

Defect Details

NC No.	8000882706
NC Date	17/07/2024
NC Submission Date	
Part No.	F2DZ04512B
Part Name	SCREW CAP/FORK BOLT ABWA ADJUSTABLE
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	DIMETER UNDERSIZE-7+0.1 UINDER SIZE

1. Problem Description

Defect Description	7+0.1 dimension found under size by up to 0.2 mm
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	118
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@sharp-engineers.com
Plant Head/CEO Email ID	kurund.ma@sharp-engineers.com
MD Email ID	urkhandelwal@sharp-engineers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	450	0	0	1200	0	1650
Check Qty	450	0	0	1200	0	1650
NG Qty	118	0	0	28	0	146

Action taken on NG part

Scrap	146
Rework	0
Under Deviation	0

Containment Action

Pipeline material segregated at Customer and our end

3. Process Flow

Process Flow Description

RM incoming Inspection

4. Process Details

Process / Operation	CNC
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	CNC

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Insert broken	No insert broken	O
Method	Fixture not clesn properly	Fixture cleaned after every cycle regardi ng Work Instruction also displayed at Machine stage	O
Man	New manpower	Manpower available as per skill matrix	O
Man	Unskill operator	Skill operator available	O
Man	Wrong setting done by operator	Setting done ok, also Setup approval report evident	O
Machine	power cut	no power cut	O
Tool	Insert wear out	No insert wear out	O
Method	Insert not change at defined frequency	As per tool history card its obeserved tool changed at defined frequency	O
Method	Part not validated after replacement of insert	Part not validated after replacement of insert	X
Tool	Tool Change	No any tool changed	O
Material	RM change	RM found as pr requirement	O
Machine	Machine changed	No machine change	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos

7. Root Cause Analysis (Occurance)

Why 1	Dimension 7 undersized
Why 2	Dimension 7 +0.2/+0.1 observed 6.95
Why 3	Insert changed
Why 4	Insert life over
Why 5	verification not done after replacement of insert coz dependency on operator.
Root Cause (Occurance)	Part not validated after replacement of insert by operator

Root Cause Analysis (Outflow)

Why 1	Dimension 7 undersized
Why 2	Skip from inspection
Why 3	No checkpoint at final inspection
Why 4	
Why 5	
Root Cause (Outflow)	No checkpoint at final inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Checkpoint added in Final inspection and verification started at PDI stage	Omkar Bhange	31/07/2024	31/07/2024	Completed
Outflow	Part verification started by Supervisor and Inprocess engineer after replacement of Insert.	Ingole and Yogesh chavan	30/07/2024	31/07/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Verification started by Supervisor and Inprocess engineer
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5

10. Evidence of Countermeasure

Occurance (Before)	Operator dependency for part verification after replacement of insert 944_Occurance_Before.jpg
Occurance (After)	On job training given to Production supervisor and Inprocess engineer for verification of part after replacement of insert 944_Occurance_After.jpeg
Outflow (Before)	No check point in final inspection 944_Outflow_Before.jpg
Outflow (After)	Check point added in Final inspection also verification point added in PDI report 944_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	For all machine

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	after correction issue not observed.