QFR No - 7000877598

Defect Details

NC No.	7000877598
NC Date	19/11/2022
NC Submission Date	
Part No.	520KU00302
Part Name	ROD GUIDE
Supplier Name & Code	100177-SPECIALITY SINTERED PRODUCTS P
ETL Plant	1116-ETL K-120 Suspension
Defect Details	DIMETER UNDERSIZE-i d undersize

1. Problem Description

Defect Description	Inner dia. undersize observed.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	208
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	ganesh.padwalkar@specialitysintered.com
Plant Head/CEO Email ID	sandeep.gaikwad@specialitysintered.com
MD Email ID	lalit.chaudhari@ssplpune.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	10000	30000	0	0	1000	41000
Check Qty	10000	30000	0	0	1000	41000
NG Qty	208	0	0	0	0	208

Action taken on NG part

Scrap	208
Rework	0
Under Deviation	0

Containment Action
100% inspection done with PPG go gauge

3. Process Flow

Process Flow Description
Raw Material Inspection - Compaction - Sintering - Debarring - sizing - Grooving - Predispatch Inspection - Oiling - Packaging - Dispatch

4. Process Details

Process / Operation	Grooving
Outsource	Yes
Machine / Cell	CNC
Machine / Cell No.	CNC Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskill operator	verified operator by interviewing and observed skill ok	X
Tool	sizing CO rod wear out	verify sizing co rod and observed spec as per specification	X
Machine	Process concern	verified machining process observed burr observed at ID groove	O
Material	incorrect raw material used	verified supplier TC and Third party report and observed raw materia as per drawing	X
Method	Inspection method at supplier end	veryfied inspection method at supplier end observed Inspection with PPG gauge	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS2500

7. Root Cause Analysis (Occurance)

Why 1	ID Under Size
Why 2	During The ID Grooving Process Part Get ID U/S
Why 3	Id Groove Burr Fold In ID .
Why 4	Process Concern
Why 5	
Root Cause (Occurance)	Process Concern

Root Cause Analysis (Outflow)

Why 1	ID Under Size
Why 2	Not Detected In final Inspection .
Why 3	Inspection Done On Sampling Basis.
Why 4	
Why 5	
Root Cause (Outflow)	Inspection Done On Sampling Basis.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Reaming Operation Started After Grooving Operation	Mahesh Narkhede	25/11/2022	25/11/2022	Completed
Outflow	100 % ID Inspection Started	Sunil Shejwal	20/11/2022	20/11/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % Inspection Started By PPG
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)	No Reaming Operation After Grooving 303_Occurance_Before.xlsx
Occurance (After)	Reaming Operation Added Before Grooving. 303_Occurance_After.xlsx
Outflow (Before)	Sampling Inspection 303_Outflow_Before.pdf
Outflow (After)	100 % Inspection Started 303_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	-

12. Document Review

Documents	PFMEA, ProcessFlowChart
Specify Other Document	Quality Alert

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	Completed.