

Defect Details

NC No.	8000852794
NC Date	24/11/2023
NC Submission Date	
Part No.	D3AD00500M
Part Name	SHAFT CUT LENGTH (R122C MAXIMA Z)
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1152-ETL L-6/3/1DrivShaft
Defect Details	LENGTH OVERSIZE-LENGTH O/S BY 1 TO 2MM

1. Problem Description

Defect Description	Total Length Oversize by 1 to 2mm
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	1000
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	irfan@sangkaj.com
Plant Head/CEO Email ID	steel@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	7000	0	0	800	0	7800
Check Qty	1005	0	0	10	0	1015
NG Qty	1000	0	0	10	0	1010

Action taken on NG part

Scrap	0
Rework	1000
Under Deviation	0

Containment Action

Segregation Pipeline material at ETL end & pipeline In-house material.

3. Process Flow

Process Flow Description

Bar cutting- -Straightening -Grinding-final inspection- Packing -Dispatch

4. Process Details

Process / Operation	Bar cutting
Outsource	No
Machine / Cell	Troub M/c
Machine / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
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6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	LENGTH OVERSIZE-LENGTH O/S BY 1 TO 2 MM
Why 2	Bar End pics mix-up in OK qty
Why 3	Bar End pics Area not defined
Why 4	
Why 5	
Root Cause (Occurance)	Bar End pics Area not defined.

Root Cause Analysis (Outflow)

Why 1	LENGTH OVERSIZE-LENGTH O/S BY 1 TO 2 MM
Why 2	T.L Oversize not detect in Final inspection .
Why 3	Total Length Check as Sampling basis as per standard.
Why 4	
Why 5	
Root Cause (Outflow)	Total Length Check as Sampling basis as per standard.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	T.L C type Snap gauge provided to M/C&final inspection. T.L 100% check by C type Snap gauge	Operator /inspector	04/12/2023	04/12/2023	Completed

Occurance	Bar End Pics Area defined.	QA inspector	29/11/2023	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	T.L C type Snap gauge provided to M/C . T.L 100% check by C type Snap gauge.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	100%
Sampling	No
Sample Size	100 %

10. Evidence of Countermeasure

Occurance (Before)	Bar End pics Area not defined 599_Occurance_Before.jpeg
Occurance (After)	Bar End pics Area defined 599_Occurance_After.jpeg
Outflow (Before)	Total Length Check as Sampling basis as per standard by H.G. 599_Outflow_Before.jpeg
Outflow (After)	T.L C type Snap gauge provided to final inspection. T.L 100% check by C type Snap gauge. 599_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Man & Method

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	