

Defect Details

| | |
|---------------------------------|---|
| NC No. | 8000877852 |
| NC Date | 11/06/2024 |
| NC Submission Date | |
| Part No. | F20508502B |
| Part Name | UNDER BKT ASSY MACHINED - XF1C1 |
| Supplier Name & Code | 100060-A.G.TRANSMISSIONS |
| ETL Plant | 1117-ETL K-228/9 Suspension |
| Defect Details | NOT AS PER SPECIFICATION-THREAD M22 MAJOR DIA UNDERSIZE |

1. Problem Description

| | |
|-------------------------------|--------------------------------|
| Defect Description | THREAD M22 MAJOR DIA UNDERSIZE |
| Detection Stage | Receipt |
| Problem Severity | Safety |
| NG Quantity | 8 |
| Is Defect Repeatative? | Yes |
| Defect Sketch / Photo | |

Supplier Communication Details

| | |
|--------------------------------|------------------------------------|
| Quality Head Email ID | agtransmissions@rediffmail.com |
| Plant Head/CEO Email ID | planthead@agtransmissionsindia.com |
| MD Email ID | agtransmissions@rediffmail.com |

2. Stock Details & action taken for NG parts

| Location | ETL End | Warehouse | Transit | Supplier FG | Supplier WIP | Total |
|------------------|---------|-----------|---------|-------------|--------------|-------|
| Total Qty | 150 | 0 | 0 | 1200 | 0 | 1350 |
| Check Qty | 150 | 0 | 0 | 1200 | 0 | 1350 |
| NG Qty | 8 | 0 | 0 | 2 | 0 | 10 |

Action taken on NG part

| | |
|------------------------|----|
| Scrap | 10 |
| Rework | 0 |
| Under Deviation | 0 |

Containment Action

100% Inspection done & special identification white dot on Shaft done.

3. Process Flow

Process Flow Description

Forging & pipe Inward, Drilling, Semi Boring, M8 Drilling, Slitting, Bracket Visual Inspection, Pipe Cutting, Flaring, Center Facing, CNC Turning, Visual Inspection, Pressing, Welding, M8 Tapping, Fine Boring, M6 Tapping, Deburring, Back Chamfer, Air Cleaning, Parallelity Inspection, Final Inspection, Packing & Dispatch

4. Process Details

| | |
|----------------------------|-------------|
| Process / Operation | CNC Turning |
| Outsource | No |
| Machine / Cell | CNC |
| Machine / Cell No. | CNC |

5. Problem Analysis

| Type | Possible Cause | Fact Verification | Jud |
|---------|-------------------------------------|---|-----|
| Machine | Wrong Offset given | Program lock not provided | X |
| Method | Sampling inspection done | 100 Nos checked | X |
| Man | Unskilled oprator | As per skill matrix Operator in skilled | O |
| Tool | Tool Change frequency not Followed. | Tool change frequency followed. OK | O |

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

| | |
|-------------------------------|--|
| Why 1 | M22 Thread undersize |
| Why 2 | Wrong offset given for M22 Thread Dia. |
| Why 3 | Program lock was not present |
| Why 4 | |
| Why 5 | |
| Root Cause (Occurance) | Program lock was not provided |

Root Cause Analysis (Outflow)

| | |
|-----------------------------|--------------------------------------|
| Why 1 | M22 Thread undersize |
| Why 2 | Not detected at Final Inspection |
| Why 3 | Sampling Inspection done. 10 Per Lot |
| Why 4 | As per control Plan frequency |
| Why 5 | |
| Root Cause (Outflow) | Lack of 100% inspection |

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

| Type | Countermeasure Details | Responsibility | Target Date | Actual Date | Status |
|-----------|------------------------|----------------|-------------|-------------|-----------|
| Occurance | Program lock provided | Supervisor | 27/06/2024 | 27/06/2024 | Completed |

9. Inspection Method After Customer Complaint

| | |
|--|---|
| Change In Inspection System | Yes |
| Change Details | Instead of sampling inspection. 100% Inspection by Thread Ring Gauge M22-6g is started. |
| Inspection Method | Gauge |
| Other Inspection Method | |
| Check Point at Final Inspection | Yes |
| Checking Freq. | 100% |
| Sampling | No |
| Sample Size | 100% |

10. Evidence of Countermeasure

| | |
|---------------------------|---|
| Occurance (Before) | Program lock was not present 852_Occurance_Before.jpeg |
| Occurance (After) | Program lock provided 852_Occurance_After.jpeg |
| Outflow (Before) | Sampling Inspection 852_Outflow_Before.xls |
| Outflow (After) | 100% Inspection started 852_Outflow_After.xls |

11. Horizontal Deployment

| | |
|---|-----------------------|
| Horizontal Deployment Required | Yes |
| Applicable Machine / Model / Plant | Caliber Under Bracket |

12. Document Review

| | |
|-------------------------------|-----------------------------|
| Documents | ControlPlan, InspCheckSheet |
| Specify Other Document | PDIR |

13. Effectiveness Of Action

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|------------------------------|-----|
| Reviewed Quantity | 150 |
| Reason for submission | OK |