QFR No - 8000787719

Defect Details

NC No.	8000787719
NC Date	17/05/2022
NC Submission Date	
Part No.	F1LG00902B
Part Name	SEAT PIPE -K86A
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	K0LA seat pipe total length less issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	nqppngc1jzrocztqb5vn0rur.xlsx

Supplier Communication Details

Quality Head Email ID	qaharshad@miteshauto.com
Plant Head/CEO Email ID	mitesh@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	4000	0	0	375	1100	5475
Check Qty	4000	0	0	375	1100	5475
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
1. 100 % sorting done at ETL 2. 100 % sorting done by length gauge checking at HEC wip & FG stock

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 at Q gate 110-B - Rust oil Application "120 - Packing & Dispatch

4. Process Details

Process / Operation	CNC
Outsource	No
Machine / Cell	CNC facing & drilling machine
Machine / Cell No.	141, 144

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Improper loading during facing operation	improper loading	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50nos

7. Root Cause Analysis (Occurance)

Why 1	Total Length under size
Why 2	Part loaded 2.0 mm offset while facing operation
Why 3	while total length facing operation part not correctly loaded
Why 4	
Why 5	
Root Cause (Occurance)	while total length facing operation part not correctly loaded

Root Cause Analysis (Outflow)

Why 1	Total Length undersize
Why 2	total length skip from inspector
Why 3	100% inspection not done for total length
Why 4	As per sampling inspection done
Why 5	
Root Cause (Outflow)	100% inspection not done for total length

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Training given to CNC operator for loading of parts	Kamil and Yogesh	26/05/2022		Completed
Outflow	100% inspection started for total length	Vaibhav Sirshat	26/05/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection done for total length
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Sampling inspection for total length 124_Occurance_Before.pdf
Occurance (After)	100% inspection for Total Length 124_Occurance_After.pdf
Outflow (Before)	Not available 124_Outflow_Before.jpg
Outflow (After)	Training and awareness given to inspector 124_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CNC

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	WI and C/P

13. Effectiveness Of Action

Reviewed Quantity	5000
Reason for submission	reviewed 5000 no length issue found ok