

Defect Details

NC No.	8000827660
NC Date	26/04/2023
NC Submission Date	
Part No.	5230103200
Part Name	THROTTLE CONTROL PULLY FOR H BAR ASSLY
Supplier Name & Code	101086-PUNE POLYMERS PVT. LTD.
ETL Plant	1102-ETL L-6 Die Casting
Defect Details	FITMENT NOT OK.-ID 21.95 UNDERSIZE

1. Problem Description

Defect Description	Fitment ID dia 21.95 undersize . Spec 21.95 observed 21.7. to 21.80
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	42
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qa.waluj@punepolymers.com
Plant Head/CEO Email ID	planthead.waluj@punepolymers.com
MD Email ID	s.gupta@punepolymers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	0	5000	8000
Check Qty	3000	0	0	0	5000	8000
NG Qty	0	0	0	0	300	300

Action taken on NG part

Scrap	0
Rework	300
Under Deviation	0

Containment Action

100 % inspection with gauge & green marking for confirmation.

3. Process Flow

Process Flow Description

Receipt - Injection molding - Annealing - De-flashing -Inspection

4. Process Details

Process / Operation	Injection molding
Outsource	No
Machine / Cell	Injection mold shop
Machine / Cell No.	IM 100T

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Less dia of punch in mold	22.04 mm against requirement of 22.20 mm	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	DVC
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10 Nos

7. Root Cause Analysis (Occurance)

Why 1	Fitment issue
Why 2	ID undersize.
Why 3	Punch dia less (22.04 mm) in the mold.
Why 4	
Why 5	
Root Cause (Occurance)	Punch dia less (22.04 mm) in the mold.

Root Cause Analysis (Outflow)

Why 1	Fitment issue
Why 2	ID undersize.
Why 3	Not detected in sampling.
Why 4	
Why 5	
Root Cause (Outflow)	Not detected in sampling.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
	New punch with increased dia of 22.20 mm replaced to				

Occurance	meet ID dimensions as per specification 21.95 ± 0.1 mm.	Balu Kasbe	25/05/2023	Inprocess
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection by Plug gauge instead of DVC
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100 %

10. Evidence of Countermeasure

Occurance (Before)	Punch dia less (22.04 mm) in the mold. 439_Occurance_Before.xlsx
Occurance (After)	New punch with increased dia of 22.20 mm replaced to meet ID dimensions as per specification 21.95 ± 0.1 mm. 439_Occurance_After.xlsx
Outflow (Before)	Not detected in sampling. 439_Outflow_Before.xlsx
Outflow (After)	100 % inspection of part by QA inspector by "GO" "NOGO" plug gauge before thread weaving of part & green marking for confirmation. 439_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Throttle control pulley 24191101

12. Document Review

Documents	PMCheckSheet, PFMEA, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	