QFR No - 8000779380

Defect Details

NC No.	8000779380
NC Date	10/03/2022
NC Submission Date	
Part No.	F1FA01333M
Part Name	FORK PIPE MACHINED-K86A
Supplier Name & Code	101187-TUBE INVESTMENTS OF INDIA LIMI
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	DIMN.U/SIZE.-TOTAL LENGTH LESS ISSUE

1. Problem Description

Defect Description	front fork K86 fork pipe Specification = Total Length Specification = – 288.3±0.2mm,Observation= Total Length – 285.39 mm, total length less issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	5btumtx43lb0oa45ujucrky4.xlsx

Supplier Communication Details

Quality Head Email ID	AmitVD@tii.murugappa.com
Plant Head/CEO Email ID	guptaajay@tii.murugappa.com
MD Email ID	mukeshahuja@tii.murugappa.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1320	0	0	800	0	2120
Check Qty	1320	0	0	800	0	2120
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
Available lot at Endurance checked 100% - No rejection

3. Process Flow

Process Flow Description
Cut to length CNC Machining 1 CNC Machining 2 Drilling Final Inspection Packing & Despatch

4. Process Details

Process / Operation	CNC Machining
Outsource	Yes
Machine / Cell	CNC Machine
Machine / Cell No.	M08

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Loose burr got struck at the end	Verified with Loose burr at the edge condition & Observed Length undersize based on the burr thk	O
Material	RM Tube length undersize	RM tube verified & found OK	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Total height under size up to 3mm
Why 2	Part moved at front side
Why 3	Improper face butting
Why 4	Machining burr sticked at butting face
Why 5	Air cleaning process not done properly
Root Cause (Occurance)	Air cleaning process not done properly

Root Cause Analysis (Outflow)

Why 1	Skipped from final inspection
Why 2	Sample inspection only
Why 3	As defined in the Existing System
Why 4	
Why 5	
Root Cause (Outflow)	Sample inspection only

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Air line provided in the Clamping chuck	Ohm Industry	04/07/2022	24/03/2022	Completed
Outflow	100% inspection implemented at process and FI	Ohm Industry	11/03/2022	11/03/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Final Inspection 100% Inspection added
Inspection Method	Other
Other Inspection Method	Dial Gauge
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Manual Air cleaning 10_Occurance_Before.xlsx
Occurance (After)	Air cleaning Nozzle introduced 10_Occurance_After.xlsx
Outflow (Before)	Sample inspection 10_Outflow_Before.xlsx
Outflow (After)	100% Inspection at Final Inspection 10_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	K86 Model

12. Document Review

Documents	PFMEA, WISOP
Specify Other Document	Q- Alert displayed

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	