QFR No - 8000787718

Defect Details

NC No.	8000787718
NC Date	17/05/2022
NC Submission Date	
Part No.	550LG06202
Part Name	SEAT PIPE -K23A/PRFH-006
Supplier Name & Code	100929-HARSHAD ENGINEERING COMPANY
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	HIGHT U/SIZE.-TOTAL LENGTH LESS ISSUE

1. Problem Description

Defect Description	KON seat pipe total length less issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	4
Is Defect Repeatative?	No
Defect Sketch / Photo	nqppngc1jzrocztqb5vn0rur.xlsx

Supplier Communication Details

Quality Head Email ID	qaharshad@miteshauto.com
Plant Head/CEO Email ID	qaharshad@miteshauto.com
MD Email ID	auto.mitesh@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	0	0	550	4325	6875
Check Qty	2000	0	0	0	0	2000
NG Qty	4	0	0	0	0	4

Action taken on NG part

Scrap	4
Rework	0
Under Deviation	0

Containment Action
1. 100 % sorting done at ETL 2. 100 % sorting done for HEC FG & WIP stock with Identification mark on box

3. Process Flow

Process Flow Description
"10 - Raw Material Annealed and Phosphated "20-A - Cutting & 20-B- Cutting wt. "30-A MOS Application 30 -B Multistation Draw "40-A- Head Formation "40-B Inward/Incoming Inspection "50 - Rough Grinding "60-A CNC Head Turning , Facing. 60-B Facing & Boring 60-C Tapping "70A - Punching "70B- Chamfering "80-A - Finish grinding 80-B Buffing "90-A- De-burr 90-B- Final/Visual Inspection "100-A ID Cleaning Diesel 100-B - Ultrasonic cleaning "110-A- Visual Inspection Q gate 110-B - Rust oil Application "120 - Packing & Dispatch

4. Process Details

Process / Operation	Inspection & Packing
Outsource	No
Machine / Cell	Packing section
Machine / Cell No.	120

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Mix up while packing process	At Packing station mix part found	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Model mix up
Why 2	During length process parts mix up
Why 3	Various models Length checking done at same station
Why 4	No any provision
Why 5	
Root Cause (Occurance)	Various models Length checking done at same station

Root Cause Analysis (Outflow)

Why 1	Model Mix up
Why 2	Various models Length checking done at same station
Why 3	After length checking process no check point
Why 4	
Why 5	
Root Cause (Outflow)	After length checking process no check point

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1.At Final inspection station separate inspection table with checking length gauge proved 2.100% inspection done for length 3."Q" Gate station added before packing 4.Total box weight done to ensure no mix up	Ashish M & Pravin Jadhav	25/05/2022	09/08/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1.At Final inspection station separate inspection table with checking length gauge proved 2.`Q` gate provided to ensure mix up concern 3. Total Box weight mention on each box
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)	Only One station for checking total length 125_Occurance_Before.jpg
Occurance (After)	Three inspection station provided for total length checking 125_Occurance_After.jpg
Outflow (Before)	No provision for Q Gate 125_Outflow_Before.jpg
Outflow (After)	Mix up checking station added (Q gate) 125_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Final Inspection & packing area total length station

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	Packing WI

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Reviewed 1000 number no issue found ok