

Defect Details

NC No.	8000881725
NC Date	08/07/2024
NC Submission Date	
Part No.	F2LG07102B
Part Name	SEAT PIPE - J1D
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	THREADING MISSING-WITHOUT THREADING

1. Problem Description

Defect Description	Thread missing
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	aslam@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	1000	0	0	500	500	2000
Check Qty	1000	0	0	500	500	2000
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action

Segregation of pipeline material, FG material, and Customer 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	70B
Outsource	No
Machine / Cell	CDL CNC
Machine / Cell No.	CDL CNC-01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Material grade not ok	Material grade found OK.	O
Man	Machine operator/Final inspector not as per skill materix	Machine operator & Final inspector found as per skill matrix	O
Tool	Wrong size grade tap used	Tapping tool found ok grade with Ok size	O
Method	Due to power off Operation not completed	Due to power of Threading operation not completed/missing	X
Machine	PM not as per plan	PM found as per plan	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	Threading missing part produced
Why 2	Threading operation not completed
Why 3	Programmed on CNC machine for tapping not executed
Why 4	Incomplete operation due to power off in running condition. .
Why 5	
Root Cause (Occurance)	Incomplete operation due to power off in running condition. .

Root Cause Analysis (Outflow)

Why 1	Threading missing part found at customer end
Why 2	Threading missing part not detected/outflows
Why 3	Detected part mixup in OK parts
Why 4	
Why 5	
Root Cause (Outflow)	Threading missing part outflows due to mixup

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	In Work instruction add checkpoint for inspection of all parameter after power off.	Mr.Irfan	07/08/2024	06/08/2024	Completed
Outflow	Red paint on head side for threading missing / operation missing part (Add in Work instruction)	Mr.Irfan	07/08/2024	06/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % inspection with threading side blue color dot.
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 instruction point for machine after power off 922_Occurance_Before.jpg
Occurance (After)	Instruction added in Work instruction for Checking all parameters after power off 922_Occurance_After.jpg
Outflow (Before)	Operation missing/threading missing part no special treatment 922_Outflow_Before.jpg
Outflow (After)	Red spray paint apply on head for operation missing/thread missing part instruction added in WI 922_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok

