QFR No - 8000783853

Defect Details

NC No.	8000783853
NC Date	14/04/2022
NC Submission Date	
Part No.	550BZ04302
Part Name	CAP OIL LOCK - DT
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-PARALLELISM NOT OK

1. Problem Description

Defect Description	End Face Parallelism Not Ok
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	144
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
Plant Head/CEO Email ID	kurund.ma@sharp-engineers.com
MD Email ID	urkhandelwal@sharp-engineers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	900	0	0	0	0	900
Check Qty	900	0	0	0	0	900
NG Qty	68	0	0	0	0	68

Action taken on NG part

Scrap	0
Rework	68
Under Deviation	0

Containment Action
Under cut added in three chuck jaw for burr removing .

3. Process Flow

Process Flow Description
CNC stage

4. Process Details

Process / Operation	CNC Machining
Outsource	No
Machine / Cell	Machine Chop
Machine / Cell No.	SE/CNCE/04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator	Skill matrix monitoring	O
Tool	Insert Worn out	Tool life monitoring	O
Material	Wrong material	MTC & Third party report	O
Machine	Three chuck jaw under cut	Missing	X
Method	Improper loading	Observed	X

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10:100

7. Root Cause Analysis (Occurance)

Why 1	0.02mm PARALLELISM NOT OK
Why 2	Improper part loading
Why 3	Less under cut in chuck jaw
Why 4	Under cut removed while jaw boring
Why 5	
Root Cause (Occurance)	Under cut removed while jaw boring

Root Cause Analysis (Outflow)

Why 1	Excess parallelism
Why 2	Sampling basis inspection as per IS:2500
Why 3	Following checking frequency as per defined control plan
Why 4	
Why 5	
Root Cause (Outflow)	Following checking frequency as per defined control plan (32:1200 Nos.)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	100% inspection started before dispatch	Mr. Shaikh L.N.	20/04/2022	20/04/2022	Completed
Occurance	2mm under cut added in chuck jaw	Mr. Pandhre Datta	20/04/2022	20/04/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Checking frequency defined 100:1000
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	100:1000

10. Evidance of Countermeasure

Occurance (Before)	Burr cleaning done thru air pressure , improper cleaning because there is no under cut in clamping chuck jaw, burr, chip not removed from Chuck jaw properly. 50_Occurance_Before.pptx
Occurance (After)	Cleaning started thru air gun by providing high air pressure (4 Bar), burr chip removed from chuck jaw properly and defect eliminated because under cut added up to 1.5mm. 50_Occurance_After.pptx
Outflow (Before)	Sampling basis inspection as per IS:2500 (Sample size 32:1200 as per IS:2500) 50_Outflow_Before.jpg
Outflow (After)	Sample size increased from 32:1200 to 100:1200 Nos. 50_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CAP OIL LOCK J1D

12. Document Review

Documents	ControlPlan
Specify Other Document	-

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Next 2 lot inspected and no defect found