QFR No - 8000798536

Defect Details

NC No.	8000798536
NC Date	04/08/2022
NC Submission Date	
Part No.	3630001833
Part Name	M/C HANDLE BAR BODY 3W (24151274) BAJAJ
Supplier Name & Code	100202-G P AUTO COMPONENTS
ETL Plant	1102-ETL L-6 Die Casting
Defect Details	TAPPING O/SIZE.-M4 TAPPING OVERSIZE

1. Problem Description

Defect Description	Speedometer Cover M4 Tapping oversize
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	180
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@advantechgroup.co.in
Plant Head/CEO Email ID	advantechengg@rediffmail.com
MD Email ID	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	500	200	3700
Check Qty	3000	0	0	500	200	3700
NG Qty	180	0	0	0	0	180

Action taken on NG part

Scrap	180
Rework	0
Under Deviation	0

Containment Action
100% inspection done with Minor diameter pin

3. Process Flow

Process Flow Description
incoming inspection>OP-10(Face cut & ø 28 hole)>OP-20 (21.8Remer) > OP30 (Speedometer drilling)>OP40(M4 Tapping)> OP50 (Spot face Outside)> OP-60(Spot Face inside face)>OP70(10.5 reamer)> OP80 (Switch hole RH side drilling)> OP90 (Switch hole LH side Drilling)> OP100(Switch Hole Tapping)> OP110(Final inspection)

4. Process Details

Process / Operation	OP30 (Speedometer drilling)
Outsource	No
Machine / Cell	SPM-03
Machine / Cell No.	SPM-03

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Wrong loading	OK	O
Man	New man Power	Skilled manpoer- Suirvanshi	O
Material	Wrong chemical composition	Chemsitry Found ok	O
Machine	Spindle run ok	Run out observed up to 8 micron	O
Tool	Drilling tapp damage	Drill tap found damage	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	5 part

7. Root Cause Analysis (Occurance)

Why 1	m4 tapping over size(minor diameter not ok)
Why 2	drill hole over size
Why 3	ø3.6 drill burn out
Why 4	unsufficient coolant flow
Why 5	Coolant Flow nozzle jam.
Root Cause (Occurance)	Coolant Flow nozzle jam

Root Cause Analysis (Outflow)

Why 1	m4 tapping over size(minor diameter not ok)
Why 2	Part Not arrest on stage
Why 3	inspection on sampling base at final inspection table only
Why 4	
Why 5	
Root Cause (Outflow)	Minor diameter not check during inprocess, only doing at final inspection on sampling base

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Coolant flow nozzle change & checking frequency added in JH check sheet	Mr. Suryavanshi	20/08/2022		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	minor diameter inspection added in in process & 100% at final stage
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)	Coolant nozzle jam 223_Occurance_Before.png
Occurance (After)	Coolant nozzle cleaned 223_Occurance_After.png
Outflow (Before)	Core pin gauge check point not add in Inprocess inspection report 223_Outflow_Before.jpg
Outflow (After)	Core pin gauge check point added in Inprocess inspection report 223_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Drilling SPM / Excellent Machine Tool / G P Auto

12. Document Review

Documents	InspCheckSheet
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	