QFR No - 8000789590

Defect Details

NC No.	8000789590
NC Date	31/05/2022
NC Submission Date	
Part No.	550LG06202
Part Name	SEAT PIPE -K23A/PRFH-006
Supplier Name & Code	100539-N P ENTERPRISES
ETL Plant	1116-ETL K-120 Suspension
Defect Details	RUN OUT MORE-RUNOUT OVERSIZE. 0.5 AGAINST 0.1 MAX

1. Problem Description

Defect Description	M8 threading runout wrt to outer dia. observed up to 0.55, 0.5 mm against drg. requirement of 0.1 mm. This concern leads to assembly movement NG as well as noise concern.
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	1700
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@npcindustries.in
Plant Head/CEO Email ID	anand@npcindustries.in
MD Email ID	ajay@npcindustries.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1700	1500	0	0	0	3200
Check Qty	15	0	0	0	0	15
NG Qty	15	0	0	0	0	15

Action taken on NG part

Scrap	0
Rework	0
Under Deviation	15

Containment Action
Segregated all parts at ETL, at Warehouse & at NPC Nabha.

3. Process Flow

Process Flow Description
1.Raw Material 2.Cutting & Chemfering 3.Multistation Draw 4.Head Formation 5.Rough Grinding 6.Punching 7.CNC Head Turning 8.CNC Boring & Facing 9.Tapping 10.Chemfering 1&2 11.Finish Grinding 12.Final Inspection 13.Cleaning 14.Oiling 15.Packing &Dispatch

4. Process Details

Process / Operation	CNC Boring & Facing
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	NPC/CNC/011

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	skipped at final inspection	it was observed that parts skipped during sampling at final inspection.	X
Man	In process operator negligent	operator was aware about the defect he found to be non negligent	O
Machine	Grinding wheel center out	Grinding wheel was not center out	O
Material	collet sleeve damage	Collet sleeve wearout	X
Machine	grinding wheel will good condition.	grinding wheel was not dress	O

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	ssp (0.65)

7. Root Cause Analysis (Occurance)

Why 1	collet sleeve was damage.
Why 2	Collet sleeve wearout during CNC boring operation
Why 3	collet sleeve was not change.
Why 4	collet sleeve was wear out before expiry
Why 5	
Root Cause (Occurance)	collet was wear out before expiry

Root Cause Analysis (Outflow)

Why 1	run out oversize.
Why 2	Could not be detected at final inspection.
Why 3	skipped at final inspection.
Why 4	Skipped in Sampling inspection.
Why 5	
Root Cause (Outflow)	Skipped in Sampling inspection.k

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Sampling plan doubled.	Mr. Gurpreet	21/06/2022	20/06/2022	Completed
Occurance	Reduce life cycle time of collet sleeve after validation.	Gursewak singh	24/06/2022	22/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	sampling plan double.
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	double

10. Evidance of Countermeasure

Occurance (Before)	collet sleeve was wear out before expiry 159_Occurance_Before.jpg
Occurance (After)	Collet sleeve is change after life time reduce (according to new validation) 159_Occurance_After.jpg
Outflow (Before)	Skipped in Sampling inspection. 159_Outflow_Before.jpg
Outflow (After)	Sampling inspection doubled 159_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CNC Machine

12. Document Review

Documents	ControlPlan, PMCheckSheet, WISOP, JHCheckSheet, ProcessFlowChart, InspCheckSheet
Specify Other Document	validation report

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	No any improvement observed in received lots.