QFR No - 8000782620

Defect Details

NC No.	8000782620
NC Date	03/04/2022
NC Submission Date	
Part No.	F1LG00902B
Part Name	SEAT PIPE -K86A
Supplier Name & Code	100538-NARINDER PARKASH AND CO
ETL Plant	1136-ETL Suspension Sanand
Defect Details	NOT AS PER SPECIFICATION-TOTAL LENGTH UNDER SIZE I.E. 148.89 MM

1. Problem Description

Defect Description	Total Length Under Size
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@npcindustries.in
Plant Head/CEO Email ID	anand@npcindustries.in
MD Email ID	ajay@npcindustries.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	20000	7000	15000	0	0	42000
Check Qty	20000	7000	15000	0	0	42000
NG Qty	4	3	0	0	0	7

Action taken on NG part

Scrap	7
Rework	0
Under Deviation	0

Containment Action
Lock & Key type rejection bins to be implemented at work station.

3. Process Flow

Process Flow Description
1.RM Receipt 2. Cutting 3.Multistation Draw 4. Head Formation 5. Rough Grinding 6. Punching 7. CNC Head Turning & Chamfering 8. CNC Boring & Facing 9. Thread M8x1.25 Tapping 10. Chamfering-1 11. Chamfering-2 12. ID Deburring 13. Finish Grinding 14. Final Inspection 15. ID Cleaning 16. Oiling 17. Packing & Dispatch 18. Transportation.

4. Process Details

Process / Operation	CNC Boring & Facing
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	NP/CNC/013

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Quality Inspector negligent	Quality Inspector found to be non-negligent and performed his duty with diligence	O
Method	Operator located part incorrectly	Verified found OK	O
Method	Other model mixed during processing	Verified found OK	O
Man	Opeartor located part incorrectly	Verified found OK	O
Method	CNC Stopper design inadequate	Verified found OK	O
Method	CNC vernier not calibrated	Verified found OK	O
Method	NG setting part mixed	Verified found not OK	X
Method	Usage of open Red Bins	Verified found not 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	Asper plan

7. Root Cause Analysis (Occurance)

Why 1	Total length undersize
Why 2	NG Setting part with length undersize passed
Why 3	NG Setting part mixed in OK parts
Why 4	Usage of open Red Bins
Why 5	
Root Cause (Occurance)	Usage of open Red Bins

Root Cause Analysis (Outflow)

Why 1	Total Length undersize

Why 2	Could not be detected at Final Inspection
Why 3	Skipped in Sampling at Final Inspection
Why 4	
Why 5	
Root Cause (Outflow)	Skipped in Sampling at Final Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Training to be provided to line supervisor and all line operators	Mr Gurpreet	11/04/2022		Completed
Occurance	Lock & Key type rejection bins to be implemented at work station (Only part drop down and not pick up from Bin)	Mr Mohinderpal	12/04/2022		Completed
Occurance	Quality Alert to be displayed at work station	Mr. Lokesh	04/04/2022		Completed
Outflow	100% marking after total length inspection to be done	Mr. Ankush	07/04/2022		Completed
Outflow	Quality alert to be displayed at final inspection	Mr. Lokesh	04/04/2022		Completed
Occurance	Setting NG part to be damaged by shift supervisor.	Mr. Gursewak Singh	07/04/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling plan is doubled
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	double

10. Evidance of Countermeasure

Occurance (Before)	Open Red Bin 41_Occurance_Before.png
Occurance (After)	Lock & Key type rejection bins at work station (Only part drop down and not pick up from Bin) 41_Occurance_After.jpg
Outflow (Before)	As per Sampling Plan 41_Outflow_Before.jpg
Outflow (After)	Sampling Plan Doubled 41_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Applicable all similar parts

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	