

Defect Details

NC No.	8000824014
NC Date	21/03/2023
NC Submission Date	
Part No.	B2BQ01726O
Part Name	SCREW FOR FASTENING CAP - C101CBS
Supplier Name & Code	100846-SANGKAJ ENGINEERING PVT.LTD.
ETL Plant	1156-ETL Disc Brake P'Nagar
Defect Details	DIMETER UNDERSIZE-LENGTH SHORT

1. Problem Description

Defect Description	Length short pieces mix up issue
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	207
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	aslam@sangkaj.com
Plant Head/CEO Email ID	pardeshinr@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	37000	0	0	0	0	37000
Check Qty	37000	0	0	0	0	37000
NG Qty	207	0	0	0	0	207

Action taken on NG part

Scrap	207
Rework	0
Under Deviation	0

Containment Action

Segregation done at ETL by supplier.

3. Process Flow

Process Flow Description

Wire draw-Cold forging-rolling-HT-plating-FID-PDI-packing- dispatch

4. Process Details

Process / Operation	Heat treat
Outsource	No
Machine / Cell	Continuous mesh belt furnace
Machine / Cell No.	Furnace no. 02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Material mixup at HT loading stage	Cause verified	O
Man	Material mix-up at packing stage	cause verified	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	as per std

7. Root Cause Analysis (Occurance)

Why 1	Short length pcs found at customer end
Why 2	Similar part of other model found in OK material
Why 3	Both Material having common process like Heat treatment
Why 4	Heat treat is continuous mesh belt ,which is loaded continuously.
Why 5	No gap between in similar parts while loading for heat treatment.
Root Cause (Occurance)	WI is inadequate, no any instruction to avoid such kind of mix-up

Root Cause Analysis (Outflow)

Why 1	Short length pcs found at customer end, mixed with regular part.
Why 2	Mixed parts were similar to ok parts.
Why 3	Material is being packed on floor.
Why 4	Similar parts are lying on floor when packing of material.
Why 5	Packing station is not proper.
Root Cause (Outflow)	Packing stage is not proper.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Outflow	Separate and proper stage for packing of material.	Aslam Shaikh	28/03/2023	27/03/2023	Completed
Occurance	Work instruction is provided with training ,to avoid mix-up.	Datta Kale	28/03/2023	27/03/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	Packing method has been changed.
Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	No instruction has been provided to maintaining gap between similar parts. 392_Occurance_Before.pdf
Occurance (After)	Work instruction is updated , converted into local language and updated for maintaining gap in similar parts. 392_Occurance_After.pdf
Outflow (Before)	Packing of material was being done on shop floor, and other material is lying near by place. 392_Outflow_Before.jpg
Outflow (After)	Packing of material is being done on table and no other material is permitted on table. 392_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Socket head bolts

12. Document Review

Documents	PFMEA, WISOP
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	done