QFR No - 7001045399

Defect Details

NC No.	7001045399
NC Date	21/08/2024
NC Submission Date	
Part No.	F2DZ08810B
Part Name	K0PG FORK BOLT
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	PLATING NOT OK-Plating milky white ,black spot

1. Problem Description

Defect Description	Plating defect i.e. milky white and Black spot .
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	721
Is Defect Repeatative?	Yes
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	7200	9800	0	5000	0	22000
Check Qty	7200	9800	0	5000	0	22000
NG Qty	780	10	0	0	0	790

Action taken on NG part

Scrap	0
Rework	780
Under Deviation	0

Containment Action
All pipeline material segregated at customer end, warehouse and FG stock

3. Process Flow

Process Flow Description
Incoming RM-Parting-CNC 1st-CNC 2nd-Plating-Final Inspection-PDI-Packing and forwarding

4. Process Details

Process / Operation	Plating
Outsource	Yes
Machine / Cell	Plating cell
Machine / Cell No.	Plating cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Process Parameter wrong	Found as per control plan	O
Method	Jig not clean properly	Cleaned properly at defined frequency	O
Method	Part not Loaded properly	Part loaded properly as per SOP	O
Method	Curing Time not given	Curing not done	X
Method	Inspection frequency	Inspection frequency less	X
Tool	Tool change	No change	O
Material	PH variation	PH found OK	O
Machine	Tank not discarded	found ok	O
Man	New manpower	Manpower not changed	O
Material	Incorrect Chemical	Found ok	O
Man	Unskilled Operator	Skill manpower available as per skill matrix	O
Material	Variation in Chemical	Chemical found ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10 nos

7. Root Cause Analysis (Occurance)

Why 1	Plating Not ok
Why 2	Found Rusty, black spot
Why 3	Part dispatched without curing process
Why 4	
Why 5	
Root Cause (Occurance)	Curing process not done

Root Cause Analysis (Outflow)

Why 1	Plating Not ok
Why 2	Found Rusty, black spot
Why 3	Skipped from final inspection stage
Why 4	Inspection frequency is low
Why 5	
Root Cause (Outflow)	Inspection frequency is low

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Onjob training given to Operator about process awareness	Mr. Pradeep Bhagwat	16/08/2024	16/08/2024	Completed
Outflow	Inspection frequency increased from 10nos per lot to 20nos per lot	Mr. Pradeep bhagwat	16/08/2024	16/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection frequency inscreased
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Curing process SOP not displayed 1029_Occurance_Before.jpg
Occurance (After)	Curing process SOP displayd 1029_Occurance_After.jpg
Outflow (Before)	Inspection frequency less 1029_Outflow_Before.jpg
Outflow (After)	Onjob training given to operator and inspector for defect awareness and inspection frequency 20nos per lot 1029_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Plating cell

12. Document Review

Documents	ControlPlan, PFMEA, WISOP

Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	5
Reason for submission	PLATING NOT OK-Plating milky white ,black spot.