0	3

Action taken on NG part

Scrap	3
Rework	0
Under Deviation	0

Containment Action

Segregate the whole lot at the ETL End/DEPL End

3. Process Flow

Process Flow Description

Blanking/Piercing_Deburring_Chamfering_CNC Machining_Final Inspection_Cleaning_Dispatch

4. Process Details

Process / Operation	CNC Machining
Outsource	No
Machine / Cell	CNC Machining
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	in final inspection Air Plug gauge Skipped by the inspector	as final inspection (Air Plug Gauge Not done 100%) as Air Plug gauge Unit is under calibration	O
Machine	In Deburring no contribution for hole oversize	No Contribution	X
Tool	In Blanking/Piercing Premachining Hole	We have verified after blanking operation Premachining hole is ok	X
Method	In Machining its chance to mix up the part (Setting Part/Rework part)	Yes its having possibility to mixup the rejected parts (Setting Parts)at machine stage	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	In CNC machining ID Oversize by 0.2
Why 2	100% Air Gauge parts not checked
Why 3	Setting Part get mix up by operator
Why 4	
Why 5	
Root Cause (Occurance)	Due to there is no Red Bin Available at machine stage so Rejected parts get mixed up

Root Cause Analysis (Outflow)

Why 1	As 100% Air Plug gauge Checking at Final Stage as well as Machine stage
Why 2	100% Plug gauge not Done for final inspection
Why 3	As Air gauge unit is under Calibration so that 100% inspection not done at final stage
Why 4	
Why 5	
Root Cause (Outflow)	As Air Gauge Unit is under calibration so that 100% inspection not done at final stage

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Now we have kept Red bin with lock and key for rejection parts (Set up /rework parts)	Mr. Gaurav Nikam	05/09/2022		Completed
Outflow	Duble Ended Plain Plug Gauge (Carbide Go) 26.020-26.041 procured as contingency of Air Gauge Unit (if Air gauge unit is under calibration so far used PPG for 100% Inspection at Final Inspection Stage)	Mr. Gaurav Nikam	05/09/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No Changed
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)	Due to there is no Red Bin Available at machine stage so Rejected parts get mixed up 231_Occurance_Before.xlsx
Occurance (After)	Now we have kept Red bin with lock and key for rejection parts (Set up /rework parts) 231_Occurance_After.xlsx
Outflow (Before)	As Air Gauge Unit is under calibration so that 100% inspection not done at final stage 231_Outflow_Before.xlsx
Outflow (After)	Duble Ended Plain Plug Gauge (Carbide Go) 26.020-26.041 procured as contingency of Air Gauge Unit (if Air gauge unit is under calibration so far used PPG for 100% Inspection at Final Inspection Stage) 231_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	
Specify Other Document	No Any Other Documen

13. Effectiveness Of Action

Reviewed Quantity	
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