

Defect Details

NC No.	8000902820
NC Date	09/12/2024
NC Submission Date	
Part No.	F2DZ03112B
Part Name	FORK BOLT
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-THREADING CONCENTRICITY MORE

1. Problem Description

Defect Description	THRADING CONCENTRICITY MORE
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	106
Is Defect Repeatative?	Yes
Defect Sketch / Photo	3tkupsqk0tnofazl2odnzfet.jpg

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	2000	5000	0	5000	3000	15000
Check Qty	2000	5000	0	5000	3000	15000
NG Qty	106	0	0	0	0	106

Action taken on NG part

Scrap	106
Rework	0
Under Deviation	0

Containment Action

WE ARE ALL MATERIAL SEGGRATION CUSTOMER AND OUR END

3. Process Flow

Process Flow Description

RAW MATERIAL+CUTTING+FORGING+CNC 1ST+CNC 2ND+ROLLING+ SURFACE TREATMENT +FINAL INSPECTION+ PACKING

4. Process Details

Process / Operation	ROLLING
Outsource	No
Machine / Cell	ROLLING
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	MACHINE ROLLING TOOL NOT ALIGMENT PROPERLY	VALIDATION AND FOUND OK	O
Material	MACHINE OUTPUT MATERAIL HANDLING NOT PROPERLY	VALIDATION AND FOUND OK	O
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL OK	O
Tool	ROLLING MACHINE PART STOPER TOOL WEAR OUT	VALIDATION AND FOUND NG	X
Method	MACHINE ROLLING PROCESS THREAD NOT CHECKED 100%	VALIDATION AND FOUND NG	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-THREADING CONCENTRICITY MORE
Why 2	ROLLING MACHINE SETTING TIME PART STOPER NOT CHECKING
Why 3	ROLLING MACHINE PART STOPER WEAR OUT
Why 4	SO PART ARE NOT INSERT AS PER ROLLING DIE STOPER PROPERLY
Why 5	ROLLING MACHINE ARE NOT STOPER CARBITE MATERIAL
Root Cause (Occurance)	ROLLING MACHINE PART STOPER WEAR OUT

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-THREADING CONCENTRICITY MORE
Why 2	ROLLING MACHINE SETTING TIME ROLLING DIE AND PART STOPER ALIGMENT NOT CHECKING POINT AVAILABLE AS PER QC CHECK SHEET
Why 3	MACHINE ROLLING PROCESS THREAD NOT CHECKED 100%
Why 4	ROLLING MACHINE PART AFTER THREAD AS PER CUSTMONER SPECIFACTION THREAD GAUGE NOT AVAILABLE
Why 5	MASTER GAUGE ARE NOT MADE AS PER ASEMBLE PROCESS
Root Cause (Outflow)	ROLLING MACHINE PART AFTER THREAD AS PER CUSTMONER SPECIFACTION THREAD GAUGE NOT AVAILABLE

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	ROLLING MACHINE ALL FORK BOLT PART STOPER PROVIDE CARBITE MATERIAL	MR. ANIL	14/12/2024	14/12/2024	Completed
Outflow	AS PER CUSTMONER SPECIFACTION THREAD GAUGE PROVIDE ON MACHINE	MR.GANESH MAURYA	14/12/2024	14/12/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% TRG CHECK IN FINAL INSPECTION
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	ROLLING MACHINE ALL FORK BOLT PART STOPER NOT PROVIDE CARBITE MATERIAL 1267_Occurance_Before.xlsx
Occurance (After)	ROLLING MACHINE ALL FORK BOLT PART STOPER PROVIDE CARBITE MATERIAL 1267_Occurance_After.xlsx
Outflow (Before)	AS PER CUSTMONER SPECIFACTION THREAD GAUGE NOT AVAILABLE ON MACHINE 1267_Outflow_Before.xlsx
Outflow (After)	AS PER CUSTMONER SPECIFACTION THREAD GAUGE PROVIDE ON MACHINE 1267_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	FORK BOLT ALL MODEL

12. Document Review

Documents	ControlPlan, PFMEA, InspCheckSheet
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	ok

