

Defect Details

NC No.	8000802992
NC Date	06/09/2022
NC Submission Date	
Part No.	F2GN20502B
Part Name	MAIN SPRING
Supplier Name & Code	100952-STUMPP SCHUELE AND SOMAPPA SPR
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	HIGHT O/SIZE.-LINGTH OVER SIZE

1. Problem Description

Defect Description	Free length found over size by 1 MM.
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	66
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	hravikumar@ssssprings.com
Plant Head/CEO Email ID	sreenivasulu.k@ssssprings.com
MD Email ID	rln@ssssprings.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	0	0	1000
Check Qty	1000	0	0	0	0	1000
NG Qty	66	0	0	0	0	66

Action taken on NG part

Scrap	66
Rework	0
Under Deviation	0

Containment Action

After Receipt a complaint 100 % inspection verified to Free Length

3. Process Flow

Process Flow Description

4. Process Details

Process / Operation	100% Lo Inspection
Outsource	No
Machine / Cell	FF Cell
Machine / Cell No.	FF Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Due to Initial Stage Free Length not added into Regular WI	Yes	O

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	05

7. Root Cause Analysis (Occurance)

Why 1	Due to Initial Stage Free Length not added into Regular WI
Why 2	This 100% Length Sorting done on 2 Inspection Stage
Why 3	1of the Operator less aware about this Specification
Why 4	
Why 5	
Root Cause (Occurance)	Specification not displayed on Regular inspection Table,

Root Cause Analysis (Outflow)

Why 1	During Sample basis Inspection done of 1 Operator
Why 2	Due to 05 No`s Sample inspection done to only 1 opearotor
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Sample inspection done to Only 1 Opearator

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

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

Occurance	Initial Stage Free Length will be added into Regular WI	Mr. Ishwar Jadhav	09/09/2022	09/09/2022	Completed
Outflow	Sample inspection will be done by QA to each operator	Mr. Shivkumar Fartade	07/09/2022	07/09/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sample inspection will be done by QA to each operator
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	02/E OP.

10. Evidance of Countermeasure

Occurance (Before)	Due to Initial Stage Free Length not added into Regular WI 242_Occurance_Before.pdf
Occurance (After)	Specification not displayed on Regular inspection Table, 242_Occurance_After.pdf
Outflow (Before)	During Sample basis Inspection done of 1 Operator 242_Outflow_Before.jpg
Outflow (After)	Sample inspection will be done by QA to each operator 242_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	FF Cell

12. Document Review

Documents	WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	66
Reason for submission	we have checked this lot and found ok.