QFR No - 7000867314

Defect Details

NC No.	7000867314
NC Date	30/09/2022
NC Submission Date	
Part No.	520BI00961
Part Name	CALIPER BODY LH FINISHED -JD BLACK
Supplier Name & Code	201092-PRANEEL INDUSTRIES
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	FITTMENT NOT OK.-Burr fold inside the 10 mm hole

1. Problem Description

Defect Description	Burr fold inside the 10 mm hole
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	131
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@praneelgroup.com
Plant Head/CEO Email ID	praneelindustries@rediffmail.com
MD Email ID	anilpatil@praneelgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	500	1500	3000
Check Qty	1000	0	0	500	1500	3000
NG Qty	131	0	0	0	0	131

Action taken on NG part

Scrap	131
Rework	0
Under Deviation	0

Containment Action
100% stock inspected at ETL and supplier end and ok parts to line with identification mark

3. Process Flow

Process Flow Description
1.Raw Material inspection 2. Powder Coating Process 3.Inspection of powder coating parts 4. Face milling 5. Drilling & Tapping 6.Deburring 7.Final Inspection 8.PDI 9.Packing & Dispatch

4. Process Details

Process / Operation	GDC Machine
Outsource	Yes
Machine / Cell	GDC Machine
Machine / Cell No.	GDC Machine 02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Tool Wear out	Fittment issue	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Burr fold inside dia 10 mm
Why 2	Core pin undersized
Why 3	core pin wear out
Why 4	core pin life not monitored
Why 5	
Root Cause (Occurance)	Due to core pin wear out burr fold in dia 10mm

Root Cause Analysis (Outflow)

Why 1	core pin wear out
Why 2	core min life not monitored
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	due to core pin life not monitored core pin wear out leads into burr fold

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Core pin monitoring stared	QA	10/10/2022	10/10/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Core pin inspection frequency change
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	CD Checking point not added in check sheet 266_Occurance_Before.pptx
Occurance (After)	100% CD Checking added in Check sheet 266_Occurance_After.pptx
Outflow (Before)	Core Pin life not monitored 266_Outflow_Before.pptx
Outflow (After)	Core pin life monitoring started 266_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	GDC machine

12. Document Review

Documents	PMCheckSheet, InspCheckSheet
Specify Other Document	Q alert

13. Effectiveness Of Action

Reviewed Quantity	10000
Reason for submission	OK.