QFR No - 8000787777

Defect Details

NC No.	8000787777
NC Date	17/05/2022
NC Submission Date	
Part No.	F2BF05707M
Part Name	OUTER TUBE P/C RH (HMS-30)
Supplier Name & Code	101219-ROCKMAN INDUSTRIES
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	THREADING MISSING-HALF THREAD OBSERVED IN FENDER HOLE

1. Problem Description

Defect Description	M6 Thread missing in fender hole
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	0odo1tillahsmzo20nbc3tx5.jpg

Supplier Communication Details

Quality Head Email ID	shriknat.sharma@rockman.in
Plant Head/CEO Email ID	mlshah@rockman.in
MD Email ID	skmishra2@rockman.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	500	0	0	500	0	1000
Check Qty	500	0	0	500	0	1000
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
Immediately segregate all the stock at M/s Endurance end and M/s Rockman end also ,

3. Process Flow

Process Flow Description
Casting - Gate Cutting /Buffing - Machining - Buffing - Leakage testing - washing - Inspection - Painting - Inspection and dispatch

4. Process Details

Process / Operation	Machining process
Outsource	No
Machine / Cell	machining cell
Machine / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	dedicated machine are not in used	verified and found dedicated machined are being used fro the part	O
Method	Pat wrong load in the machine	part loading in OK condition	O
Material	wrong material used during casting	verified and found OK	O
Man	New manpower deoute	Skilled manpower used on the machining center	O
Tool	tool become worn out	verified and found tool become worn out	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Drill Length Less.
Why 2	Home position missed by machine
Why 3	Home position memory forget after some time
Why 4	
Why 5	
Root Cause (Occurance)	Home Position forget after some time

Root Cause Analysis (Outflow)

Why 1	Part skipped from final Inspection
Why 2	check point not given to Operator
Why 3	earlier there is no any check point added in the system
Why 4	
Why 5	
Root Cause (Outflow)	earlier there is no any check point added in the system

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Tapping Check as per sampling Plan Hourly monitoring at generation stage	Production	16/06/2022	15/06/2022	Completed
Occurance	Machine CMOS changed	lalit	16/06/2022	15/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Hourly monitoring started at machine shop
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)	not applicable 122_Occurance_Before.pdf
Occurance (After)	not available 122_Occurance_After.pdf
Outflow (Before)	not applicable 122_Outflow_Before.pdf
Outflow (After)	Photo attached 122_Outflow_After.bmp

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CMOS changed on all the machine

12. Document Review

Documents	
Specify Other Document	no change

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	Repeated issue observed in every month