QFR No - 7000831106

Defect Details

NC No.	7000831106
NC Date	14/04/2022
NC Submission Date	
Part No.	550LG06702
Part Name	SEAT PIPE-(HMS-30 & HMP-30)
Supplier Name & Code	100538-NARINDER PARKASH AND CO
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	THREADING NOT OK-Half thread and Go gauge not qualified

1. Problem Description

Defect Description	Half Thread observed
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	61
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@npcindustries.in
Plant Head/CEO Email ID	anand@npcindustries.in
MD Email ID	ajay@npcindustries.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	10000	0	0	0	0	10000
Check Qty	10000	0	0	0	0	10000
NG Qty	14	0	0	0	0	14

Action taken on NG part

Scrap	14
Rework	0
Under Deviation	0

Containment Action
Segregated all the parts at ETL end.

3. Process Flow

Process Flow Description
1. Raw Material 2.Cutting 3.Multistation Draw 4.Head Formation 5.Rough Grinding 6.Punching 7.CNC Head Turning 8.CNC Boring & Facing 9.Tapping 10.Chemfering-1&2 11.Finish Grinding 12.Final Inspection 13. Cleaning 14.Oiling.

4. Process Details

Process / Operation	Tapping
Outsource	No
Machine / Cell	Tapping Machine
Machine / Cell No.	NPC/TPM/012

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Chips in thread	Verified ok	O
Method	Pre Tapping Bore dia u/s	Verified ok	O
Method	Tap Wear Out	Verified not ok	X
Material	Material Hardness less / more	Verified ok	O
Man	Operator negligency at inprocess	Verified not ok	X
Method	Minor Dia u/s	Verified ok	O
Method	Dents in thread	Verified 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	Asper plan

7. Root Cause Analysis (Occurance)

Why 1	M8 GO TPG not answering
Why 2	Wearout tapping tool used in process.
Why 3	Operator was less awareness about the tapping tool
Why 4	New operator appointed and training gap observed
Why 5	
Root Cause (Occurance)	New operator appointed and training gap observed

Root Cause Analysis (Outflow)

Why 1	M8 GO TPG not answering
Why 2	Could not be detected at Final Inspection
Why 3	Skipped in Sampling at Final Inspection
Why 4	Less quantity in our Sampling at Final Inspection

Why 5	
Root Cause (Outflow)	Less quantity in our Sampling at Final Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	TPG Inspection to be done after every 60pcs(or 10minutes) by operator.	Mr. Paramjeet	20/04/2022		Completed
Occurance	Quality Alert to be displayed at Work Station	Mr. Lokesh	14/04/2022		Completed
Outflow	Increase sampling size at Final inspection.	Mr. Gurpreet Singh	14/06/2022		Completed
Outflow	Quality alert to be displayed at final inspection area	Mr. Lokesh	14/04/2022		Completed
Occurance	Training to be provided to new operator about the process any new station.	Mr. Gurpreet	18/04/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Increase sampling plan at final inspection
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	increase p

10. Evidance of Countermeasure

Occurance (Before)	Operator unaware 54_Occurance_Before.jpg
Occurance (After)	Training to be provided to new operator about the process any new station. 54_Occurance_After.jpg
Outflow (Before)	As per sampling plan. 54_Outflow_Before.jpg
Outflow (After)	Increase sampling size at Final inspection. 54_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All similar model

12. Document Review

Documents	ControlPlan, PFMEA

Specify Other Document	No.

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	