QFR No - 7000838557

Defect Details

NC No.	7000838557
NC Date	25/05/2022
NC Submission Date	
Part No.	S2HT52107B
Part Name	OUTER SPRING K0PG
Supplier Name & Code	101225-HELICAL SPRINGS
ETL Plant	1136-ETL Suspension Sanand
Defect Details	NOT AS PER SPECIFICATION-Grinding Angle Less than 270 °

1. Problem Description

Defect Description	Grinding angel found less i.e. observed 190, 185, 220 degree against the spec of 270 degree min.
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	1820
Is Defect Repeatative?	No
Defect Sketch / Photo	3jd0wsglcjllsqocql1hxmsz.jpg

Supplier Communication Details

Quality Head Email ID	ravindra@helicalsprings.in
Plant Head/CEO Email ID	shaikhmoin@helicalsprings.in
MD Email ID	ataneja@helicalsprings.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1820	0	0	0	4000	5820
Check Qty	1820	0	0	0	4000	5820
NG Qty	1820	0	0	0	0	1820

Action taken on NG part

Scrap	0
Rework	0
Under Deviation	1820

Containment Action
Check all material found ok at helical end found ok.

3. Process Flow

Process Flow Description
RM>Coiling> SR1>Grinding>Shot peening >Correction>Powder Coating>PDI>Packing> Dispatch.

4. Process Details

Process / Operation	Grinding
Outsource	No
Machine / Cell	Grinding M/c
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	not feasible to maintain	grinding angle 250 deg	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos

7. Root Cause Analysis (Occurance)

Why 1	Grinding angle less observed
Why 2	grinding angle not achieved in grinding
Why 3	due to length variation, the grinding angle less
Why 4	grinding angle required is 250 deg min
Why 5	--
Root Cause (Occurance)	grinding angle required is 250 deg min

Root Cause Analysis (Outflow)

Why 1	Grinding angle less observed
Why 2	Not arrested in existing sampling due to less in no.
Why 3	--
Why 4	--
Why 5	--
Root Cause (Outflow)	Not arrested in existing sampling due to less in no.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Drawing modified and updated for Grinding angle	ETL-HELICAL	30/05/2022	08/08/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No change
Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10 nos

10. Evidance of Countermeasure

Occurance (Before)	Drawing with grinding angle 270 deg min 151_Occurance_Before.pdf
Occurance (After)	Drawing with grinding angle 250 deg min 151_Occurance_After.pdf
Outflow (Before)	Acceptance criteria - 270 deg min 151_Outflow_Before.pdf
Outflow (After)	Acceptance criteria - 250 deg min 151_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	no

12. Document Review

Documents	Drawing, ControlPlan, WISOP, InspCheckSheet
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	0
Reason for submission	Grinding leas