

## Defect Details

<b>NC No.</b>	8000887128
<b>NC Date</b>	16/08/2024
<b>NC Submission Date</b>	
<b>Part No.</b>	F2DZ15510B
<b>Part Name</b>	FORK BOLT -ACJA FF
<b>Supplier Name &amp; Code</b>	100505-A B AUTOCOMPONENTS
<b>ETL Plant</b>	1117-ETL K-228/9 Suspension
<b>Defect Details</b>	NOT AS PER SPECIFICATION-COLOUR SHADING

## 1. Problem Description

<b>Defect Description</b>	COLOUR SHADING
<b>Detection Stage</b>	Customer End
<b>Problem Severity</b>	Aesthetic
<b>NG Quantity</b>	9
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	headqaabauto@gmail.com
<b>Plant Head/CEO Email ID</b>	kamalabautocomponent@gmail.com
<b>MD Email ID</b>	abautocomponent@gmail.com

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	2000	0	0	0	400	2400
<b>Check Qty</b>	2000	0	0	0	400	2400
<b>NG Qty</b>	9	0	0	0	0	9

## Action taken on NG part

<b>Scrap</b>	9
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

Verify the WIP stocks, there is no FG qty.

## 3. Process Flow

**Process Flow Description**

CNC Turning &gt;VMC Milling &gt;Special process.

**4. Process Details**

<b>Process / Operation</b>	Turning, Milling & Black Anodizing
<b>Outsource</b>	Yes
<b>Machine / Cell</b>	CNC & VMC & Special process
<b>Machine / Cell No.</b>	CNC & VMC & Special

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Tool	Part clamp issue	Verified Jig problem found.	X
Man	Part Jigging variation	Verified found ok	O
Method	Process variation	Process parameters witnessed and found ok.	O
Machine	Maintenance overdue.	Preventive Maintenance verification done, found ok	O
Machine	Power fluctuation	Verified found ok	O
Material	Chemical used	Verified found ok	O
Material	Cleaning agents	Verified there is no cleaning agent using.	O
Method	Cleaning problem	There is no cleaning required with agent, Only cloth cleaning found ok.	O

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Limit sample visual
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	Shade variation.
<b>Why 2</b>	Due to the Part hold in the jig, improper hold / part shake will create the shade variation in the part.
<b>Why 3</b>	Part holding not rigid in the jigs.
<b>Why 4</b>	Jigs weaker
<b>Why 5</b>	Jigs Life does not monitor.
<b>Root Cause (Occurance)</b>	Due to the Part hold in the jig, improper hold / part shake will create the shade variation in the part.

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	Shade variation
<b>Why 2</b>	Not witnessed during final visual inspection.
<b>Why 3</b>	Due to shade variation not capturing immediately.
<b>Why 4</b>	Shade generation will take time to appear.

<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	Shade generation will take time to appear.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Monitor the Jig life through number of Batch processed, also verify the jigs while loading the part. SIR report updated, also revise the supplier inspection reports.	Karan Metals	04/09/2024	02/09/2024	Completed
Outflow	Avoid the immediate dispatches from AB Auto to ETL to avid shade issues.	Rudresh	04/09/2024	02/09/2024	Completed

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	100 % visual after one-week FG WIP Stock.
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	WIP stock maintain
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

## 10. Evidance of Countermeasure

<b>Occurance (Before)</b>	Monthly verifying the Anodizing processes through check list. <a href="#">1026_Occurance_Before.pdf</a>
<b>Occurance (After)</b>	Anodizing process verifying each batch by updating the checklist. <a href="#">1026_Occurance_After.pdf</a>
<b>Outflow (Before)</b>	Same day dispatch after anodizing <a href="#">1026_Outflow_Before.pdf</a>
<b>Outflow (After)</b>	Minimum one week kept before dispatch after FG. <a href="#">1026_Outflow_After.pdf</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	Fork bolts & screw caps.

## 12. Document Review

<b>Documents</b>	AuditCheckSheet, InspCheckSheet
<b>Specify Other Document</b>	No

### 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	50
<b>Reason for submission</b>	05 Problem analysis - Fact verification need to correct as per actual observation against 4M and give judgment `X` for not ok and `O` for OK