QFR No - 7000965699

Defect Details

NC No.	7000965699
NC Date	08/12/2023
NC Submission Date	
Part No.	520FG08402
Part Name	GEAR PRIMARY DRIVEN (discover 125 cc)
Supplier Name & Code	100987-FLASH VIVEN MACHINING TECHNOLO
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	DIAMETER OVER SIZE-dia 36.0+0.016 found 36.036 mic

1. Problem Description

Defect Description	ID Found oversize up to 36.036 mm against 36 +0.016 mm
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	17
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	srk.quality@flashgroup.in
Plant Head/CEO Email ID	dkj.mfg@flashgroup.in
MD Email ID	sv.md@flashgroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	1500	0	2500	1590	7590
Check Qty	2000	1500	0	2500	1590	7590
NG Qty	17	0	0	0	0	17

Action taken on NG part

Scrap	17
Rework	0
Under Deviation	0

Containment Action
All WIP segregated

3. Process Flow

Process Flow Description
Forging - CNC Turning - Hobbing - Heat Treatment - Shot Blasting - ID Honing - Teeth Honing - Final Inspection - Packing & dispatch

4. Process Details

Process / Operation	ID Honing
Outsource	No
Machine / Cell	Nagel-2
Machine / Cell No.	Hard Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Excess material removed during ID honing	Spindle relay malfunctioning	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10

7. Root Cause Analysis (Occurance)

Why 1	Excess material remove from id
Why 2	Ladges not retract to original position after expansion
Why 3	spindle not retract to upward, and continuously rotating inside components
Why 4	spindle relay malfunction
Why 5	
Root Cause (Occurance)	spindle relay malfunction

Root Cause Analysis (Outflow)

Why 1	Not detected during final inspection
Why 2	Only sampling inspection
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Only sampling inspection at final inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	spindle relay replaced	adk	14/12/2023	14/12/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no 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)	Machine spindle relay malfunctioning 609_Occurance_Before.pdf
Occurance (After)	Machine spindle relay replaced 609_Occurance_After.pdf
Outflow (Before)	Sampling inspection at Final inspection 609_Outflow_Before.pdf
Outflow (After)	100% inspection started at Final inspection 609_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Nagel 1

12. Document Review

Documents	PMCheckSheet, InspCheckSheet
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Ok