QFR No - 8000799248

Defect Details

NC No.	8000799248
NC Date	09/08/2022
NC Submission Date	
Part No.	520DZ00212
Part Name	FORK BOLT K60-(DS181012)
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1126-ETL Pantnagar
Defect Details	THREADING NOT OK-CHIPS IN M10 THREAD

1. Problem Description

Defect Description	Chips in M10 thread
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	50
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1400	2000	0	0	1500	4900
Check Qty	1400	2000	0	0	1500	4900
NG Qty	500	0	0	0	0	500

Action taken on NG part

Scrap	0
Rework	500
Under Deviation	0

Containment Action
100 % gauge inspection done at warehouse and supplier end.

3. Process Flow

Process Flow Description
1. RM INSPECTION. 2. CNC TURNING 3. TAPPING 4. RETAPPING 5. THREAD ROLLING 6. PLATING. FINAL INSPECTION 7. PACKING

4. Process Details

Process / Operation	TAPPING
Outsource	No
Machine / Cell	TAPPING MACHINE
Machine / Cell No.	2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	tool wear	checked and validated tool life is effective	O
Material	material was not of required grade and size	checked and validated that material was of same grade and size	O
Machine	machine is not in good condition	checked and found machine is in good working condition	O
Method	Chips stuck in I.D during tapping process	validated and found I.D was not clear	X
Man	unskilled labour	checked and validated operator was skilled	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50/1200

7. Root Cause Analysis (Occurance)

Why 1	Go gauge not qualify in M10 Thread
Why 2	Chips were formed in M10 I.D during Tapping process and not removed
Why 3	Chips were fold and stuck in M10 I.D and were not visible
Why 4	
Why 5	
Root Cause (Occurance)	Chips were formed in M10 I.D during Tapping process and not removed. Chips were fold and stuck in M10 I.D and were not visible.

Root Cause Analysis (Outflow)

Why 1	Go gauge not qualify in M10 Thread
Why 2	Defected Part not detected in final inspection stage
Why 3	Inspection was done according to sample plan
Why 4	Defected parts skipped from inspection
Why 5	Inspection was done according to sample plan
Root Cause (Outflow)	Inspection was done according to sample plan

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Additional process of Re -tapping check added in control plan	Ganesh Maurya	19/08/2022	19/08/2022	Completed
Outflow	100% Retapping check done after Plating process to prevent the defect	Naveen	19/08/2022	19/08/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Additional process of 100% Retapping check added
Inspection Method	Other
Other Inspection Method	Retapping check m/c
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50/1200

10. Evidance of Countermeasure

Occurance (Before)	NOT AVAILABLE 224_Occurance_Before.pdf
Occurance (After)	ADDITONAL PROCESS OF RETAPPING CHECK ADDED IN CONTROL PLAN 224_Occurance_After.pdf
Outflow (Before)	NOT AVAILABLE 224_Outflow_Before.pdf
Outflow (After)	100% RETAPPING CHECK DONE TO PREVENT THE DEFECT 224_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NOT APPLICABLE

12. Document Review

Documents	ControlPlan
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	Do correction in why-why analysis