QFR No - 8000785385

Defect Details

NC No.	8000785385
NC Date	26/04/2022
NC Submission Date	
Part No.	530CZ00102
Part Name	DU BUSH
Supplier Name & Code	100037-BBL DAIDO PRIVATE LIMITED
ETL Plant	1136-ETL Suspension Sanand
Defect Details	CHAMFER NOT DONE- WARRANTY ANALYSIS PART

1. Problem Description

Defect Description	Uneven Chamfer and ID Coating Crumble observed in Warranty Return Parts, Also witnessed to supplier person.
Detection Stage	Warranty
Problem Severity	Function
NG Quantity	5
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rajamani@bbldaido.com
Plant Head/CEO Email ID	vinod@bbldaido.com
MD Email ID	

2. Stock Details & action taken for NG parts

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

Action taken on NG part

Scrap	5
Rework	0
Under Deviation	0

Containment Action
Bush investigated and found ID chamfer found OK and Bush material PTFE composition found good , hence Oil leak is not related to DU Bush. Available Bush at BBLD found OK

3. Process Flow

Process Flow Description
RM Inspection - Slitting - Welding - Size rolling - Facing and chamfering -Pressing - Coining - Plating - Final Inspection - Despatch

4. Process Details

Process / Operation	Facing and chamfering
Outsource	No
Machine / Cell	Bush Manufacturing line
Machine / Cell No.	5B-2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	ID Chamfer one side tool less depth of cut	Less depth of cut	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20 nos per

7. Root Cause Analysis (Occurance)

Why 1	ID Chamfer one side tool less depth of cut
Why 2	Coil Feed to chamfering tool contact space less
Why 3	Chamfer coil movement waviness not consider to run the parts maximum side
Why 4	Control dimension not provided in the process drawing
Why 5	
Root Cause (Occurance)	Control dimension not provided in the process drawing

Root Cause Analysis (Outflow)

Why 1	Bush ID chamfer found NG
Why 2	Bush ID chamfer sampling (1 no per lot) inspection by contour
Why 3	Sampling not adequate to control the ID chamfer dimension
Why 4	
Why 5	
Root Cause (Outflow)	Sampling not adequate to control the ID chamfer dimension

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1.Control dimension not provided in the process drawing	T.Rajamani	05/05/2022	05/09/2022	Completed
Outflow	Visual inspection limit sample provided to check the less chamfer	T.Rajamani	05/05/2022	05/09/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	ID chamfer band modified as per customer required chamfer
Inspection Method	Other
Other Inspection Method	ID chamfer provided
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20

10. Evidance of Countermeasure

Occurance (Before)	Refer attached 77_Occurance_Before.pdf
Occurance (After)	Refer attached 77_Occurance_After.pdf
Outflow (Before)	Refer attached 77_Outflow_Before.pdf
Outflow (After)	Refer attached 77_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Not applicable

12. Document Review

Documents	PFMEA, InspCheckSheet
Specify Other Document	Process drawing

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	