

Defect Details

NC No.	8000842148
NC Date	26/08/2023
NC Submission Date	
Part No.	F2GN25602B
Part Name	MAIN SPRING Ø33 SPD
Supplier Name & Code	101225-HELICAL SPRINGS
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	LENGTH OVERSIZE-FREE LENGTH OVERSIZE OBS.375MM

1. Problem Description

Defect Description	Free length over size by 3 mm.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	229
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality.waluj@helicalsprings.in
Plant Head/CEO Email ID	shaikhmoin@helicalsprings.in
MD Email ID	ataneja@helicalsprings.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1500	0	0	800	1000	3300
Check Qty	1500	0	0	800	1000	3300
NG Qty	229	0	0	0	0	229

Action taken on NG part

Scrap	229
Rework	0
Under Deviation	0

Containment Action

Problem Verified And Checked All Material in Stock.

3. Process Flow

Process Flow Description

Raw Material Receipt & Inspection, Coiling, Stress Relieving, End Grinding, Shot Peening, Scragging, Length & Wavyness checking, Strain-aging, Surface Finish-Oiling, Final Inspection/ PDI, Packing, Dispatch.

4. Process Details

Process / Operation	Satge Of Packing.
Outsource	No
Machine / Cell	NA
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Wrong Material Mix	Skill Matrix Found Ok	O
Tool	NA	Check Sheet Found Ok	O
Material	RMTC Found Ok	TC Verification	O
Method	Area Not Identified For New Developments Parts.	Stock sheet Verification	X
Machine	Herdon	Verified Ok	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Length Oversize
Why 2	Other Material Mixed With Ok Parts
Why 3	Both Are The Similar Looking Items
Why 4	Storing In Same Place
Why 5	Due To No Route cards Available For NPD Parts.
Root Cause (Occurance)	No Identification (Route Card) Placed in NPD Parts.

Root Cause Analysis (Outflow)

Why 1	Length Oversize
Why 2	Not Detected During PDIR Due To Less Qty.
Why 3	PDIR Done On Sampling Basis.
Why 4	
Why 5	
Root Cause (Outflow)	Sample Size Not Sufficient To Detect The Issue (Only 5 Nos for 1000)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Route Cards Started For Development Parts.	Production	30/08/2023		Completed
Outflow	Sampling Plan Increased For Next 3 Lots (20 Nos Per 1000Nos)	QA	30/08/2023		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling Plan Increased.
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)	Route Cards Not Available For NPD Parts 535_Occurance_Before.pdf
Occurance (After)	Route Card Available For NPD Parts 535_Occurance_After.pdf
Outflow (Before)	Area Not Defined For NPD Parts. 535_Outflow_Before.pdf
Outflow (After)	Area Defined and Training Given to Packing and Dispatch Station Employee. 535_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Similar Parts

12. Document Review

Documents	ProcessFlowChart, InspCheckSheet
Specify Other Document	Route Cards

13. Effectiveness Of Action

Reviewed Quantity	10000
Reason for submission	No any concern observed after action plan submitted.

