QFR No - 8000795258

Defect Details

NC No.	8000795258
NC Date	14/07/2022
NC Submission Date	
Part No.	F1BF04316M
Part Name	OUTER TUBE BUFF LH- K0LA DRUM
Supplier Name & Code	100001-ANANT ENTERPRISES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	DIAMETER OVER SIZE-OIL SEAL AND DUBUSH DIA OVER SIZE

1. Problem Description

Defect Description	KOPG front fork 2 numbers leakage in dry air leak test in line because of bottom case oil seal diameter ,Du bush diameter over size repeated issue
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	2
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	anandkulkarni@anantgroup.co.in
Plant Head/CEO Email ID	pramodgosavi@anantgroup.co.in
MD Email ID	ashwinjoshi@anantgroup.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	0	0	1000	0	3000
Check Qty	2000	0	0	1000	0	3000
NG Qty	1	0	0	3	0	4

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
100 % SAGRIGATION & DOT IDENTIFICATION ON OIL SEAL ID.

3. Process Flow

Process Flow Description
VMC 01 (OP10) -BTA (OP20) - LEAKAGE -VISUAL-BUFFING-PACKIN & DISPATCH

4. Process Details

Process / Operation	VMC 01(OP-10) 1ST UP
Outsource	No
Machine / Cell	VMC 01 (OP10)
Machine / Cell No.	VMC 01 (OP10)

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	BURR CHIP STICK ON ADAPTOR	VISUAL	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	8 / HOUR

7. Root Cause Analysis (Occurance)

Why 1	TOOL RUNOUT MORE
Why 2	BURR STICK ON TOOL ADAPTOR DUE TO THAT TOOL RUNOUT MORE AT TIME OF MACHINING
Why 3	TOOL ADAPTOR PROTECTIVE CAP WORN OUT .
Why 4	
Why 5	
Root Cause (Occurance)	BURR STICK ON TOOL ADAPTOR.

Root Cause Analysis (Outflow)

Why 1	TOOL ADAPTOR CAP CHECK POINT NOT ADDRESED IN PREVENTIVE CHECK SHEET.
Why 2	NO AWARENESS ABOUT THIS TYPE OF NG POSSIBILITY.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	TOOL ADAPTOR CAP CHECK POINT NOT ADDRESED IN PREVENTIVE CHECK SHEET.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	AWARENESS & TRAINING RECORD	BHAGYESH KHAIRNAR	22/07/2022	22/07/2022	Completed
Occurance	PREVENTIVE MAINTAINANCE CHECK SHEET UPDATE	MALLAPA DALAVI	22/07/2022	22/07/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	AIR PLUG GAUGE
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	8/ HOUR

10. Evidance of Countermeasure

Occurance (Before)	PROCESS IMPROVEMENT 199_Occurance_Before.xls
Occurance (After)	PROCESS IMPROVEMENT 199_Occurance_After.xls
Outflow (Before)	PM CHECK SHEET 199_Outflow_Before.xlsx
Outflow (After)	PM CHECK SHEET 199_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	KONA BOTTOM CASE

12. Document Review

Documents	PMCheckSheet
Specify Other Document	PROCESS IMPROVEMENT

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	reviewed 2000 numbers found ok