QFR No - 8000790294

Defect Details

NC No.	8000790294
NC Date	07/06/2022
NC Submission Date	
Part No.	S1JL02405B
Part Name	PISTON ROD PLATED K0LA
Supplier Name & Code	100953-PACE AUTOPARTS PRIVATE LIMITED
ETL Plant	1136-ETL Suspension Sanand
Defect Details	LENGTH OVERSIZE-TOTAL LENGTH OVERSIZE

1. Problem Description

Defect Description	Length Over Size
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	140
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qa@paceautoparts.in
Plant Head/CEO Email ID	sudhakar.chavan@paceautoparts.in
MD Email ID	jadhav@paceautoparts.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4200	0	10000	2520	0	16720
Check Qty	4200	0	10000	2520	0	16720
NG Qty	140	0	0	0	0	140

Action taken on NG part

Scrap	0
Rework	0
Under Deviation	140

Containment Action
All quantity available at end checked for reported concern issue & no any found defective quantity.

3. Process Flow

Process Flow Description
Cutting- CNC machining-I - Rough grinding-I -Rough grinding-II - CNC machining -II - Thread rolling- I- thread rolling-II - Semi finish grinding-Finish grinding - Hard chrome plating- Superfinishing process- Final inspection - packing- Dispatch

4. Process Details

Process / Operation	Packing
Outsource	No
Machine / Cell	Packing
Machine / Cell No.	packing-I

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Improper material handling	Improper material handling	O
Method	Multiple items handled same time at packaging	Multiple items handled same time at packaging	O
Method	Similar location for items	Similar location for items	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Multiple items handled same time at packaging
Why 2	Similar locations for items
Why 3	care not to be taken during packaging
Why 4	Lack of awareness
Why 5	
Root Cause (Occurance)	operator negligence

Root Cause Analysis (Outflow)

Why 1	Lack of awareness
Why 2	Negligence
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Negligence

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	We had started the box weight 200 %& displayed the weight chart at weighing machine	Store	10/06/2022	07/06/2022	Completed
Occurance	We had implemented the one item packaging at a single time & on only line single model will be placed for final inspection also.	Final inspection	15/06/2022	10/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No any change in inspection system.
Inspection Method	Other
Other Inspection Method	200 % box weight
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100 %

10. Evidance of Countermeasure

Occurance (Before)	Box weight done 100 % at the time of dispatch & multiple items for packaging at a time 163_Occurance_Before.jpg
Occurance (After)	We have started the box weight 200 % at the time of dispatch & box weight chart displayed at weighing machine & On final inspection table single component will be checked & packed. 163_Occurance_After.jpg
Outflow (Before)	Improper material handling 163_Outflow_Before.jpg
Outflow (After)	Training given to operator regarding concern issue & proper material handling .. 163_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Horizontally deployed for all parts

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	DOC AUDIT

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Closed