QFR No - 7000831526

Defect Details

NC No.	7000831526
NC Date	16/04/2022
NC Submission Date	
Part No.	550BZ01402
Part Name	CAP OIL LOCK - DF01
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	PARALITY NOT OK.-Parallelism Not Ok

1. Problem Description

Defect Description	Parallism more
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	15
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
Plant Head/CEO Email ID	kurund.ma@sharp-engineers.com
MD Email ID	urkhandelwal@sharp-engineers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4500	0	0	0	3000	7500
Check Qty	4500	0	0	0	3000	7500
NG Qty	22	0	0	0	2	24

Action taken on NG part

Scrap	2
Rework	20
Under Deviation	0

Containment Action
Drill changing frequency reduced from 600 Nos 500/Re-sharpening

3. Process Flow

Process Flow Description
10) Raw material inward, 20) Parting & drilling, 30) Chamfering (Ø8.50 & 14.04mm),40) Grinding 60) Plating process, 70) Inward inspection (for plated parts), 80) Final inspection, 90) Packing & Dispatch.

4. Process Details

Process / Operation	Drilling & Parting
Outsource	No
Machine / Cell	Traub Machine Shop
Machine / Cell No.	Traub/SE/ALM/05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Tool setting not done properly/inaccurate machine	SOP & work instruction displayed on machine , Machine maintenance being followed as per plan	O
Man	Unskilled/semi-skilled operator	Operator having good knowledge of operation and skill matrix exist stage wise	O
Tool	Drill Ø14.10mm worn out	Drill Ø14.10 observed worn out earlier than defined tool life 600/Re-sharpening	X
Material	Setting pieces/ NG parts mix up with ok material	Rework & rejection bins available on machine in the lock and key.	O

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS:2500

7. Root Cause Analysis (Occurance)

Why 1	Excess Parallelism (0.040)
Why 2	Burr placed at surface (7.0)
Why 3	Drill worn out
Why 4	Excess use of drill Ø14.10mm
Why 5	Tool life defined for 600nos/Re-sharpening
Root Cause (Occurance)	Excess use of drill Ø14.10mm

Root Cause Analysis (Outflow)

Why 1	Skipped from final inspection
Why 2	Sampling basis inspection as per IS:2500
Why 3	No 100% inspection
Why 4	checking frequency followed as per control plan
Why 5	Correction required in the control plan for sample size and inspection frequency.
Root Cause (Outflow)	Correction required in the control plan for sample size and inspection frequency.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Inspection frequency increased from IS:2500 to 100:1200 as per control plan. rev date 05/05/2022.	Mr. Shaikh Laik	28/04/2022		Completed
Occurance	Drill changing frequency reduced from 600 to 500/Re-sharpening	Mr. Vinod Jadhav	28/04/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection frequency defined 100:1200
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	100:1200

10. Evidance of Countermeasure

Occurance (Before)	Excess use of drill Ø14.10mm (600/Re-sharpening) 57_Occurance_Before.jpg
Occurance (After)	Excess use of drill Ø14.10mm (500/Re-sharpening) 57_Occurance_After.jpg
Outflow (Before)	//0.040 checking freq. 32:1200 as per IS:2500 57_Outflow_Before.jpg
Outflow (After)	//0.040 checking freq. 100:1200 Was 32:1200 57_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CAP OIL LOCK (PRF & LML)

12. Document Review

Documents	ControlPlan, PFMEA, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Recheck, Problem Analysis, Occurenece side cause & actions to be updated and aligned.