

Defect Details

NC No.	8000833477
NC Date	20/06/2023
NC Submission Date	
Part No.	S1GD01726B
Part Name	INNER TUBE CHAMFERED KOLA
Supplier Name & Code	101273-SAPTAGIRI ENGINEERING PRIVATE
ETL Plant	1136-ETL Suspension Sanand
Defect Details	LESS CHAMFER-CHAMFER NG

1. Problem Description

Defect Description	ID gauge not qualifying (Chamfer NG and bend).
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	90
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@saptagirigroup.in
Plant Head/CEO Email ID	production@saptagirigroup.in
MD Email ID	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	3000	0	0	2000	8000
Check Qty	3000	3000	0	0	2000	8000
NG Qty	90	0	0	0	0	90

Action taken on NG part

Scrap	0
Rework	90
Under Deviation	0

Containment Action

100 % material verified by visual

3. Process Flow

Process Flow Description

Raw Tube + Cutting + Both Side chamfer + Inspection

4. Process Details

Process / Operation	Chamfer
Outsource	No
Machine / Cell	01
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Clamp loosed	No Rigid clamping provided	X
Man	Inspector not aware	Inspector not aware about the chamfer	X
Tool	Insert Ware out or broken	No Insert warn out and broken	O
Machine	Uneven tube cutting done	No uneven cutting done its parallelism observed within 0.1 mm	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	Less Chamfer / Chamfer Uneven
Why 2	W.r.t. center outer tube clamping alignment disturb
Why 3	O/t Clamping plate loosed
Why 4	Capsule slot given for bolt locking of the clamping plate
Why 5	
Root Cause (Occurance)	Capsule slot given for bolt locking of the clamping plate

Root Cause Analysis (Outflow)

Why 1	Less Chamfer / Chamfer Uneven
Why 2	Inspector Not aware about defect
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Inspector Not aware about defect

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Awareness training given to inspector	Mr. Dhiraj Patil	27/06/2023	26/06/2023	Completed
Occurance	Rigid bolt engage with clamping plate including spring tension washer to avoided clamping plate loosed issue	Mr. Pravin Jonwal	27/06/2023	26/06/2023	Completed
Occurance	For verification of O/t clamping plate point has added in daily machine check sheet	Mr. Pravin Jonwal	27/06/2023	26/06/2023	Completed
Outflow	100 % visul inspection started as per one point lesson and Q alert Display at work place	Mr. Dhiraj Patil	27/06/2023	26/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	Na
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)	Implementation & Action for Less chamfer 491_Occurance_Before.pptx
Occurance (After)	Implementation & Action for Less chamfer 491_Occurance_After.pptx
Outflow (Before)	Implementation & Action for Less chamfer 491_Outflow_Before.pptx
Outflow (After)	Implementation & Action for Less chamfer 491_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All type of Inner Tube

12. Document Review

Documents	PokayokeCheckSheet
Specify Other Document	Na

13. Effectiveness Of Action

Reviewed Quantity	3
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