QFR No - 7001024806

Defect Details

NC No.	7001024806
NC Date	18/06/2024
NC Submission Date	
Part No.	S2DP02902B
Part Name	EXTENSION K55G
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	CRACK-crack lot (suspected material)

1. Problem Description

Defect Description	Crack
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	2200
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	5000	5000	2000	3000	500	15500
Check Qty	5000	5000	2000	3000	500	15500
NG Qty	2200	0	0	0	5	2205

Action taken on NG part

Scrap	2205
Rework	0
Under Deviation	0

Containment Action
Segregation done immediately for suspected material of pipeline .

3. Process Flow

Process Flow Description
10) RM Inward 20) RM Storage 30) Traub Operation (Parting & Drilling) 40) Forming 50) Tapping 60) OD grinding 70) MPI 80) Visual Inspection 90) Oiling 100) Packing & forwarding

4. Process Details

Process / Operation	Traub Machining
Outsource	No
Machine / Cell	Traub Machine
Machine / Cell No.	SE/SSAL/06

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	NG storage open	Wrong storage method for NG part, no lock and key	X
Man	Unskilled Manpower	Skill matrix as per requirement	O
Machine	Machine Variation	JH/PM as per defined frequency	O
Material	Wrong material grade	Third part inspection as per RM testing plan	O
Tool	Tool/insert/drill worn out	Tool life monitoring as per defined frequency	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Extension K55 Crack
Why 2	RM crack at draw stage
Why 3	Internal crack not detectable.
Why 4	Not feasible in MPI
Why 5	Need ultrasonic test at round bar stage not done.
Root Cause (Occurance)	Need ultrasonic test at round bar stage not done.

Root Cause Analysis (Outflow)

Why 1	Crack Part got mix up with ok part
Why 2	NG material kept openly in bin without lock and keys.
Why 3	lock and key not available at MPI testing supplier (Outsource)
Why 4	
Why 5	
Root Cause (Outflow)	lock and key not available at MPI testing supplier (Outsource)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Ultrasonic test is being done at round bar stage after draw process	Mr. Ganesh Chavan	25/06/2024	25/06/2024	Completed
Outflow	Lock and key provided for NG material at MPI testing supplier.	Mr. Shaikh L.N.	26/06/2024	26/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Ultrasonic test is being don at draw stage at sub-supplier.(Vishwa Samrudhi Industries)
Inspection Method	Other
Other Inspection Method	ultrasonic test (UTI
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	Magnetic particle inspection after draw process 874_Occurance_Before.pptx
Occurance (After)	Additional Ultrasonic test is being done at round bar stage after draw process 874_Occurance_After.pptx
Outflow (Before)	lock and key not available at MPI testing supplier (Outsource) 874_Outflow_Before.pptx
Outflow (After)	Lock and key provided for NG material at MPI testing supplier. 874_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

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

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	Crack