QFR No - 7000829350

Defect Details

NC No.	7000829350
NC Date	02/04/2022
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	DIMETER UNDERSIZE-Grove Dia 22.45-0.1 found Under Size

1. Problem Description

Defect Description	Grove Dia NG (Under Size & Over Size)
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	2400
Is Defect Repeatative?	Yes
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	2400	0	0	2000	2000	6400
Check Qty	2400	0	0	2000	2000	6400
NG Qty	2400	0	0	0	0	2400

Action taken on NG part

Scrap	0
Rework	2400
Under Deviation	0

Containment Action
100% material inspect at my end blue identification mark provided on component. also material started 100% checking with snap gauge.

3. Process Flow

Process Flow Description
RM INWARD - PARTING - TURNING CNC1 - TURNING CNC2 - PLATING - FINAL INSPECTION - DISPATCH

4. Process Details

Process / Operation	CNC TURNING 2ND SETUP
Outsource	No
Machine / Cell	CNC MACHINE CELL
Machine / Cell No.	38

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	INSERT WEAR OUT AND DOUBLE PUNCH	INSERT DOUBLE PUNCH	X
Method	INSERT LIFE NOT MONITORING	INSERT LIFE MONITORED 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	Grove OD undersize.
Why 2	Insert double plunge for 3.10 mm slot making purpose.
Why 3	Standard insert is not available
Why 4	
Why 5	
Root Cause (Occurance)	Standard insert is not available so we punch insert 2 times in groove.

Root Cause Analysis (Outflow)

Why 1	Grove OD undersize.
Why 2	Not detected in inspection
Why 3	Material checked with snap gauge.
Why 4	
Why 5	
Root Cause (Outflow)	Material checked with snap gauge.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Now we used 3 mm insert and 0.1 mm we linear machining.	Raut Santosh	20/04/2022	26/04/2022	Completed
Outflow	100%c material inspect with Digital vernier and blue identification mark also provided	Mahesh Mishra	20/04/2022	03/05/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Material 100 Inspect with Digital vernier against 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)	Standard insert is not available so we plunge insert 2 times in groove. 40_Occurance_Before.jpg
Occurance (After)	Now we used 3 mm insert and 0.1 mm we linear machining. 40_Occurance_After.jpg
Outflow (Before)	Material 100% inspect with snap gauge 40_Outflow_Before.jpg
Outflow (After)	Material 100% inspect with digital vernier 40_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	0
Reason for submission	ETL Return Material stock details and actions are not given. All 4m to be addressed and fact verification to be corrected. Root Cause is not adequate (both Flow and Occurrence) i.e. why not detected at Setup inspection, Petro inspection sheet, PDIR etc. ? If tool double plunged then why 4M change not followed ? Occurrence side corrective action is given but preventive action is not defined i.e. How to avoid repeating of use of Non Standard tool. All Updated or Reviewed Documents to be uploaded (OPL, Training records, Control Plan etc.)