

Defect Details

NC No.	8000879354
NC Date	22/06/2024
NC Submission Date	
Part No.	F2LG05402B
Part Name	SEAT PIPE - J1A & J1D
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-MIX-UP

1. Problem Description

Defect Description	Mix-up
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	5
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	aslam@sangkaj.com
Plant Head/CEO Email ID	pardeshinr@snagkaj.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	1000	0	0	1000	0	2000
Check Qty	1000	0	0	1000	0	2000
NG Qty	5	0	0	0	0	5

Action taken on NG part

Scrap	5
Rework	0
Under Deviation	0

Containment Action

Segregation of Pipeline material, Customer end, WIP, Supplier end.

3. Process Flow

Process Flow Description

10.RM Inspection; 20.Parting off and chamfering; 30.Weighing and moly powder application; 40.Draw forging; 50.Head Forging; 60.Rough Grinding; 70A. Collar Machining; 70B. Total length facing, Drilling & Tapping; 80.Hole piercing; 90 DF and Compression hole chamfering; 100.ID Cleaning & Deburring; 110.Finish Grinding; 120.Ultrasonic Cleaning; 130. Final Inspection; 140.Oiling; 150.Packing and storage.

4. Process Details

Process / Operation	140.Final Inspection
Outsource	No
Machine / Cell	Final Inspection table
Machine / Cell No.	FID-SP-01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator/Inspector	Found skilled operator	O
Tool	Wrong tool used	OK tool used	O
Method	Method of handling of rework and rejection Not ok	Rework method not described properly	X
Material	Wrong Input material	Material found OK	O
Machine	NO input and output stage defined at Machine stage	Input and Output found	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	Seat pipe model mix up.
Why 2	Rework of J1A and J1D at FID kept in same bin.
Why 3	Parameters are same in J1A and J1D of rework
Why 4	In rework handling procedure modelwise seperate rework not defined.
Why 5	
Root Cause (Occurance)	In rework handling procedure modelwise seperate rework not defined.

Root Cause Analysis (Outflow)

Why 1	Model mix up of seat pipe J1A and J1D found at customer end.
Why 2	Mix up of J1A and J1D seat pipe not detected at FID.
Why 3	After rework of material only rework parameter verified
Why 4	After rework mix up parameter not verified.
Why 5	
Root Cause (Outflow)	After rework mix up parameter not verified.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Changes in rework handling procedure for repeat Final inspection for all parameters after rework done.	Mr.Irfan	01/07/2024	01/07/2024	Completed
Occurance	Changes in rework handling procedure for keeping material modelwise and rework parameter wise seperate.	Mr.Irfan	01/07/2024	01/07/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection from initial stage after rework of parts.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

10. Evidence of Countermeasure

Occurance (Before)	No instructions on Modelwise seperate before rework in SOP. 882_Occurance_Before.jpg
Occurance (After)	Seperate material before rework modelwise Instruction added in SOP. 882_Occurance_After.jpg
Outflow (Before)	NO reverification from initial stage of rework material on final inspection. 882_Outflow_Before.jpg
Outflow (After)	Instruction added in rework SOP for reinspection of all material from initial stage on Final inspection. 882_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Not applicable

12. Document Review

Documents	WISOP
Specify Other Document	NO other document

13. Effectiveness Of Action

Reviewed Quantity	100
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