QFR No - 7001013621

Defect Details

NC No.	7001013621
NC Date	14/05/2024
NC Submission Date	
Part No.	S2CW00612B
Part Name	D NUT- HF DELUX
Supplier Name & Code	100151-EXCELL PRESSINGS
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	NOT AS PER SPECIFICATION-perpendicularity 0.66 mm against 0.25 mm

1. Problem Description

Defect Description	Not as per Specification Perpendicularity 0.66 mm against 0.25 mm.
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	4000
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	excellpressings.qc@gmail.com
Plant Head/CEO Email ID	yogesh_vaidya42@yahoo.co.in
MD Email ID	excellpressings@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4000	0	0	2000	3000	9000
Check Qty	4000	0	0	2000	3000	9000
NG Qty	4000	0	0	1200	800	6000

Action taken on NG part

Scrap	6000
Rework	0
Under Deviation	0

Containment Action
We have checked all the lots available in Finished goods area and parts available in Work in progress, in which some parts are found NG, that will be scraped.

3. Process Flow

Process Flow Description
Shearing -Blanking & piercing - ID chamfer- tapping to ID(M9X1.25 6G)-plating-final inspection- dispatch

4. Process Details

Process / Operation	Tapping opeartion
Outsource	No
Machine / Cell	Tapping machine upto M12
Machine / Cell No.	EP-25

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	STOPPER STRIP WEAR OUT	STOPPER STRIP FOUND WEAR OUT	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5

7. Root Cause Analysis (Occurance)

Why 1	Perpendicularity increased
Why 2	Threading has gone crossed while tapping
Why 3	Part has moved with tap to upper side,part got tilt by 0.3 mm.
Why 4	Stopper strip provided on tapping fixture has wear out
Why 5	Not checked the stopper strip
Root Cause (Occurance)	As the stopper strip was wear out, part came on top side and part get tilted, so perpendicularity increased.

Root Cause Analysis (Outflow)

Why 1	Part not checked for perpendicularity
Why 2	not aware of problem raised due to perpendicularity
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Perpendicularity was not checked in process and final inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	part will be checked in process inspection and in final inspection for perpendicularity	Ankosh Mathure	18/05/2024	18/05/2024	Completed
Occurance	stopper strip will be changed	Ankosh Mathure	18/05/2024	18/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	perpendicularity will be checked for every lot
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5

10. Evidance of Countermeasure

Occurance (Before)	STOPPER STRIP ON TAPPING FIXTURE WEAR OT 802_Occurance_Before.jpg
Occurance (After)	NEW STOPPER STRIP OF HARDENED MATERIAL USED 802_Occurance_After.jpg
Outflow (Before)	PERPENDICULARITY FOUND NOT OK 802_Outflow_Before.jpg
Outflow (After)	PERPENDICULARITY OBSERVED OK 802_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	TAPPING MACHINE EP-17

12. Document Review

Documents	PMCheckSheet, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	