

## Defect Details

|                                 |   |
|---------------------------------|---|
| <b>NC No.</b>                   | 8000876968  |
| <b>NC Date</b>                  | 05/06/2024  |
| <b>NC Submission Date</b>       |   |
| <b>Part No.</b>                 | F2FA25633M  |
| <b>Part Name</b>                | FORK PIPE MACHINED (26.1*21*264)                              |
| <b>Supplier Name &amp; Code</b> | 101030-TUBE INVESTMENTS OF INDIA LTD                          |
| <b>ETL Plant</b>                | 1117-ETL K-228/9 Suspension                                   |
| <b>Defect Details</b>           | NOT AS PER SPECIFICATION-ID UNDER SIZE & RUN OUT OBSERVED 0.4 |

## 1. Problem Description

|                               |                                      |
|-------------------------------|--------------------------------------|
| <b>Defect Description</b>     | ID UNDER SIZE & RUN OUT OBSERVED 0.4 |
| <b>Detection Stage</b>        | Inprocess                            |
| <b>Problem Severity</b>       | Fitment                              |
| <b>NG Quantity</b>            | 239                                  |
| <b>Is Defect Repeatative?</b> | Yes                                  |
| <b>Defect Sketch / Photo</b>  |                                      |

## Supplier Communication Details

|                                |                               |
|--------------------------------|-------------------------------|
| <b>Quality Head Email ID</b>   | AmitVD@tii.murugappa.com      |
| <b>Plant Head/CEO Email ID</b> | guptaajay@tii.murugappa.com   |
| <b>MD Email ID</b>             | mukeshahuja@tii.murugappa.com |

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

| Location         | ETL End | Warehouse | Transit | Supplier FG | Supplier WIP | Total |
|------------------|---------|-----------|---------|-------------|--------------|-------|
| <b>Total Qty</b> | 500     | 0         | 0       | 0           | 0            | 500   |
| <b>Check Qty</b> | 500     | 0         | 0       | 0           | 0            | 500   |
| <b>NG Qty</b>    | 239     | 0         | 0       | 0           | 0            | 239   |

## Action taken on NG part

|                        |     |
|------------------------|-----|
| <b>Scrap</b>           | 239 |
| <b>Rework</b>          | 0   |
| <b>Under Deviation</b> | 0   |

## Containment Action

All Stock is available at ETL end & in-house checked for the Machining Rut out at ID Spec. 0.05 MM Max.

## 3. Process Flow

**Process Flow Description**

Raw Material Inspection- Machining (Caulking &amp; Threading)-Drilling-Oiling-Final Inspection-Dispatch

**4. Process Details**

|                            |              |
|----------------------------|--------------|
| <b>Process / Operation</b> | Machining    |
| <b>Outsource</b>           | No           |
| <b>Machine / Cell</b>      | Machine Cell |
| <b>Machine / Cell No.</b>  | M/c No. 18   |

**5. Problem Analysis**

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| Type | Possible Cause | Fact Verification | Jud |
|------|----------------|-------------------|-----|
|------|----------------|-------------------|-----|

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

|  |  |
|--|--|
| <b>Inspection Method</b>               |  |
| <b>Other Inspection Method</b>         |  |
| <b>Check Point at Final Inspection</b> |  |
| <b>Checking Freq.</b>                  |  |
| <b>Sampling</b>                        |  |
| <b>Sample Size</b>                     |  |

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

|                               |  |
|-------------------------------|--|
| <b>Why 1</b>                  |  |
| <b>Why 2</b>                  |  |
| <b>Why 3</b>                  |  |
| <b>Why 4</b>                  |  |
| <b>Why 5</b>                  |  |
| <b>Root Cause (Occurance)</b> |  |

**Root Cause Analysis (Outflow)**

|                             |  |
|-----------------------------|--|
| <b>Why 1</b>                |  |
| <b>Why 2</b>                |  |
| <b>Why 3</b>                |  |
| <b>Why 4</b>                |  |
| <b>Why 5</b>                |  |
| <b>Root Cause (Outflow)</b> |  |

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

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| Type | Countermeasure Details | Responsibility | Target Date | Actual Date | Status |
|------|------------------------|----------------|-------------|-------------|--------|
|------|------------------------|----------------|-------------|-------------|--------|

9. Inspection Method After Customer Complaint

|  |  |
|--|--|
| <b>Change In Inspection System</b>     |  |
| <b>Change Details</b>                  |  |
| <b>Inspection Method</b>               |  |
| <b>Other Inspection Method</b>         |  |
| <b>Check Point at Final Inspection</b> |  |
| <b>Checking Freq.</b>                  |  |
| <b>Sampling</b>                        |  |
| <b>Sample Size</b>                     |  |

10. Evidence of Countermeasure

|                           |  |
|---------------------------|--|
| <b>Occurance (Before)</b> |  |
| <b>Occurance (After)</b>  |  |
| <b>Outflow (Before)</b>   |  |
| <b>Outflow (After)</b>    |  |

11. Horizontal Deployment

|   |  |
|---|--|
| <b>Horizontal Deployment Required</b>     |  |
| <b>Applicable Machine / Model / Plant</b> |  |

12. Document Review

|                               |  |
|-------------------------------|--|
| <b>Documents</b>              |  |
| <b>Specify Other Document</b> |  |

13. Effectiveness Of Action

|                              |  |
|------------------------------|--|
| <b>Reviewed Quantity</b>     |  |
| <b>Reason for submission</b> |  |