

Defect Details

| | |
|---------------------------------|---------------------------------|
| NC No. | 8000805177 |
| NC Date | 22/09/2022 |
| NC Submission Date | |
| Part No. | F1BF04133M |
| Part Name | OUTER TUBE M/C LH- KOLA DISC |
| Supplier Name & Code | 100017-DEKSON CASTINGS LIMITED. |
| ETL Plant | 1146-ETL Suspension Narasapura |
| Defect Details | FITMENT NOT OK.-BTA ID ISSUES |

1. Problem Description

| | |
|-------------------------------|---|
| Defect Description | BTA ID ISSUE |
| Detection Stage | Inprocess |
| Problem Severity | Fitment |
| NG Quantity | 94 |
| Is Defect Repeatative? | No |
| Defect Sketch / Photo | dr3tcca01njs00mekriaf3pk.pptx |

Supplier Communication Details

| | |
|--------------------------------|---------------------------|
| Quality Head Email ID | quality@dekson.co.in |
| Plant Head/CEO Email ID | mr@dekson.co.in |
| MD Email ID | chetandekate@dekson.co.in |

2. Stock Details & action taken for NG parts

| Location | ETL End | Warehouse | Transit | Supplier FG | Supplier WIP | Total |
|------------------|---------|-----------|---------|-------------|--------------|-------|
| Total Qty | 200 | 0 | 0 | 0 | 300 | 500 |
| Check Qty | 200 | 0 | 0 | 0 | 300 | 500 |
| NG Qty | 1 | 0 | 0 | 0 | 0 | 1 |

Action taken on NG part

| | |
|------------------------|---|
| Scrap | 1 |
| Rework | 0 |
| Under Deviation | 0 |

Containment Action

All suspected part checked

3. Process Flow

Process Flow Description

Inward-Melting-Degassing-GDC-Riser Cutting-fettling grinding-GDC Q Gate- SPM-HT-VMC-BTA-BufferingFinal-Inspection- Dispatch

4. Process Details

| | |
|----------------------------|-----|
| Process / Operation | BTA |
| Outsource | No |
| Machine / Cell | BTA |
| Machine / Cell No. | 4 |

5. Problem Analysis

| Type | Possible Cause | Fact Verification | Jud |
|------|-------------------|-------------------------------|-----|
| Tool | BTA Tool Wear out | Tool wear out before life end | X |

6. Inspection Method Analysis (Current)

| | |
|--|------------|
| Inspection Method | Gauge |
| Other Inspection Method | |
| Check Point at Final Inspection | No |
| Checking Freq. | Sampling |
| Sampling | No |
| Sample Size | 2 per hour |

7. Root Cause Analysis (Occurance)

| | |
|-------------------------------|-------------------------------|
| Why 1 | FITMENT NOT OK.-BTA ID ISSUES |
| Why 2 | BTA ID having minor line mark |
| Why 3 | Tool Wear out |
| Why 4 | |
| Why 5 | |
| Root Cause (Occurance) | Tool Wear out |

Root Cause Analysis (Outflow)

| | |
|-----------------------------|-------------------------------|
| Why 1 | FITMENT NOT OK.-BTA ID ISSUES |
| Why 2 | Part skipped from inspection |
| Why 3 | oversight by inspector |
| Why 4 | |
| Why 5 | |
| Root Cause (Outflow) | oversight by inspector |

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

| Type | Countermeasure Details | Responsibility | Target Date | Actual Date | Status |
|-----------|------------------------|----------------|-------------|-------------|-----------|
| Occurance | Tool changed | Mr. Ingle | 30/09/2022 | 28/09/2022 | Completed |

9. Inspection Method After Customer Complaint

| | |
|--|----------|
| Change In Inspection System | No |
| Change Details | No |
| Inspection Method | Gauge |
| Other Inspection Method | |
| Check Point at Final Inspection | Yes |
| Checking Freq. | Sampling |
| Sampling | No |
| Sample Size | 5 |

10. Evidence of Countermeasure

| | |
|---------------------------|---|
| Occurance (Before) | Tool wear out 262_Occurance_Before.jpeg |
| Occurance (After) | Tool life monitoring after tool changed 262_Occurance_After.jpeg |
| Outflow (Before) | BTA line mark 262_Outflow_Before.jpg |
| Outflow (After) | OPL Displayed 262_Outflow_After.jpeg |

11. Horizontal Deployment

| | |
|---|---------|
| Horizontal Deployment Required | Yes |
| Applicable Machine / Model / Plant | All BTA |

12. Document Review

| | |
|-------------------------------|-----------------|
| Documents | AuditCheckSheet |
| Specify Other Document | No |

13. Effectiveness Of Action

| | |
|------------------------------|-------------------------------|
| Reviewed Quantity | 1000 |
| Reason for submission | reviewed 1000 number found ok |