QFR No - 8000793197

Defect Details

NC No.	8000793197
NC Date	27/06/2022
NC Submission Date	
Part No.	S1GD01726B
Part Name	INNER TUBE CHAMFERED K0LA
Supplier Name & Code	100165-SAPTAGIRI INDUSTRIES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	HIGHT O/SIZE.-TOTAL LENGTH LESS&MORE

1. Problem Description

Defect Description	inner tube total length less issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	121
Is Defect Repeatative?	Yes
Defect Sketch / Photo	1aq54fznl1qpruyaavnfmmtb.xlsx

Supplier Communication Details

Quality Head Email ID	quality@saptagirigroup.in
Plant Head/CEO Email ID	production@saptagirigroup.in
MD Email ID	argandhi@saptagirigroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	2000	0	0	2000	7000
Check Qty	3000	2000	0	0	2000	7000
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action
100 % verify all material at all location and observed 02 nos NG

3. Process Flow

Process Flow Description
RM receipt & Inspection , Cutting , Chamfer at both end , Straightness inspection , Packing

4. Process Details

Process / Operation	Tube Cutting
Outsource	No
Machine / Cell	Troub machine
Machine / Cell No.	Troub machine 04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Total length checking special gauge ware out	Gauge verified by height gauge and its observed ok	O
Machine	Set up part mix up with OK material	Red bin with lock and key it's missing at the machine	O
Machine	Stopper locking loosed while tube cutting	Not loosed the stopper while tube cutting	O
Machine	End piece mix up with OK material	For storing end pieces one gunny bag available with identified	O
Method	Length checking not done adequately	Length checking done adequality	O
Man	Inspector not aware about total length	Operator and inspector nor a aware about the total length special gauge and its operating	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Total length U/s
Why 2	Set up part mix up with OK material
Why 3	Set up part storing bin missing
Why 4	No Lock & Key for storing set up or rejected parts
Why 5	
Root Cause (Occurance)	No Lock & Key for storing set up or rejected parts

Root Cause Analysis (Outflow)

Why 1	Total length U/s
Why 2	Operator not aware about total length
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Operator not aware about total length

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	) Provide Lock & key Rejection storage bin	Mr. Munja Hore	29/06/2022	30/06/2022	Completed
Occurance	) Provide the stopper slot on chamfer machine	Mr. Munja Hore	29/06/2022	30/06/2022	Completed
Occurance	) Make SOP for Tube Cutting operation & its verification	Mr. Munja Hore	29/06/2022	30/06/2022	Completed
Outflow	Verify Gauge Length. Started 100% inspection for length verification.	Mr. Munja Hore	29/08/2022	30/06/2022	Completed
Outflow	Awareness Training given to concern operator & Inspector	Mr. Munja hore	29/08/2022	30/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % inspection started by special total length gauge
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)	Set part storage bin missing (Not available at machine) , no lock & key equipment for keeping rejection or set up piece 190_Occurance_Before.pdf
Occurance (After)	Provided lock & key equipment for keeping rejection or set up piece 190_Occurance_After.pdf
Outflow (Before)	Inspector not aware about total length and checking method 190_Outflow_Before.pdf
Outflow (After)	Awareness training given to concern inspector & OPL display at work place , Made SOP for length checking gauge and same awareness given 190_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Other machine operator and inspector

12. Document Review

Documents	ControlPlan
Specify Other Document	Control plan

13. Effectiveness Of Action

Reviewed Quantity	12600
Reason for submission	Effectiveness monitored 4 lots and no defect repeated