QFR No - 7001019734

Defect Details

NC No.	7001019734
NC Date	01/06/2024
NC Submission Date	
Part No.	F2PH00902B
Part Name	VALVE RETAINER (C101B)
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	HIGHT U/SIZE.-Total Width undersize

1. Problem Description

Defect Description	Total width undersize, Specification 9.3 mm observation 8.75 mm
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	4670
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
Plant Head/CEO Email ID	kurund.ma@sharp-engineers.com
MD Email ID	urkhandelwal@sharp-engineers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	10000	0	5000	0	10000	25000
Check Qty	10000	0	5000	0	10000	25000
NG Qty	4670	0	0	0	0	4670

Action taken on NG part

Scrap	4670
Rework	0
Under Deviation	0

Containment Action
Segregation done for all the suspected material of pipeline and defective part removed from OK part and quarantine.

3. Process Flow

Process Flow Description
10) RM inward 20) RM Storage 30) Parting 40) CNC 1st set up 50) OD grinding 60) Plating (Outsource) 70) Inward Inspection 80) Final inspection 90) Pr-dispatch inspection 100) Packing & forwarding.

4. Process Details

Process / Operation	CNC Machining
Outsource	No
Machine / Cell	Machine Shop
Machine / Cell No.	SE/CNC 01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled manpower	Skilled manpower available	O
Tool	Tool/Insert worn out	Tool life monitoring as per defined frequency available in the machine interlock.	O
Machine	Machine Variation	JH/PM as per defined frequency	O
Material	Suspected NG part in the pipeline material	Pipeline material was NG and not recalled after receipt of customer complaint	X
Method	Incorrect checking method	common method for inspection by attribute type height gauge	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

7. Root Cause Analysis (Occurance)

Why 1	Total length under part reached at ETL
Why 2	NG material of pipeline not recalled
Why 3	Because of line stoppage
Why 4	
Why 5	
Root Cause (Occurance)	NG material of pipeline not recalled

Root Cause Analysis (Outflow)

Why 1	Total length under part reached at ETL
Why 2	not detected in the final inspection
Why 3	Taper observed at one side of the parts
Why 4	
Why 5	

Root Cause (Outflow)	Taper observed at one side of the parts

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Inventory level of ware house for VALVE RETAINER increase as per defined scheduled qty	Mr. Kurund M.A.	20/06/2024	20/06/2024	Completed
Outflow	Part are being checked at both side of the part by attribute type height gauge 100% before dispatch. inspector identification tag are being provided for traceability purpose	Mr. Shaikh L.N	20/06/2024	20/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Component are being checked at both side of the part by attribute type height gauge 100% before dispatch.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	NG material of pipeline not recalled because of less material inventory level at warehouse. 833_Occurance_Before.pptx
Occurance (After)	Inventory level of ware house for VALVE RETAINER increase as per defined scheduled qty. 833_Occurance_After.xlsx
Outflow (Before)	Taper observed at one side of the parts, inspection done only one side of the part. 833_Outflow_Before.pptx
Outflow (After)	Part are being checked at both side of the part by attribute type height gauge 100% before dispatch. inspector identification tag are being provided for traceability purpose 833_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	Total width undersize