QFR No - 8000798549

Defect Details

NC No.	8000798549
NC Date	04/08/2022
NC Submission Date	
Part No.	520MD19002
Part Name	COMPRESSION SPRING (4 PLATE VAVE)
Supplier Name & Code	100952-STUMPP SCHUELE AND SOMAPPA SPR
ETL Plant	1135-ETL 7/10 P Nagar
Defect Details	LENGTH OVERSIZE-

1. Problem Description

Defect Description	Length o/s & u/s issue
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	10
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	hravikumar@ssssprings.com
Plant Head/CEO Email ID	sreenivasulu.k@ssssprings.com
MD Email ID	rln@ssssprings.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	2000	0	5000
Check Qty	3000	0	0	2000	0	5000
NG Qty	10	0	0	0	0	10

Action taken on NG part

Scrap	10
Rework	0
Under Deviation	0

Containment Action
After Receipt a complaint 100 % inspection done found ok

3. Process Flow

Process Flow Description

Coiling - Tempering-Grinding-Shot Peening - Setting-Inspection-Paint identification-Oiling-Packing

4. Process Details

Process / Operation	Inspection
Outsource	Yes
Machine / Cell	Clutch Cell
Machine / Cell No.	Clutch Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Full Tolerance used for gauge	Yes	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	Without Setting spring
Why 2	Spring Setting Operation skip
Why 3	Spring fall down during loading
Why 4	
Why 5	
Root Cause (Occurance)	Fall down spring out into Output of setting Bins

Root Cause Analysis (Outflow)

Why 1	length gauge Horizontal type
Why 2	100% Tolerance used in gauge
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	100% Tolerance used in gauge for Length Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	75% Tolerance used in gauge	Mr. Shivkumar Fartade	29/08/2022	28/08/2022	Completed
Occurance	Fall down spring out into yellow bins	Raghu Kanike	29/08/2022	28/08/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	75% Tolerance used in gauge
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	0100

10. Evidance of Countermeasure

Occurance (Before)	Spring fall down during loading and kept into Ok Bins 221_Occurance_Before.pdf
Occurance (After)	Fall down spring will be put into yellow bins- 221_Occurance_After.pdf
Outflow (Before)	100% Tolerance used in gauge 221_Outflow_Before.pdf
Outflow (After)	75% Tolerance used in gauge 221_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Yes

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK