QFR No - 8000782061

Defect Details

NC No.	8000782061
NC Date	27/03/2022
NC Submission Date	
Part No.	520CJ00102
Part Name	COPPER WASHER
Supplier Name & Code	100152-GOLDY PRECISION STAMPINGS PVT.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	EXCESS CUT/SANDERING-CUT FROM EDGE

1. Problem Description

Defect Description	Part Cut From OD
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	5
Is Defect Repeatative?	Yes
Defect Sketch / Photo	rfo2mvbruc002pra10ggh2kq.png

Supplier Communication Details

Quality Head Email ID	quality@goldy.in
Plant Head/CEO Email ID	mangesh.chaudhary@goldy.in
MD Email ID	sidhesh.raikar@goldy.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	10000	0	0	10000	0	20000
Check Qty	10000	0	0	10000	0	20000
NG Qty	5	0	0	0	0	5

Action taken on NG part

Scrap	5
Rework	0
Under Deviation	0

Containment Action
Finish good qty 10000 Nos verify at visual inspection found ok.

3. Process Flow

Process Flow Description

10- RAW MATERIAL INSPECTION, 20-BLANKING, 30-ANNELING, 40-100% VISUAL INSPECTION, PACKING & FG STOCK, 50-FINAL INSPECTION & DISPATCH

4. Process Details

Process / Operation	BLANKING
Outsource	No
Machine / Cell	PRESS MACHINE
Machine / Cell No.	P-4

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Operator skill	Verify opeartor skill as per Enducation & training, operator found trained	O
Method	Blanking method not ok	Checked method as per work instruction found ok	O
Tool	Tool not ok	Verify Tool condition, dowel pin found not ok	X
Machine	Machine not ok	Checked Parameter checked founf ok	O
Material	Material not ok	Material thickness width, hardness checked found ok	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Outer Diameter cut found parts no- 520CJ00102
Why 2	Outer diameter cut during blanking while strip feeding
Why 3	Strip Overlap feed because toll dowel not control to overlap operation
Why 4	Dowel pin not ok, dowel pin height in sufficient
Why 5	NOT APPLICABLE
Root Cause (Occurance)	Dowel pin not ok, dowel pin height in sufficient

Root Cause Analysis (Outflow)

Why 1	Outer diameter cut parts skipped in visual inspection
Why 2	Operator could not detect to cut parts
Why 3	Operator take more parts on table for visual inspection
Why 4	NOT APPLICABLE
Why 5	NOT APPLICABLE
Root Cause (Outflow)	Operator take more parts on table for visual inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1) Dowel pin height increase more than 2 mm of thickness. (Height increase 3.5 against 1.5mm) 2) Operator verify pin height condition before start blanking.	Vikas Divate / Rahul kandale	28/03/2022	28/03/2022	Completed
Outflow	10-12 no`s parts checking started on visual inspection on table	Rahul Pawar	29/03/2022	29/03/2022	Completed
Outflow	Training given to visual inspector for part inspection	Rahul Pawar / Vikas Divate	29/03/2022	29/03/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	10-12 no`s parts checking started on visual inspection on table
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)	Dowel pin not ok, dowel pin height in sufficient 27_Occurance_Before.pdf
Occurance (After)	1) Dowel pin height increase more than 2 mm of thickness. (Height increase 3.5 against 1.5mm) 2)Operator verify pin condition before start blanking. 27_Occurance_After.pdf
Outflow (Before)	Operator take more parts on table for visual inspection 27_Outflow_Before.pdf
Outflow (After)	10-12 no`s parts checking started on visual inspection on table 27_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Cooper parts - 520CJ00502 & 520CJ00702

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	Before after

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Accepted