

Defect Details

NC No.	8000820728
NC Date	16/02/2023
NC Submission Date	
Part No.	F1BF04016M
Part Name	OUTER TUBE BUFF RH- KOLA DRUM
Supplier Name & Code	100001-ANANT ENTERPRISES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	DIAMETER OVER SIZE-DUBUSH,OI SEAL AND DUSTSEAL DIA OVERSIZE

1. Problem Description

Defect Description	Bottom case Du bush ,oil seal and Dust seal over size Repeated issue
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	9
Is Defect Repeatative?	Yes
Defect Sketch / Photo	1a32ymnot22m5ocd3cuqbppg.xlsx

Supplier Communication Details

Quality Head Email ID	anandkulkarni@anantgroup.co.in
Plant Head/CEO Email ID	pramodgosavi@anantgroup.co.in
MD Email ID	ashwinjoshi@anantgroup.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2500	0	1500	0	1533	5533
Check Qty	2500	0	1500	0	1533	5533
NG Qty	15	0	0	0	66	81

Action taken on NG part

Scrap	81
Rework	0
Under Deviation	0

Containment Action

Dust seal dia,42.2 + - 0.1 ,Oil seal dia, 42+0.039 and Du-bush dia,33.03-33.06 bore diameter checked 100% at final stage .

3. Process Flow

Process Flow Description

Inward inspection -OP-10 VMC Machining - OP-20 BTA Machining - Leak testing - Visual inspection - Buffing - Visual inspection - Packing - Dispatch

4. Process Details

Process / Operation	OP-10 VMC Machining / PCD Finish Boring
Outsource	No
Machine / Cell	Chiron DZ 18W / Machine cell - 1
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	4th axis worm wheel worn out.	Disassemble the 4th axis and visually observed worn out wheel.	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

7. Root Cause Analysis (Occurance)

Why 1	4th axis brake release at the time of 90 degree rotation.
Why 2	4th axis worm wheel clearance observed.
Why 3	4th axis worm wheel worn out.
Why 4	Checking the condition of the worm wheel were not present in the preventive maintenance check sheet.
Why 5	This point was not anticipated considered during finalization of the planned preventive maintenance check sheet.
Root Cause (Occurance)	TRC :- 4th axis worm wheel worn out. MRC:- This point was not anticipated considered during finalization of the planned preventive maintenance check sheet.

Root Cause Analysis (Outflow)

Why 1	less checking frequency defined.
Why 2	Control plan will be addressed hourly basis.
Why 3	PFMEA not addressed all potential causes.
Why 4	No awareness of this type of defect occurs in machining.
Why 5	
Root Cause (Outflow)	1.less checking frequency defined. 2.PFMEA not addressed all potential causes.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Outflow	100% inspection at final inspection stage.	Mukund Ghawane	20/02/2023	20/02/2023	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% oil seal bore dia 42+0.04 and dust seal bore 42.2 +-0.1 ,du-bush bore 33.03-33.06 checked with air plug gauge at final stage.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

10. Evidence of Countermeasure

Occurance (Before)	PREVENTIVE MAINTENANCE CHECK SHEET 366_Occurance_Before.pdf
Occurance (After)	UPDATED PREVENTIVE MAINTENANCE CHECK SHEET 366_Occurance_After.pdf
Outflow (Before)	WORK INSTRUCTIONS FOR VMC MACHINE 366_Outflow_Before.pdf
Outflow (After)	UPDATED WORK INSTRUCTIONS FOR VMC MACHINE. 366_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CHIRON / DZ18W / ANANT ENTERPRISES PLOT NO 3/3 MIDC PIMPRI PUNE-411018

12. Document Review

Documents	ControlPlan, PMCheckSheet, PFMEA, WISOP, InspCheckSheet
Specify Other Document	ONE POINT LESSON

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	Verified 200 numbers lot invoice number AE/00012/23-24 found ok