

## Defect Details

<b>NC No.</b>	8000859440
<b>NC Date</b>	18/01/2024
<b>NC Submission Date</b>	
<b>Part No.</b>	520DW01303
<b>Part Name</b>	FLANGE BOLT SUZUKI
<b>Supplier Name &amp; Code</b>	100073-SINGLA FORGING (P) LTD
<b>ETL Plant</b>	1117-ETL K-228/9 Suspension
<b>Defect Details</b>	NOT AS PER SPECIFICATION-THREAD NG/ OVERSIZE

## 1. Problem Description

<b>Defect Description</b>	Fitment issue - Thread NG
<b>Detection Stage</b>	Inprocess
<b>Problem Severity</b>	Fitment
<b>NG Quantity</b>	28
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality@singlaforging.in
<b>Plant Head/CEO Email ID</b>	quality@singlaforging.in
<b>MD Email ID</b>	jain@singlaforging.com

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	5028	0	0	0	0	5028
<b>Check Qty</b>	5028	0	0	0	0	5028
<b>NG Qty</b>	28	0	0	0	0	28

## Action taken on NG part

<b>Scrap</b>	28
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

segrsdmklxfd

## 3. Process Flow

**Process Flow Description**

10 RM 20 FORGING 30 FACING &amp; COLLAR MACHINING 40 ROLLING 50 H/T 60 SURFACE PLATING 70 FINAL INSPECTION 80 PACKING 90 DISPATCH

**4. Process Details**

<b>Process / Operation</b>	COLLAR MACHINING
<b>Outsource</b>	No
<b>Machine / Cell</b>	TURNING TRAUB MACHINING
<b>Machine / Cell No.</b>	01

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Method	TOOL FREQUENCY RESHARPNING WAS NOT EFFECTIVE	TOOL LIFE REVALIDATION DONE	X
Man	OPERATOR WAS SKILLED	SKILL MATRIX VERIFIED	X

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	VISUAL INSPECTION
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	THE PROBLEM OCCURED AT FACING & COLLAR MACHINING STAGE OF MANUFACTURING SEQUENCE
<b>Why 2</b>	THE FACING TOOL WAS WEAR RESULTED INTO BURR ON FACE
<b>Why 3</b>	THE RESHARPNING FREQUENCY FOR THE CUTTING TOOL WAS DEFINED 200 NO'S
<b>Why 4</b>	RESHARPNING FREQUENCY WAS NOT EFFECTIVE, NEED TO BE REVALIDATED AS RAISED CUSTOMER COMPLAINT
<b>Why 5</b>	
<b>Root Cause (Occurance)</b>	RESHARPNING FREQUENCY WAS NOT EFFECTIVE, NEED TO BE REVALIDATED AS RAISED CUSTOMER COMPLAINT

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	VISUALLY INSPECTION WAS NOT EFFECTIVE
<b>Why 2</b>	THOUGH INSPECTOR WAS SKILLED YET IF A FEW PARTS SKIPPED FROM VISUAL INSPECTION
<b>Why 3</b>	
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	THOUGH INSPECTOR WAS SKILLED YET IF A FEW PARTS SKIPPED FROM VISUAL INSPECTION

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	THOUGH INSPECTOR WAS SKILLED YET IF A FEW PARTS SKIPPED FROM VISUAL INSPECTION	Mr. RAM HARESH	01/02/2024	12/02/2024	Completed
Outflow	DEDICATED PERSON APPOINTED	Mr. AMBHOORE	08/02/2024	14/02/2024	Completed

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	No
<b>Change Details</b>	DEDICATED INSPECTOR DEPLOYED, SKILL MATRIX REVIEWED AFTER SHIFT OVER
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	100% VISUAL
<b>Check Point at Final Inspection</b>	No
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

## 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	EVIDANCE ATTACHED <a href="#">637_Occurance_Before.xlsx</a>
<b>Occurance (After)</b>	EVIDANCE ATTACHED <a href="#">637_Occurance_After.xlsx</a>
<b>Outflow (Before)</b>	EVIDANCE ATTACHED <a href="#">637_Outflow_Before.jpeg</a>
<b>Outflow (After)</b>	EVIDANCE ATTACHED <a href="#">637_Outflow_After.jpeg</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	No
<b>Applicable Machine / Model / Plant</b>	NO

## 12. Document Review

<b>Documents</b>	
<b>Specify Other Document</b>	OJT

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	352
<b>Reason for submission</b>	Checked found ok