

Defect Details

NC No.	8000876571
NC Date	30/05/2024
NC Submission Date	
Part No.	165FG01101
Part Name	GEAR PRIMARY ASSLY 3W-4S 200 cc LPG
Supplier Name & Code	100237-SANJEEV AUTO PARTS MRFS PVT LT
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	MIX UP OTHER MODEL-WRONG HOBGING ISSUE (77TEETH)

1. Problem Description

Defect Description	Wrong teeth Hobbing done (77 teeth Hobbing done instead of 74 Nos)
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	vpwankhade@sanjeevgroup.com
Plant Head/CEO Email ID	rmtiwari@sanjeevgroup.com
MD Email ID	maithilee@sanjeevgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	200	0	0	210	240	650
Check Qty	200	0	0	210	240	650
NG Qty	0	0	0	0	0	0

Action taken on NG part

Scrap	0
Rework	0
Under Deviation	0

Containment Action

100% material checked at WIP & Final inspection confirmation with tick mark identification to ensure defect free parts.

3. Process Flow

Process Flow Description

Raw Material Inward Bar Cutting Billet Heating Hot Forging Normalizing Shotblasting Coining Preturning Peircing-1 Peircing-2 Shaving-1 Shaving-2 Milling-1 Milling-2 Finish turning 1st setup Finish turning 2nd setup Finish turning 3rd setup Deburring Final Inspection CNC Blank Inward Inspection CNC Blank Traciability Marking Hobbing Teeth Chamfering Gear Shaving Heat treatment Shotblasting ID Turning Bush Pressing Bush Turning Washing Final inspection

4. Process Details

Process / Operation	Hobbing
Outsource	No
Machine / Cell	GPH Cell
Machine / Cell No.	Glesson -1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	material mixup with GPH single groove in GPH double groove	During hobbing part loading visaul inspection to be done.	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	MIX UP OTHER MODEL-WRONG HOBBING ISSUE (77 TEETH)
Why 2	WRONG CNC BLANKLOADED FOR HOBBING
Why 3	VERIFICATION OF BLANK NOT DONE BEFORE LOADING FOR HOBBING
Why 4	VERIFICATION (INPECTION) SKIPPED
Why 5	NA
Root Cause (Occurance)	VERIFICATION (INPECTION) SKIPPED

Root Cause Analysis (Outflow)

Why 1	MIX UP OTHER MODEL-WRONG HOBBING ISSUE (77 TEETH)
Why 2	Not arrested during DFCE inspection
Why 3	Dail pressure scale value inspection skipped during DFCE Inspection.
Why 4	NA
Why 5	NA
Root Cause (Outflow)	Dail pressure scale value inspection skipped during DFCE Inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	OPL DISPLAYED AT HOBBING	VGW	04/06/2024	04/06/2024	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Visual Inspection
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	Wrong part loaded during hobbing verification skipped 831_Occurance_Before.pdf
Occurance (After)	Q-Alert dispayed at hobbing sytage for identification of CNC parts. 831_Occurance_After.pdf
Outflow (Before)	Dial pressure scale value inspection skipped durong inspection 831_Outflow_Before.pdf
Outflow (After)	Q-Alert dispayed at Final inspection stage for inspection of dial pressure scale value 831_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	ALL GPH Family

12. Document Review

Documents	
Specify Other Document	Q-Alert Dispalyed

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	Repeated Quality issue -POKA YOKE required in Machine (Possibility of customer Complaint) Also outflow action missing