

Defect Details

NC No.	8000895365
NC Date	14/10/2024
NC Submission Date	
Part No.	538FL00102
Part Name	PISTON NUT - WP
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	CRACKS-CRACK

1. Problem Description

Defect Description	cracke
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	158
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4000	2000	0	5000	3000	14000
Check Qty	4000	2000	0	5000	3000	14000
NG Qty	158	0	0	0	0	158

Action taken on NG part

Scrap	158
Rework	0
Under Deviation	0

Containment Action

we are checked 100% material lying at various stage

3. Process Flow

Process Flow Description

RAW MATERIAL + CNC PART OFF,DRILLING,THREADING + HEAT TREATMENT + SURFACE GRINDING + SURFACE TREATMENT + FINAL INSPECTION + PACKING

4. Process Details

Process / Operation	RAW MATERIAL
Outsource	Yes
Machine / Cell	CNC
Machine / Cell No.	05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	TOOL WAEROUT	VALIDATION AND FOUND TOOL OK	O
Material	RAW MATERIAL MIX -UP OTHER NG MATERIAL	VALIDATION AND FOUND N/G MATERIAL MIX UP	X
Method	INSPECTION METHOD NOT EFFECTIVE	VALIDATION AND FOUND TRG NOT USE 100%IN MACHINE	X
Machine	MACHINE PM NOT DONE AS PER PLAN	VALIDATION AND FOUND PM DONE	O
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL LOW	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	R/M 100% CHECK
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	CRACKS-CRACK
Why 2	HOLD RAW MATERIAL MIX-UP OK MATERIAL
Why 3	HOLD MATERIAL NOT COVERED AND RED PAINT NOT IDENTIFY
Why 4	RAW MATERIAL OTHER GRADE MIX UP GRAIN FLOW OVER SIZE
Why 5	HOLD MATERIAL LOCK AND KEY NOT AVAILLABLE
Root Cause (Occurance)	HOLD RAW MATERIAL MIX-UP OK MATERIAL

Root Cause Analysis (Outflow)

Why 1	CRACKS-CRACK
Why 2	INSPECTION PLAN WAS NOT EFFECTIVE
Why 3	NG PART SKIPPED FROM INSPECTION
Why 4	SO NG PART DELIEVERED TO CUSTOMER
Why 5	
Root Cause (Outflow)	INSPECTION PLAN WAS NOT EFFECTIVE

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	NG MATERIAL RED PAINT MARK	GANESH MAURYA	18/10/2024	18/10/2024	Completed
Outflow	FIFO SYSTEM MAINTAIN IN RAW MATERIAL STAGE	GANESH MAURYA	18/10/2024	18/10/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% MATERIAL CHECK
Inspection Method	Other
Other Inspection Method	R/M GRAIN FLOW CHECK
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	NO

10. Evidance of Countermeasure

Occurance (Before)	RED PAINT NOT MARK N/G MATERIAL 1147_Occurance_Before.xlsx
Occurance (After)	RED PAINT MARK N/G MATERIAL 1147_Occurance_After.xlsx
Outflow (Before)	INSPECTION AGREEMENTS NOT UPDATE 1147_Outflow_Before.xlsx
Outflow (After)	INSPECTION AGREEMENTS UPDATE 1147_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	R/M

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	3000
Reason for submission	no cracks found in this lot.

