QFR No - 7000847161

Defect Details

NC No.	7000847161
NC Date	06/07/2022
NC Submission Date	
Part No.	550BZ05802
Part Name	CAP OIL LOCK -PRFH006
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1126-ETL Pantnagar
Defect Details	DEPTH O/SIZE.-Depth over size

1. Problem Description

Defect Description	Depth found Over size Observed 7.20,7.34 against 7±0.10 mm
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	114
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	29000	0	0	5000	0	34000
Check Qty	29000	0	0	5000	0	34000
NG Qty	114	0	0	5	0	119

Action taken on NG part

Scrap	0
Rework	119
Under Deviation	0

Containment Action
Segregation done for all the pipeline material & Dial type gauge made available in place of PPG on all the stages & Stage wise skill matrix defined for operator. Q gate license implemented for inspectors. OPL displayed on machine as well as inspection stages.

3. Process Flow

Process Flow Description
10) Parting ,Drilling & angle 2.7° 20) Ø8.50 chamfering 30) Grinding Operation 40) Plating, 50) Final Inspection, 60) Pre-dispatch inspection, 70) Packing & Dispatch

4. Process Details

Process / Operation	10) Parting ,Drilling & angle 2.7°
Outsource	No
Machine / Cell	TRAUB MACHINE SHOP
Machine / Cell No.	SE/ALM/03

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Semi-skilled manpower, inadequate knowledge of process/operations	Semi-skilled operator was working on machine for parting & drilling operation.	O
Tool	worn out	Tool life monitoring exist	O
Material	Bend bar in the raw material	bar observed bend at machining stage.	X
Method	100%Checking by relation type gauge, Dial type gauge required for sampling inspection.	Dial type gauge not evident for sampling basis inspection.	X
Machine	inaccurate machine/variations in machine	All the machine are ok and preventive maintenance being done as per defined frequency.	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Dial type gauge .
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

7. Root Cause Analysis (Occurance)

Why 1	DIM 7.0+/-0.1 under size
Why 2	Bar bend (Raw material Ø18.05) & uneven movement while machining.
Why 3	Excess bar length 5-6 meter
Why 4	Length requirement not given to RM supplier
Why 5	
Root Cause (Occurance)	Excess length of bar Ø18.05mm (5-6 meter)

Root Cause Analysis (Outflow)

Why 1	DIM 7.0+/-0.1 under size
Why 2	Inspection by Spl. concentricity checking gauge
Why 3	Attribute type gauge

Why 4	Dial type gauge not available.
Why 5	
Root Cause (Outflow)	Dial type gauge not in used while checking DIM 7.0+/-0.1mm.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Dial type gauge and comparator stand provided for sampling basis inspection as per SSPN IS:2500	Mr. Shaikh L..N	11/07/2022	08/07/2022	Completed
Occurance	Raw material ena1a Ø18.05mm total length reduced from 5/6 meter to 3/4 meter.	Mr. Datta Pandher	11/07/2022	08/07/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Dial type gauge and comparator stand provided for sampling basis inspection as per SSPN IS:2500 and 100% inspection by Spl. concentricity checking gauge.
Inspection Method	Other
Other Inspection Method	Dial type gauge.
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	32:1200

10. Evidance of Countermeasure

Occurance (Before)	Excess length of bar Ø18.05mm (5-6 meter). 192_Occurance_Before.jpg
Occurance (After)	Bar length of raw material Ø18.05mm reduced from 5/6 meter to 3/4 meter. 192_Occurance_After.jpg
Outflow (Before)	Inspection by Spl. concentricity checking gauge, Dial type gauge not in used while checking DIM 7.0+/-0.1mm. 192_Outflow_Before.pptx
Outflow (After)	Dial type gauge and comparator stand provided for sampling basis inspection as per SSPN IS:2500 192_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CAP OIL LOCK LML/ DF

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	OK