QFR No - 8000790517

Defect Details

NC No.	8000790517
NC Date	08/06/2022
NC Submission Date	
Part No.	F2DZ04603B
Part Name	FORK BOLT J1A & J1D
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M38 THREADING NOT OK

1. Problem Description

Defect Description	M38 THREADING NOT OK
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	58
Is Defect Repeatative?	Yes
Defect Sketch / Photo	z00fl2pbvmq5dnlexw5yl2nz.pptx

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	100	5000	0	5000	0	10100
Check Qty	100	5000	0	5000	0	10100
NG Qty	10	0	0	0	0	10

Action taken on NG part

Scrap	10
Rework	0
Under Deviation	0

Containment Action
dot mark on head

3. Process Flow

Process Flow Description
1.RAW MATERIAL 2.CUTTING 3.BUFFING 4.DRILLING&FACING 5.TAPPING 6.CNC TURNING 7.MILLING 8.BACK FACE BUFFING&MILLING BURR REMOVE 9.SURFACE TREATMENT 10.FINAL INSPECTION

4. Process Details

Process / Operation	threading op
Outsource	No
Machine / Cell	202
Machine / Cell No.	2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	MISHANDLING OF MATERIAL	DURING TRANSPORTATION 1 PIECE FELL DOWN FROM BIN AND THREAD GOT DAMAGE	O
Method	INSPECTION METHOD NOT EFFECTIVE	CHECKED AND VALIDATED ,FOUND EFFECTIVE	X
Material	RAW MATERIAL GRADE NOT OK	CHECKED AND VALIDATED ,FOUND OK	X
Tool	ROLLING DIE WEAR	CHECKED AND VALIDATED ,FOUND OK	X
Machine	NUT AND BOLTS OF MACHINE MAY LOOSE	CHECKED AND VALIDATED FOUND PROPERLY TIGHT	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	50/1200

7. Root Cause Analysis (Occurance)

Why 1	M38 Threading not ok
Why 2	The problem occurred at transportation stage.
Why 3	During transportation 1 piece fell down from bin and thread got damage.
Why 4	Operator was new and put the N.G part along with the OK part bin.
Why 5	So One piece of thread damage got mixed with finished material .
Root Cause (Occurance)	During transportation 1 piece fell down from bin and thread got damage.

Root Cause Analysis (Outflow)

Why 1	M38 Threading not ok
Why 2	Operator was not aware about this type of defect.
Why 3	This type of problem came first time so the defected part skipped from detection.
Why 4	So final inspector was not able to detect this problem.
Why 5	So NG part dispatched to customer.
Root Cause (Outflow)	Operator was not aware about this type of defect.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Work instructions given to Operator about the defect and to handle the material with proper care.	NAVEEN	08/06/2022	07/06/2022	Completed
Outflow	Work instructions given to final inspector regarding the defect and to check the material with gauge before packing and dispatch.	UMED	08/06/2022	07/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50/1200

10. Evidance of Countermeasure

Occurance (Before)	NOT AVAILABLE 171_Occurance_Before.pdf
Occurance (After)	WORK INSTRUCTIONS 171_Occurance_After.pdf
Outflow (Before)	NOT AVAILABLE 171_Outflow_Before.pdf
Outflow (After)	WORK INSTRUCTIONS 171_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NOT APPLICABLE

12. Document Review

Documents	WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	100

Reason for submission	As discussed with local representative Mr Ambhore Raosaheb- Plan for packaging improvement and share line of action through mail