

Defect Details

NC No.	8000818048
NC Date	23/01/2023
NC Submission Date	
Part No.	F2DZ09002B
Part Name	FORK BOLT -K17E
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M26 GAUGE AND MATING PART NOT QUALIFY

1. Problem Description

Defect Description	M26 Threads found damage so not qualifying with mating part
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	480
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1600	0	0	0	0	1600
Check Qty	1600	0	0	0	0	1600
NG Qty	810	0	0	0	0	810

Action taken on NG part

Scrap	0
Rework	810
Under Deviation	0

Containment Action

100% MATING PART INSPECTION DONE AT ALL THE MATERIAL LYING AT VARIOUS STAGES .

3. Process Flow

Process Flow Description

1.RM 2.PART OFF 3.PUNCHING 4.DRILLING+COUNTER 5.TAPPING 6.CNC TURNING 7.FINAL INSPECTION 8.PACKING AND DISPATCH (ROHTAK TO AURANGABAD)9.SURFACE TREATMENT 10.FINAL SORTING 11. PACKING AND DISPATCH(AURANGABAD TO ETL)

4. Process Details

Process / Operation	TRANSPORTATION (ROHTAK TO WAREHOUSE AURANGABAD)
Outsource	No
Machine / Cell	TRANSPORTATION
Machine / Cell No.	TRANSPORTATION

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	ROLLING DIE MAY WEAR	VALIDATED AND FOUND OK	X
Material	RM SIZE AND GRADE NOT OK	VALIDATED AND FOUND OK	X
Machine	NUT BOLTS MAY LOOSE	VALIDATED AND FOUND OK	X
Man	MISHANDLING OF MATERIAL	DURING TRANSPORTATION THREAD OF PART WAS NOT PROPERLY COVERED AND THREAD GOT DAMAGE OF SOME PIECES	O
Method	INSPECTION METHOD NOT EFFECTIVE	VALIDATED AND FOUND EFFECTIVE	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	ACC.PLAN

7. Root Cause Analysis (Occurance)

Why 1	M26 THREAD NOT OK
Why 2	DURING TRANSPORTATION FROM ROHTAK TO WAREHOUSE THREAD GOT DAMAGE
Why 3	THREAD WERE NOT PROPERLY COVERED
Why 4	SO THREAD GOT DAMAGE
Why 5	
Root Cause (Occurance)	DURING TRANSPORTATION FROM ROHTAK TO WAREHOUSE THREAD GOT DAMAGE.THREAD WERE NOT PROPERLY COVERED.SO THREAD GOT DAMAGE.

Root Cause Analysis (Outflow)

Why 1	M26 THREAD NOT OK
Why 2	TRANSPORT FACILITY WAS FIRST SHARED WITH OTHER COMPANIES.
Why 3	DURING TRANSPORT HANDLING OF MATERIAL WAS NOT EFFECTIVE
Why 4	SO NG PARTS DISPATCHED TO CUSTOMER
Why 5	

Root Cause (Outflow)

TRANSPORT FACILITY WAS FIRST SHARED WITH OTHER COMPANIES.DURING TRANSPORT HANDLING OF MATERIAL WAS NOT EFFECTIVE.SO NG PARTS DISPATCHED TO CUSTOMER

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	THREADS WERE PROPERLY COVERED WITH CAP AND PROPER BOX USED FOR PACKING THE MATERIAL TO AVOID THE CONTACT OF MATERIAL WITH EACH OTHER	GANESH MAURYA	30/01/2023	31/01/2023	Completed
Outflow	TRANSPORTATION FACILITY CHANGED. NOW OUR MATERIAL WILL BE DISPATCHED DIRECTLY FROM ROHTAK TO WAREHOUSE WITH SINGLE TRANSPORT TO AVOID THE MISHANDLING OF MATERIAL.	GANESH MAURYA	30/01/2023	31/01/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NO CHANGE
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	PLAN

10. Evidance of Countermeasure

Occurance (Before)	MATERIAL WAS PACKED WITHOUT CAP. 345_Occurance_Before.pdf
Occurance (After)	CAP COVERED THE THREADS FROM DENT AND DAMAGES DURING TRANSPORTATION. 345_Occurance_After.pdf
Outflow (Before)	TRANSPORTATION WAS NOT PROPER AND SHARED WITH OTHER COMPANY MATERIAL. 345_Outflow_Before.pdf
Outflow (After)	MATERIAL WILL BE DISPATCHED DIRECTLY FROM ROHTAK TO WAREHOUSE(AURANGABAD) WITH PROPER CARE AND HANDLING. 345_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	ALL FORK BOLTS

12. Document Review

Documents	PackingStd
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Next lot verified and found ok