

Defect Details

NC No.	8000867015
NC Date	13/03/2024
NC Submission Date	
Part No.	550DZ05202
Part Name	FORK BOLT :PRFH-006
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1116-ETL K-120 Suspension
Defect Details	NOT AS PER SPECIFICATION-AFTER ASSLY LEAKAGE FOUND

1. Problem Description

Defect Description	Fork bolt Oil Leakage through Blow hole
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	2
Is Defect Repeatative?	No
Defect Sketch / Photo	vzrcupqzjwcv04yu3ocopnr.png

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	7000	0	0	0	0	7000
Check Qty	7000	0	0	0	0	7000
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action

stocks checked 100% material All stage but no any part get this types

3. Process Flow

Process Flow Description

1-R/M ,2-PART OFF ,3-TAPPING 4-RE-TAPPING ,5-FLAT BUFFING IF NECESSARY ,6-THREAD ROLLING ,7-SURFACE TREATMENT ,8-FINAL INSPECTION 9-PAACKING

4. Process Details

Process / Operation	RAW MATERIAL GRAIN FLOW OVER SIZE
Outsource	Yes
Machine / Cell	RAW MATERIAL
Machine / Cell No.	N/A

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	DRILL DEPTH OVER SIZE	VALIDATED AND FOUND OK	O
Method	INSPECTION PLAN NOT EFFECTIVE	VALIDATED AND FOUND INSPECTION PLAN NOT EFFECTIVE SO PART SKIPPED FROM FINAL INSPECTION	X
Man	UNAWARENESS OF OPERATOR	VALIDATED AND FOUND OK	O
Material	RAW MATERIAL MIX -UP OTHER NG MATERIAL	VALIDATED AND FOUND NG MATERIAL MIX UP	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	SAMPL PLAN

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-AFTER ASSLY LEAKAGE FOUND
Why 2	RAW MATERIAL GRAIN FLOW OVER SIZE
Why 3	HOLD RAW MATERIAL MIX-UP OK MATERIAL
Why 4	
Why 5	
Root Cause (Occurance)	HOLD RAW MATERIAL MIX-UP OK MATERIAL

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-AFTER ASSLY LEAKAGE FOUND
Why 2	INSPECTION PLAN WAS NOT EFFECTIVE
Why 3	NG PART SKIPPED FROM INSPECTION
Why 4	SO NG PART DELIEVERED TO CUSTOMER
Why 5	
Root Cause (Outflow)	INSPECTION PLAN WAS NOT EFFECTIVE

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	INSPECTION FREQUENCY CHANGE TO 100%	GANESH MAURYA	31/03/2024	31/03/2024	Completed
Occurance	NG MATERIAL RED PAINT MARK	GANESH MAURYA	31/03/2024	31/03/2024	Completed
Outflow	FIFO SYSTEM MAINTAIN IN RAW MATERIAL STAGE	GANESH MAURYA	31/03/2024	31/03/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % MATERIAL CHECKED
Inspection Method	Other
Other Inspection Method	R/M GRAIN FLOW CHECK
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	BRFORE REJECTION RED PAINT MARK NOT AVAILABLE 710_Occurance_Before.xlsx
Occurance (After)	AFTER REJECTION RED PAINT MARK AVAILABLE 710_Occurance_After.xlsx
Outflow (Before)	BEFORE - INSPECTION AS PER SAMPLING PLAN 710_Outflow_Before.xlsx
Outflow (After)	AFTER - 100% CHECKED MATERIAL 710_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	FORK BOLT (PRFH-006/K23A)

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	15
Reason for submission	Rejection material identification started. WI required.

