QFR No - 8000795960

Defect Details

NC No.	8000795960
NC Date	18/07/2022
NC Submission Date	
Part No.	F2KH02002B
Part Name	REBOUND SPRING -K74A
Supplier Name & Code	101159-TECHNOMAT SPRINGS
ETL Plant	1116-ETL K-120 Suspension
Defect Details	DIAMETER OVER SIZE-OUTER DIA. OVERSIZE.

1. Problem Description

Defect Description	In K74 Rebound spring (F2KH02002B) observed wtih outer dia. oversize concern. OD oversize by 0.2 to 0.3 mm.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	10053
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@technomatsprings.com
Plant Head/CEO Email ID	technomatsprings@gmail.com
MD Email ID	patilsadanand@technomatsprings.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	15000	0	0	0	1200	16200
Check Qty	15000	0	0	0	1200	16200
NG Qty	10053	0	0	0	0	10053

Action taken on NG part

Scrap	10053
Rework	0
Under Deviation	0

Containment Action
Check all material in house & customer end

3. Process Flow

Process Flow Description
RM>Coiling>B1>Grinding>shotpeening>B2>setting>visual inspection>oiling>Packing>Dispatch

4. Process Details

Process / Operation	Coiling
Outsource	No
Machine / Cell	CNC Coiling
Machine / Cell No.	Na

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator	Skill evaluation done (Training to be provided	X
Material	As per Drawing	RMTC checked found ok	O
Tool	Improper Tool Use	Check found ok	O
Machine	Coiling Machine	Found Ok	O
Method	Improper Material handling	Material handling done as per process verified found ok	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	1000

7. Root Cause Analysis (Occurance)

Why 1	OD Over Size
Why 2	Found OD over size 0.20 - 0.30 mm
Why 3	Finger tool loose.
Why 4	
Why 5	
Root Cause (Occurance)	Finger tool loose

Root Cause Analysis (Outflow)

Why 1	OD Over size
Why 2	OD checking not done
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	OD Checking not done

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	OD Checking Start and training provide to visual inspection & Final inspection operator	Mrs.Renuka	10/08/2022	02/08/2022	Completed
Occurance	Training Provide to CNC operator.	Mr.Santosh	02/08/2022	03/08/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	OD Checking Start
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1000/20

10. Evidance of Countermeasure

Occurance (Before)	OD Checking Frequency four hourly. 204_Occurance_Before.jpg
Occurance (After)	OD Checking frequency change hourly basis & training provide to operator. 204_Occurance_After.jpg
Outflow (Before)	OD checking not done at final inspection. 204_Outflow_Before.pdf
Outflow (After)	OD checking start before dispatch. 204_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Rebound Spring

12. Document Review

Documents	InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1500
Reason for submission	Sustenance required.