

Defect Details

NC No.	8000884034
NC Date	25/07/2024
NC Submission Date	
Part No.	F2FA19033M
Part Name	K0PG FORK PIPE MACHINED
Supplier Name & Code	101223-SANGKAJ BRIGHT WIRES PRIVATE L
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	EXCESS M/CING-DOUBLE GROOVE OPERATION

1. Problem Description

Defect Description	K0PG fork pipe ID double groove operation
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	3
Is Defect Repeatative?	Yes
Defect Sketch / Photo	I055dbjk0qj0wsubay1neyhu.jpg

Supplier Communication Details

Quality Head Email ID	mayursurse11@gmail.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	2000	0	0	1000	1000	4000
Check Qty	1998	0	0	1000	1000	3998
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action

100% check all stock visual

3. Process Flow

Process Flow Description

Incoming Raw Material + Inward Inspection Raw Material+ CNC 1st set up+ CNC 2nd set up + Drilling + Air Cleaning + Final Inspection + Movement & PDI Inspection + Dispatch

4. Process Details

Process / Operation	CNC MACHINING
Outsource	No
Machine / Cell	CNC CELL
Machine / Cell No.	2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Wrong offset given by operator at the time of rework	at time of rework operator could not judge offser 1.5mm	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	5nos

7. Root Cause Analysis (Occurance)

Why 1	Doable Groove
Why 2	After changing insert job at lower out of specification
Why 3	End of shift that job rework
Why 4	Offset not given by operator.
Why 5	
Root Cause (Occurance)	Offset not given by operator.

Root Cause Analysis (Outflow)

Why 1	Doable Groove
Why 2	Rejected material mix-up with ok material
Why 3	Rejection bin provided but not daily rejection rework clear
Why 4	
Why 5	
Root Cause (Outflow)	Rejection bin provided but not daily rejection rework clear

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no changes
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

10. Evidence of Countermeasure

Occurance (Before)	no offset locking 964_Occurance_Before.png
Occurance (After)	Offset locking 964_Occurance_After.png
Outflow (Before)	rework data not available 964_Outflow_Before.png
Outflow (After)	Rej rework & red yellow bin available 964_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO MODEL SAME AS

12. Document Review

Documents	
Specify Other Document	One point lesson

13. Effectiveness Of Action

Reviewed Quantity	15000
Reason for submission	Reviewed next 3 lots found ok no issue