

Defect Details

NC No.	8000825878
NC Date	10/04/2023
NC Submission Date	
Part No.	B2HF03624O
Part Name	MCYL PISTON ANODISED-Ø12,K2 FRONT
Supplier Name & Code	100505-A B AUTOCOMPONENTS
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	HIGHT O/SIZE.-EXCESS TIP AT TOP SIDE OF PISTON

1. Problem Description

Defect Description	Loose ring observed in part
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	4
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	headqaabauto@gmail.com
Plant Head/CEO Email ID	kamalabautocomponent@gmail.com
MD Email ID	abautocomponent@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	0	2000	3000
Check Qty	1000	0	0	0	2000	3000
NG Qty	4	0	0	0	0	4

Action taken on NG part

Scrap	4
Rework	0
Under Deviation	0

Containment Action

Available 2000nos verified at AB.

3. Process Flow

Process Flow Description

RM - Turning - Tip grinding - Inspection - Anodizing - Final inspection - PDIR - Dispatch.

4. Process Details

Process / Operation	Turning
Outsource	No
Machine / Cell	Master Piston Cell
Machine / Cell No.	Master Piston Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Nil	RM OK as per MTC	O
Man	No manual intervention in this problem	No manual intervention	O
Method	Yes	Some parts we are getting	X
Tool	Nil	Tool ok	O
Machine	Nil	Machine found ok as per check sheet.	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Tip & Ring found in parts.
Why 2	Generating in the process
Why 3	
Why 4	
Why 5	
Root Cause (Occurance)	Process Problem

Root Cause Analysis (Outflow)

Why 1	Tip & Ring found in parts.
Why 2	Skipped from the inspection
Why 3	New Inspector.
Why 4	
Why 5	
Root Cause (Outflow)	New inspector.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	1. Awareness given to the inspectors at final inspection. 2. Defect photos available in defect matrix	Harshith	22/04/2023	22/04/2023	Completed
Occurance	1. Process improvement taken place but still not controlled 100%, 2. Manual tip grinding doing.	Sudhir	25/04/2023	25/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	Awareness given to inspectors.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	
Occurance (After)	
Outflow (Before)	
Outflow (After)	

11. Horizontal Deployment

Horizontal Deployment Required	
Applicable Machine / Model / Plant	

12. Document Review

Documents	
Specify Other Document	

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	