QFR No - 8000786759

Defect Details

NC No.	8000786759
NC Date	09/05/2022
NC Submission Date	
Part No.	F2BF26416M
Part Name	OUTER TUBE BUFF LH K0NA DRUM
Supplier Name & Code	100001-ANANT ENTERPRISES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	THREADING NOT OK-M6 WITH OUT THREAD

1. Problem Description

Defect Description	M6
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	4
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	anandkulkarni@anantgroup.co.in
Plant Head/CEO Email ID	pramodgosavi@anantgroup.co.in
MD Email ID	ashwinjoshi@anantgroup.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	0	0	2000	0	2000
Check Qty	0	0	0	2000	0	2000
NG Qty	0	0	0	1	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
100 % segregation on inhouse stock & Dot identification on job.

3. Process Flow

Process Flow Description
Vmc 1st Setup Op-10

4. Process Details

Process / Operation	Tapping operation
Outsource	No
Machine / Cell	vmc 1st setup op-10
Machine / Cell No.	vmc 1st setup op-10

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Due to abnormal situation tool broken	visual	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	4

7. Root Cause Analysis (Occurance)

Why 1	M6 Tapping tool broken
Why 2	Due to abnormal situation in machine process
Why 3	
Why 4	
Why 5	
Root Cause (Occurance)	M6 tool broken due to abnormal situation in m/c process.

Root Cause Analysis (Outflow)

Why 1	No 100 % inspection for M6 TPG.
Why 2	Checking Frequency On Hourly Basis.
Why 3	No Awareness about this type of defect due to abnormal situation .
Why 4	
Why 5	
Root Cause (Outflow)	No 100 % inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	Q-alert given to all operators & final inspectors	Bhagyesh khairnar	04/05/2022	04/05/2022	Completed
Occurance	Defect CatLog updated	Bhagyesh khairnar	04/05/2022	04/05/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Dot identification at M6 lug Area.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

10. Evidance of Countermeasure

Occurance (Before)	Training record 101_Occurance_Before.pdf
Occurance (After)	Q Alert given to all operators & final inspector 101_Occurance_After.pdf
Outflow (Before)	Identification mark on job 101_Outflow_Before.pdf
Outflow (After)	Defect CatLog 101_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Kola Disc Bottom Case

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	Training record

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	