QFR No - 8000779743

Defect Details

NC No.	8000779743
NC Date	12/03/2022
NC Submission Date	
Part No.	S1CW00512B
Part Name	D NUT K0LA
Supplier Name & Code	100165-SAPTAGIRI INDUSTRIES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	THREADING MISSING-DNUT WITHOUT THREADING

1. Problem Description

Defect Description	K0LA rear D nut without threading issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	3
Is Defect Repeatative?	No
Defect Sketch / Photo	r4uioy4swlnu5yytx1sfjsju.xlsx

Supplier Communication Details

Quality Head Email ID	quality@saptagirigroup.in
Plant Head/CEO Email ID	quality@saptagirigroup.in
MD Email ID	argandhi@saptagirigroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	10000	12000	0	13500	5200	40700
Check Qty	10000	12000	0	13500	5200	40700
NG Qty	0	0	0	25	0	25

Action taken on NG part

Scrap	13
Rework	0
Under Deviation	0

Containment Action
We have checked In house and M/S ETL end

3. Process Flow

Process Flow Description

Raw Material Inward Sheet Shearing Blanking & Center Piercing Both side chamfer Tapping Plating Final Inspection Packing/storing

4. Process Details

Process / Operation	Tapping
Outsource	No
Machine / Cell	Machine No 1
Machine / Cell No.	Machine No 1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Punch NG	Punch Worn out.	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

7. Root Cause Analysis (Occurance)

Why 1	D`nut found Go not pass
Why 2	Punch Worn out.
Why 3	Before threading Id undersize observed 8.65mm Instead of 8.75mm.
Why 4	Tool History card not updated
Why 5	
Root Cause (Occurance)	Before threading Id undersize observed 8.65mm Instead of 8.75mm.

Root Cause Analysis (Outflow)

Why 1	Punch Replace with New one with size 8.75mm.
Why 2	Tool history card maintain.
Why 3	Sampling qty. increases for thread inspection for inprocess & final inspection 100 nos/lot instead of 50 nos/lot
Why 4	
Why 5	
Root Cause (Outflow)	Sampling qty. increases for thread inspection for inprocess & final inspection 100 nos/lot instead of 50 nos/lot

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	final inspection 100 nos/lot instead of 50 nos/lot
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

10. Evidance of Countermeasure

Occurance (Before)	Punch wear out NOGO Pass 14_Occurance_Before.pptx
Occurance (After)	Punch Replace Dimn. 14_Occurance_After.pptx
Outflow (Before)	Less sampling frequency 14_Outflow_Before.pdf
Outflow (After)	sampling frequency Increase 14_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Saptagiri Engg. Machine No 1

12. Document Review

Documents	WISOP
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	15000
Reason for submission	reviewed 15000 numbers no thread miss found ok