QFR No - 8000783094

Defect Details

NC No.	8000783094
NC Date	07/04/2022
NC Submission Date	
Part No.	F2DZ08810B
Part Name	K0PG FORK BOLT
Supplier Name & Code	101037-SHREE PATEL INDUSTRIES
ETL Plant	1136-ETL Suspension Sanand
Defect Details	DEEP MARK-MACHINING UNCLEAN

1. Problem Description

Defect Description	Line mark at OD 26.15
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	35
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality_spi@rediffmail.com
Plant Head/CEO Email ID	planthead_spi@rediffmail.com
MD Email ID	rspatel_spi@rediffmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	10000	0	0	2618	0	12618
Check Qty	10000	0	0	2618	0	12618
NG Qty	1	0	0	2	0	3

Action taken on NG part

Scrap	3
Rework	0
Under Deviation	0

Containment Action
Hold the material at all stages and inspection done accordingly .

3. Process Flow

Process Flow Description
1. Incoming RM 2. Acid Pickling 3. Water Wash 4. Lime Wash 5. Pointing 6. Draw 7. Cutting 8. Straightening 9. Inspection 10.Packing & Dispatch 11. Incoming RM 12. Traub Turning 13. CNC 1st set up 14. CNC 2nd set up 15. Plating 16. Inspection 17. Packing & Dispatch

4. Process Details

Process / Operation	Draw
Outsource	No
Machine / Cell	Draw Machine
Machine / Cell No.	Draw Line

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Awareness of Inspector	Operator was not aware about inspection std	O
Machine	Die Check sheet	During process Verification no Die check point available	O
Method	Rod Draw	During process verification a deep line mark generated on rod during draw operation.	O
Machine	Die Life Monitoring	During process Verification no Die life monitoring record available	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	05

7. Root Cause Analysis (Occurance)

Why 1	Deep Line mark part reached at customer end.
Why 2	Deep line mark part generate during CNC operation.
Why 3	Deep line mark found on input rod .
Why 4	At draw operation chips observed on rod, which remains a deep line on rod during draw process.
Why 5	There was No checkpoint & WI available at draw operation to check the input & output material of rod.
Root Cause (Occurance)	At draw operation chips observed on rod which generate / remains a deep line on rod during draw operat

Root Cause Analysis (Outflow)

Why 1	Deep Line mark part reached at customer end.
Why 2	Inspector not detected deep line mark part during final inspection .
Why 3	Inspector was not aware about the defect.
Why 4	No inspection std available at final inspection station.
Why 5	
Root Cause (Outflow)	No inspection std available at final inspection station.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. WI made to check the Input & Output material & also FIR ,IIR made to check the draw bar after draw process . 2. Draw Die checkpoint check sheet made . 3. Die life monitoring to be started	Pradeep Tripathi	18/02/2022	18/02/2022	Completed
Outflow	1. Training provided to the final inspector about the problem and inspection std. 2. 200% visual inspection started.	Pradeep Tripathi	18/02/2022	18/02/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	200% Visual Inspection
Inspection Method	Other
Other Inspection Method	Visual Inspection.
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Die Check Sheet 45_Occurance_Before.zip
Occurance (After)	Die Check Sheet 45_Occurance_After.zip
Outflow (Before)	Inspection Std 45_Outflow_Before.xlsx
Outflow (After)	Inspection Std 45_Outflow_After.zip

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	No

12. Document Review

Documents	ControlPlan, PMCheckSheet, InspCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	0
Reason for submission	Draw Die PM Sheet updated but revision number not changed. Also Document Control plan and PFMEA not updated as per revised Checking frequency and possible causes.