

Defect Details

NC No.	8000818063
NC Date	23/01/2023
NC Submission Date	
Part No.	F20508007B
Part Name	UND BKT SUB-ASSEMBLY (K17B/D)
Supplier Name & Code	100061-BAJAJSONS LIMITED
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-BALL RACE OD FOUND UNDERSIZE

1. Problem Description

Defect Description	Ball race OD found undersize
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	kasingh@bajajsons.com
Plant Head/CEO Email ID	crbansal@bajajsons.com
MD Email ID	sanjay.bajaji@bajajsons.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	600	1200	300	200	200	2500
Check Qty	600	600	0	200	200	1600
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action

All customer end , warehouse, transit & FG stock will re-check for this issue before dispatch to customer.

3. Process Flow

Process Flow Description

Pipe cutting-ID Deburring-Flaring-ID. Boring for bush fitting- Bush fitting-Bush welding- Length sizing & counterering -CNC Turning-Thread rolling-Grinding 1st-Grinding 2nd- To Assy.

4. Process Details

Process / Operation	Grinding
Outsource	No
Machine / Cell	Centerless Grinding machine
Machine / Cell No.	CGM-01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Improper handling of setting part at Grinding machine	During verification found that setting part did not identify after setting,resulting part mixed up w	X
Tool	Chips stuck on control wheel	During verification found that control wheel dressing done freq.	O
Man	Unskilled manpower	During verification found that skilled manpower deployed	O
Method	Improper handling of NG part	During verification found that NG part did not identify	X
Material	Material hardness less	MTC verified & found ok	O
Machine	machine Spindle jam	During verification found that machine is ok	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	Setting part mix up
Why 2	Setting part mix up due to setting part kept at wrong place
Why 3	Setting part kept at wrong place due to neglegency of operator
Why 4	Neglegency of operator due to lack of awareness
Why 5	
Root Cause (Occurance)	Neglegency of operator due to lack of awareness

Root Cause Analysis (Outflow)

Why 1	NG part skipped from inspection stage
Why 2	OK part mix up in NG part
Why 3	Mix up due to no identified of NG part
Why 4	NG part did not identify due to neglegency of checker
Why 5	

Root Cause (Outflow)

NG part did not identify due to negligence of checker

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Awareness given to machine operator for proper handling of NG part. A special lock type provision will be implement for setting part handling	Vijay Singh	04/02/2023	31/01/2023	Completed
Outflow	Awareness given to checker for proper identification of NG part & after identification NG part should be kept in lock & key provision	Sandeep	31/01/2023	30/01/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	NG part will identify & after that part will kept in lock & key provision
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)	NG Part kept at wrong place 346_Occurance_Before.jpg
Occurance (After)	NG Part kept at defined place 346_Occurance_After.jpg
Outflow (Before)	NG part kept without identification 346_Outflow_Before.jpg
Outflow (After)	NG Part identified ang kept in lock & key 346_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Other grinding machines

12. Document Review

Documents	PFMEA
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity

100

Reason for submission

Verified next 3 lot and found ok