

Defect Details

NC No.	8000872282
NC Date	24/04/2024
NC Submission Date	
Part No.	550FA19033
Part Name	FORK PIPE M/CED-(HMS-30 & HMP-30)
Supplier Name & Code	101186-SANGKAJ BRIGHT WIRES PRIVATE L
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	THREADING NOT OK-M26 THREAD NO GO QUALIFY

1. Problem Description

Defect Description	Fork pipe M26 x 1-6H Thread No Go Qualify and After Assembly Mating Part Open in process due to thread NG.
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	11
Is Defect Repeatative?	No
Defect Sketch / Photo	sx54kcwuj1hqagksy3cng00.jpg

Supplier Communication Details

Quality Head Email ID	shivpal@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	15500	0	0	4900	0	20400
Check Qty	15500	0	0	4900	0	20400
NG Qty	11	0	0	2	0	13

Action taken on NG part

Scrap	13
Rework	0
Under Deviation	0

Containment Action

segregation of all fork pipe line material at customer ETL Halol as well as inhouse

3. Process Flow

Process Flow Description

000.Receipt of Material, 010 inward inspection, 020 CNC Turn1st, 030 CNC Turn-2nd , 040 Drilling, 050 Final Inspection, 060 Anti Rust Oil Application, 070Air Cleaning, 080 Dispatched

4. Process Details

Process / Operation	020 CNC Turn1st
Outsource	No
Machine / Cell	CNC fork pipe
Machine / Cell No.	CNC 02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	WEAR OFFSET LOCK	WEAR OFFSET NOT LOCK IN CNC MACHINE	X
Man	NEW OPERATOR	SKILLED OPERATOR	O
Material	MATERIAL HARDNESS MORE	MATERIAL HARDNESS OK	O
Method	INSERT CHANGE WI	INSERT CHANGE WI NOT AVAILABLE	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	5nos/hrs

7. Root Cause Analysis (Occurance)

Why 1	M26X1-6H Threading NO-GO Tight
Why 2	threading minor diameter was at higher side
Why 3	at the time of correction operator taken 0.3mm offset instead of 0.03mm
Why 4	wrong offset given by operator
Why 5	wear offset not lock in CNC machine
Root Cause (Occurance)	Wear offset not lock in CNC Machine.

Root Cause Analysis (Outflow)

Why 1	M26X1-6H Threading No-Go Tight
Why 2	Inspection skipped by Operator and line Inspector
Why 3	Inspection Done On Sampling Basis. (5 Nos / Lot)
Why 4	
Why 5	
Root Cause (Outflow)	Inspection Done On Sampling Basis. (5 Nos / Lot).

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	At Final Inspection stage we have started the 100% inspection at with the help of thread plug gauge up to till date no any defective part found. We will doing inspection upto 15.05.2024. Then we will doing inspection as per IS 2500 Standard.	Mr. Amol Rathod	25/04/2024	25/04/2024	Completed
Occurance	wear offset locked by 0.03mm in CNC machine	Mr. Bijay maity	25/04/2024	25/04/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Inspection with the help of thread plug gauge & plug gauge before supply the ETL With identification mark on Ok Part.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	ALL PART

10. Evidance of Countermeasure

Occurance (Before)	Wear offset not lock in CNC machine. 756_Occurance_Before.jpg
Occurance (After)	Wear Offset locked By 0.03mm In CNC Machine. 756_Occurance_After.jfif
Outflow (Before)	Final Inspection Stage Frequency has 5 Nos/Lot 756_Outflow_Before.jpeg
Outflow (After)	At Final Inspection stage we have started the 100% inspection at with the help of thread plug gauge up to till date no any defective part found. We will doing inspection unto 15.05.2024. Then we will doing inspection as per IS 2500 Standard 756_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	FORK PIPE HMS30& HMP30 (550FA19033)

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	500 part checked not ok part not found

