

Defect Details

NC No.	8000854740
NC Date	12/12/2023
NC Submission Date	
Part No.	B2SU01002O
Part Name	BRAKE HOSE TUBE CLAMP 2 (N282)
Supplier Name & Code	100151-EXCELL PRESSINGS
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	OTHER-BENDING NOT OK

1. Problem Description

Defect Description	BENDING NOT OK
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	393
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	excellpressings.qc@gmail.com
Plant Head/CEO Email ID	yogesh_vaidya42@yahoo.co.in
MD Email ID	excellpressings@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4000	0	0	3000	2000	9000
Check Qty	4000	0	0	3000	2000	9000
NG Qty	393	0	0	0	0	393

Action taken on NG part

Scrap	393
Rework	0
Under Deviation	0

Containment Action

100% inspection is done at ETL end and our end also

3. Process Flow

Process Flow Description

Blanking& piercing- Z bending- Lug bending- U bending- Final Forming

4. Process Details

Process / Operation	press operation
Outsource	No
Machine / Cell	EP-04
Machine / Cell No.	EP-04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Old location pin was wear out	Due to wear out location pin, ,movement took place of part on die	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Hole not mached after full closing at ETL end
Why 2	In U bending operations, movement took place
Why 3	location pin was wear out
Why 4	New operator was on machine at U Bending operations
Why 5	That operator was not aware about the location pin wear out
Root Cause (Occurance)	In U bending operation, shifting took place due to location pin wear out

Root Cause Analysis (Outflow)

Why 1	Full closing operation is take place at ETL end
Why 2	Partial closing at our end, cant check every job by doing full closing at our end
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Every job full closing cant be done at our end, as we have to supply partial closing job.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	New location pin will be provided, so that movement cant be take place	Nikhil Ghodmare & Ankosh Mathure	20/12/2023	20/12/2023	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling of folding jobs at our end will be increased
Inspection Method	Other
Other Inspection Method	Rod & block
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10

10. Evidance of Countermeasure

Occurance (Before)	location pin wear out 614_Occurance_Before.jpg
Occurance (After)	old location pin changed and new one added 614_Occurance_After.jpg
Outflow (Before)	Hole not meet after full closing at ETL end 614_Outflow_Before.jpg
Outflow (After)	Hole meet after full closing 614_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	At Excell pressings, hole should be matched after full closing

12. Document Review

Documents	PMCheckSheet, JHCheckSheet, InspCheckSheet
Specify Other Document	FFPA checksheet

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	No defect found in latest lot