QFR No - 8000782143

Defect Details

NC No.	8000782143
NC Date	28/03/2022
NC Submission Date	
Part No.	580DV00102
Part Name	GEAR CONTROL PULLY H BAR ASSLY(24191184)
Supplier Name & Code	101086-PUNE POLYMERS PVT. LTD.
ETL Plant	1102-ETL L-6 Die Casting
Defect Details	FITTMENT NOT OK.-HOLE SHIFT

1. Problem Description

Defect Description	Diameter 2.2 Shift
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	669
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qa.waluj@punepolymers.com
Plant Head/CEO Email ID	planthead.waluj@punepolymers.com
MD Email ID	s.gupta@punepolymers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5000	0	0	1500	1500	8000
Check Qty	5000	0	0	1500	1500	8000
NG Qty	550	0	0	0	0	550

Action taken on NG part

Scrap	550
Rework	0
Under Deviation	0

Containment Action
100 % inspection done for all material in stock.

3. Process Flow

Process Flow Description
In. molding - Inspection - packing - Dispatch

4. Process Details

Process / Operation	Inj. molding
Outsource	No
Machine / Cell	Cell A
Machine / Cell No.	Cell A

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Pin bent in mold.	Pin bent in mold.	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	10

7. Root Cause Analysis (Occurance)

Why 1	Fitment not ok
Why 2	Hole shift
Why 3	Pin bent in mold.
Why 4	
Why 5	
Root Cause (Occurance)	Pin bent in mold.

Root Cause Analysis (Outflow)

Why 1	Skipped from inspection.
Why 2	Not detected in sampling.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Not detected in sampling.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Pin replaced in the mold.	PPPL	15/04/2022	15/04/2022	Completed
Outflow	100 % inspection	PPPL	05/04/2022	05/04/2022	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	Pin bent 30_Occurance_Before.xls
Occurance (After)	Pin replaced. 30_Occurance_After.xls
Outflow (Before)	Sampling inspection. 30_Outflow_Before.xls
Outflow (After)	100 % inspection. 30_Outflow_After.xls

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

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

13. Effectiveness Of Action

Reviewed Quantity	50000
Reason for submission	Monitor for next one month & no issue observed