

Defect Details

NC No.	8000848572
NC Date	13/10/2023
NC Submission Date	
Part No.	B2SU01102O
Part Name	ETL ABS MTG BKT PLATINA B106J(SILVER)
Supplier Name & Code	100144-AURANGABAD PRESSINGS
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	FLATNESS NOT OK.-FLATNESS NOT OK

1. Problem Description

Defect Description	FLATNESS NOT OK.-FLATNESS NOT OK
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	63
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
Plant Head/CEO Email ID	aurangabadpressings@apw3.co.in
MD Email ID	shashikant@apw3.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	800	0	0	200	500	1500
Check Qty	800	0	0	200	500	1500
NG Qty	63	0	0	0	0	63

Action taken on NG part

Scrap	20
Rework	43
Under Deviation	0

Containment Action

flattening Tool Die & punch reshaping

3. Process Flow

Process Flow Description

Blanking-Piercing -logo - 1St forming -2 nd forming-flattening

4. Process Details

Process / Operation	flattning
Outsource	No
Machine / Cell	machine No 10
Machine / Cell No.	press shop

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Inspection method change	Inspection for flatness 5 nos component every Bin before dispatch	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	surface plate
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos

7. Root Cause Analysis (Occurance)

Why 1	Gap between bracket & modular
Why 2	Flatness not ok
Why 3	Punch Pressure not applied on bracket total area
Why 4	
Why 5	
Root Cause (Occurance)	Punch & die plate surface uneven

Root Cause Analysis (Outflow)

Why 1	Gap between bracket & modular
Why 2	Flatness not ok
Why 3	Punch Pressure not applied on bracket total area
Why 4	
Why 5	
Root Cause (Outflow)	Punch & die plate surface uneven

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Punch & die plate surface uneven	D D Ingale	16/10/2023		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling inspection 5 nos every Bin before Dispatch
Inspection Method	Other
Other Inspection Method	Gap between bracket
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos /Bin

10. Evidence 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	