QFR No - 7000985442

Defect Details

NC No.	7000985442
NC Date	14/02/2024
NC Submission Date	
Part No.	F2FA19033M
Part Name	K0PG FORK PIPE MACHINED
Supplier Name & Code	101109-TUBE INVESTMENTS OF INDIA LIMI
ETL Plant	1136-ETL Suspension Sanand
Defect Details	HOLE BLOCK-1.50 hole Problem

1. Problem Description

Defect Description	Hole block 1.50mm in Fork Pipe K0PG
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	170
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	anandms@tii.murugappa.com
Plant Head/CEO Email ID	girisha@tii.murugappa.com
MD Email ID	mukeshahuja@tii.murugappa.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	1300	500	4800
Check Qty	3000	0	0	1300	500	4800
NG Qty	170	0	0	0	0	170

Action taken on NG part

Scrap	0
Rework	170
Under Deviation	0

Containment Action
100% inspection done for Drill Hole 1.50 mm with Pin Gauge at customer end & In-house stock available.

3. Process Flow

Process Flow Description
RM - CNC MACHINING - DRILLING - DEBURRING - INSPECTION - BIN PACKING - DISPATCH.

4. Process Details

Process / Operation	DRILLING
Outsource	No
Machine / Cell	DRILLING MACHINE
Machine / Cell No.	DRILL MACHINE - 01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Drill hole burr not cleaned	Verifed & found drill hole burr not getting removed from drill hole ID	X
Method	Deburring operation not done	Verified & observed deburring operation being done	O
Man	unskilled manpower	Verified record & found Skilled	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	HOLE BLOCK-1.50 hole Problem
Why 2	Drill hole burr does not get removed in a deburring operation
Why 3	generation of an excess hard burr at hole ID
Why 4	Drill warn out before defined frequency of drill change
Why 5	Drill bit Manufacturing defect
Root Cause (Occurance)	Drill bit Manufacturing defect

Root Cause Analysis (Outflow)

Why 1	HOLE BLOCK-1.50 hole Problem
Why 2	Drill hole burr does not get removed in a deburring operation
Why 3	Drill hole burr not getting detected in Visual inspection
Why 4	No Inspection Specified in the final Inspection Quality plan for the drill hole block
Why 5	
Root Cause (Outflow)	No Inspection Specified in the final Inspection Quality plan for the drill hole block

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	check point added in Hourly inspection report for Drill hole block	Mr. Abhishek Yadav	10/03/2024	08/03/2024	Completed
Outflow	Inspection Specified in the final Inspection Quality plan for the drill hole block by using Pin gauge as per samplinug plan	Mr. Abhishek Yadav	10/03/2024	08/03/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection Specified in the final Inspection Quality plan for the drill hole block by using Pin gauge as per samplinug plan
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	Sampleplan

10. Evidance of Countermeasure

Occurance (Before)	No checkpoint added in Hourly inspection report for Drill hole block 677_Occurance_Before.pdf
Occurance (After)	checkpoint added in Hourly inspection report for Drill hole block 677_Occurance_After.pdf
Outflow (Before)	No Inspection was Specified in the final Inspection Quality plan for the drill hole block by using Pin gauge as per the sampling plan 677_Outflow_Before.pdf
Outflow (After)	Inspection Specified in the final Inspection Quality plan for the drill hole block by using Pin gauge as per sampling plan 677_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	K86

12. Document Review

Documents	InspCheckSheet
Specify Other Document	Quality Plan

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	Hole block 1.5 mm in fork pipe K0PG.