

Defect Details

NC No.	8000807219
NC Date	08/10/2022
NC Submission Date	
Part No.	S2BG02502B
Part Name	BRACKET UN P/C KTEP
Supplier Name & Code	100973-TESMO MOTORCAST PRIVATE LIMITE
ETL Plant	1116-ETL K-120 Suspension
Defect Details	DIMN.U/SIZE.-I D NOT OK

1. Problem Description

Defect Description	Fitment parameter $\varnothing 22.50 \pm 0.2$ mm observed not OK. Same causing bush fitment not ok at assembly stage.
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	100
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rkhare@tesmomotorcast.com
Plant Head/CEO Email ID	harish.bala@tesmomotorcast.com
MD Email ID	svkallani@tesmomotorcast.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5000	0	0	3000	10100	18100
Check Qty	5000	0	0	3000	10100	18100
NG Qty	100	0	0	0	50	150

Action taken on NG part

Scrap	150
Rework	0
Under Deviation	0

Containment Action

ID CHECKING STARTED IN FINAL STAGE

3. Process Flow

Process Flow Description

PDC - REMER - DEBURRING - SURFACE TREATMENT - CHAMFER - TAPPING - AIR CLEANING - PACKING

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	DIE CASTING MACHINE
Machine / Cell No.	205-01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Reamer Id under size	instrument	O
Tool	PUNCH OD UNDERSIZE	DIEMETER CHECKING	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	100

7. Root Cause Analysis (Occurance)

Why 1	Diameter under size
Why 2	punch die undertime on die
Why 3	punch worn-out
Why 4	die life over
Why 5	die life monitoring not done
Root Cause (Occurance)	die lift monitoring not done

Root Cause Analysis (Outflow)

Why 1	Diameter undertime
Why 2	diameter checking not done
Why 3	point not included in check sheet
Why 4	
Why 5	
Root Cause (Outflow)	Diameter checking points not available in check sheet

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Die life monitoring started	Scahin	01/04/2023	01/04/2023	Completed
Outflow	Diameter check point added in first piece inspection check sheet	Rahul	01/04/2023	01/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Point added in first piece inspection
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	300

10. Evidence of Countermeasure

Occurance (Before)	Diameter undersize 279_Occurance_Before.jpeg
Occurance (After)	Diameter ok 279_Occurance_After.jpeg
Outflow (Before)	Diameter undersize 279_Outflow_Before.jpeg
Outflow (After)	Diameter ok 279_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	KWPK

12. Document Review

Documents	InspCheckSheet
Specify Other Document	Inspection

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	