QFR No - 7000839961

Defect Details

NC No.	7000839961
NC Date	01/06/2022
NC Submission Date	
Part No.	550LG06202
Part Name	SEAT PIPE -K23A/PRFH-006
Supplier Name & Code	100929-HARSHAD ENGINEERING COMPANY
ETL Plant	1116-ETL K-120 Suspension
Defect Details	RUN OUT MORE-concentricty not ok (0.35 Ageins 0.1max)

1. Problem Description

Defect Description	Threading run out NG concern reported in PRFH Seat pipe. Run out observed up to 0.4 mm against required of 0.1 mm.
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	2000
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qaharshad@miteshauto.com
Plant Head/CEO Email ID	qaharshad@miteshauto.com
MD Email ID	auto.mitesh@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	9200	3200	0	2100	3400	17900
Check Qty	9200	3200	0	2100	3400	17900
NG Qty	3800	0	0	0	3400	7200

Action taken on NG part

Scrap	3800
Rework	0
Under Deviation	0

Containment Action
100% sorting done for Thread conc.

3. Process Flow

Process Flow Description
1. Cutting 2. Draw 3.Header(Cold forging) 4. Rough Grinding 5. CNC & SPM (Head, boring & Tapping) 6. Punching 7. Finish Grinding

4. Process Details

Process / Operation	CNC Boring & Tapping
Outsource	No
Machine / Cell	SPM (Boring & Tapping) & CS
Machine / Cell No.	SPM 1, 2, 3 & 4, 151

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Drilling Spindle TR Bad	Found upto 0.07 mm, spec. 0.05 mm	X
Machine	Face cutter TR Bad	Found ok within 0.02 against 0.05 mm	O
Machine	Collet TR wrt Tapping Spindle not ok	Found upto 0.03 against 0.05 mm	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	IS 2500

7. Root Cause Analysis (Occurance)

Why 1	Concentricity found oversize
Why 2	Bore conc. wrt Shank Dia. found Oversize
Why 3	Boring Spindle alignment wrt Collet found disturb 0.10 against 0.02 mm
Why 4	Indexing table repeatability not ok
Why 5	
Root Cause (Occurance)	Indexing table repeatability not ok

Root Cause Analysis (Outflow)

Why 1	Concentricity found oversize
Why 2	During production, only TPG conc. check point available
Why 3	Inspection freq. is 5 nos/2 hr
Why 4	
Why 5	
Root Cause (Outflow)	Inspection freq. is 5 nos/2 hr

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Indexing table replaced & Collet alignment done with Spindle	D. Jople	01/09/2022	01/09/2022	Completed
Outflow	Collet--wise runout checked every 2 hrs	Ashish Moharir	17/08/2022	01/09/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NA
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	13 nos

10. Evidance of Countermeasure

Occurance (Before)	Collet alignment with spindle found disturb 160_Occurance_Before.jpg
Occurance (After)	Old turret replace by New One 160_Occurance_After.jpg
Outflow (Before)	Runout checking done 5 nos every 2 hrs 160_Outflow_Before.pdf
Outflow (After)	Runout checking done collet-wise after every 2 hrs 160_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CNC, Tapping & SPM

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	Completed.