QFR No - 7000933352

Defect Details

NC No.	7000933352
NC Date	28/07/2023
NC Submission Date	
Part No.	S1AB00612B
Part Name	ADJUSTER PLATED
Supplier Name & Code	100782-NICE STEEL INDUSTRIES
ETL Plant	1136-ETL Suspension Sanand
Defect Details	DIAMETER OVER SIZE-ID Oversize

1. Problem Description

Defect Description	ID oversize found 31.50 mm against specification (30.50~30.70)
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	1601
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	ppc.nice@batragroup.biz
Plant Head/CEO Email ID	ho.nice@batragroup.biz
MD Email ID	hitesh@batragroup.biz

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	4000	0	2000	2000	11000
Check Qty	3000	4000	0	2000	2000	11000
NG Qty	45	10	0	0	0	55

Action taken on NG part

Scrap	55
Rework	0
Under Deviation	0

Containment Action
All material segregated and rejection part scarped

3. Process Flow

Process Flow Description
10 RECEIVING INSPECTION 20 STORAGE 30 BLANKING 40 1st BENDING (`U` BENDING) 50 FINAL BENDING (ROUNDING) 60 MIG WELDING 70 FLAIRING 1st 80 FLAIRING 2nd 90 ID SIZING 100 SIDE GRINDING & BUFFING 110 BROACHING 120 HEAD GRINDING 130 OUTSIDE MOVEMENT FOR PLATING 140 STORAGE & RQC INSP. OF PLATED MATERIAL 150 FINAL INSPECTION 160 PACKING & DISPATCH

4. Process Details

Process / Operation	ID sizing
Outsource	No
Machine / Cell	Press machine
Machine / Cell No.	Press machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Wrong material used	MTC verified and found ok	O
Tool	ID sizing punch	ID sizing punched checked and found NG	X
Method	SOP not followed	SOP available and followed	O
Man	Unskilled operator	Skill matrix available	O
Machine	Machine capacity was not ok	Machine capacity is ok	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	ID oversize observed
Why 2	id not maintained in part at upper size
Why 3	leg was open during id sizing
Why 4	Extra force on part by ID sizing punch
Why 5	Minor welding bead stuck in part -
Root Cause (Occurance)	leg was open during id sizing

Root Cause Analysis (Outflow)

Why 1	Defective part passed to customer
Why 2	Could not detect during inspection
Why 3	Only go side inspection done by gauge
Why 4	
Why 5	
Root Cause (Outflow)	Only go side inspection done by gauge

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Re Round process added to close the open legs	Subodh Upadhyay	20/08/2023	20/08/2023	Completed
Outflow	Go and No Go gauge to be made	Nimit	20/08/2023	20/08/2023	Completed
Outflow	OPL dispalyed	Prahlad	20/08/2023	20/08/2023	Completed
Outflow	Training provided to all concern person	Nimit Prakash	20/08/2023	20/08/2023	Completed
Occurance	ID punch size decreased	Nimit Prakash	20/08/2023	20/08/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	GO and No go gauge implemented
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)	PFD DOCUEMNT 513_Occurance_Before.xlsx
Occurance (After)	PFD DOCUEMNT REVISED 513_Occurance_After.jpeg
Outflow (Before)	GAUGE 513_Outflow_Before.jpeg
Outflow (After)	GAUGE REVISED 513_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	POWER PRESS

12. Document Review

Documents	ControlPlan, ProcessFlowChart
Specify Other Document	PFD AND CP UPDATED

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	