QFR No - 7000828629

Defect Details

NC No.	7000828629
NC Date	29/03/2022
NC Submission Date	
Part No.	F2DZ08810B
Part Name	K0PG FORK BOLT
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	DIMN.U/SIZE.-Grove Dia Over Size

1. Problem Description

Defect Description	Critical dimension Groove Under Size i.e. 22.23, 22.29, 22.30 again the spec of 22.45-0.1 Also observed Packing standard failure as well as heavy dent and damage at parts
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	2000
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	maheshmishra@sangkaj.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	0	0	0	2000	2000	4000
Check Qty	0	0	0	2000	2000	4000
NG Qty	0	0	0	0	0	0

Action taken on NG part

Scrap	0
Rework	0
Under Deviation	0

Containment Action
100% material we inspect with DVC

3. Process Flow

Process Flow Description
Inward RM - Parting - CNC st - CNC 2nd - Plating - final inspection -Dispatch

4. Process Details

Process / Operation	CNC
Outsource	No
Machine / Cell	CNC cell
Machine / Cell No.	38

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	insert plunge 2 time in groove	found not ok	X
Man	New manpower	Old manpower found ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

7. Root Cause Analysis (Occurance)

Why 1	OD oversize observed in KOPG 22.45mm
Why 2	Insert plunge 2 times
Why 3	Standard insert is not available.
Why 4	
Why 5	
Root Cause (Occurance)	Standard insert is not available.

Root Cause Analysis (Outflow)

Why 1	OD oversize observed in KOPG 22.45mm
Why 2	Skip from inspection
Why 3	Sampling inspection
Why 4	
Why 5	
Root Cause (Outflow)	Sampling inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	100% material inspect with DVC	Mahesh Mishra	20/04/2022	21/04/2022	Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% material inspect with DVC instead of snap gauge.
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	00

10. Evidance of Countermeasure

Occurance (Before)	
Occurance (After)	
Outflow (Before)	
Outflow (After)	

11. Horizontal Deployment

Horizontal Deployment Required	
Applicable Machine / Model / Plant	

12. Document Review

Documents	
Specify Other Document	

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	