QFR No - 7001010243

Defect Details

NC No.	7001010243
NC Date	01/05/2024
NC Submission Date	
Part No.	520KT00102
Part Name	ROD BUSH
Supplier Name & Code	100177-SPECIALITY SINTERED PRODUCTS P
ETL Plant	1136-ETL Suspension Sanand
Defect Details	PARALITY NOT OK.-Parallelism observed up to 0.150 against

1. Problem Description

Defect Description	Parallelism observed 0.150 against specification 0.100 mm.
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	15000
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	kalyan.babar@specialitysintered.com
Plant Head/CEO Email ID	Datta.gadhave@ssplpune.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	51000	0	0	5000	0	56000
Check Qty	51000	0	0	5000	0	56000
NG Qty	51000	0	0	0	0	51000

Action taken on NG part

Scrap	51000
Rework	0
Under Deviation	0

Containment Action
100% inspection done for FG parts available at SSPL END

3. Process Flow

Process Flow Description
RM Inspection - Forming - Sintering - Debarring - Steam - Final inspection - Packaging

4. Process Details

Process / Operation	Forming
Outsource	Yes
Machine / Cell	15F3
Machine / Cell No.	15F3

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	unskilled operator	interviewing operator operator skill observed ok	X
Material	Wrong grade RM used	verified Raw Materil TC obsered grade is OK	X
Material	incorrect resting material	verified resting obsevred less strength	O
Method	incorrect control plan	verified control plan flange tapper not addressed in control plan	O
Tool	incorrect tool used	verified inccorect tool used detected in first off	X
Method	incorrect inspection method	verified inspection method observed ok with V block & dial gauge	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Parallelism NG observed up to 0.25 mm against spec 0.1 mm max
Why 2	Parallelism Getting out of spec In Forming Process.
Why 3	In Running Condition Length Taper Generated
Why 4	Punch resting Getting Cracked during running condition
Why 5	less strength of resting
Root Cause (Occurance)	less strength of resting

Root Cause Analysis (Outflow)

Why 1	Parallelism NG observed up to 0.25 mm against spec 0.1 mm max
Why 2	Part Not Detect in Process Inspection
Why 3	Inspector Not Checked Flange Taper.
Why 4	Flange Taper Checkpoint Not Address In Forming Control Plan. .
Why 5	
Root Cause (Outflow)	Flange Taper Checkpoint Not Address In Forming Control Plan. .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Countermeasure Details Responsibility Target Date Actual Date Status Occurance New Top Punch Resting Made With Sufficient Straight. (Total Width 50MM) Top Punch Resting Check Point Add In Tool History Card.	Mayur Patil	16/05/2024	17/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	length inspection method changed flange tapper point added in forming control plan
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS2500

10. Evidance of Countermeasure

Occurance (Before)	N-31 material grade used 770_Occurance_Before.xlsx
Occurance (After)	N-24 material grade used 770_Occurance_After.xlsx
Outflow (Before)	Their was no check point of flange tapper 770_Outflow_Before.jpeg
Outflow (After)	Flange tapper check point added in control plan 770_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	S2KT model

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	Parallelism found Ok in upcoming fresh Lots .