QFR No - 8000804715

Defect Details

NC No.	8000804715
NC Date	19/09/2022
NC Submission Date	
Part No.	165FG01101
Part Name	GEAR PRIMARY ASSLY 3W-4S 200 cc LPG
Supplier Name & Code	100237-SANJEEV AUTO PARTS MRFS PVT LT
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	DIAMETER OVER SIZE-DIA 35.5-0.009/-0.034 OVER SIZE

1. Problem Description

Defect Description	DIAMETER FOUND OVER SIZE (DIM 35.5-0.009/-0.034 FOUND UPTO 35.550~35.70 MM)
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	36
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	vpwankhade@sanjeevgroup.com
Plant Head/CEO Email ID	rmtiwari@sanjeevgroup.com
MD Email ID	maithilee@sanjeevgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	500	0	0	0	0	500
Check Qty	500	0	0	0	0	500
NG Qty	10	0	0	0	0	10

Action taken on NG part

Scrap	0
Rework	10
Under Deviation	0

Containment Action
Segregated All parts at ETL end.

3. Process Flow

Process Flow Description
RM Inward-bar cutting-billet cutting-hot forging-normalizing-shotblasting-coining-preturning-peircing-1peircing-2shaving-1-shaving-2milling-1-milling-2-finish turning 1st setup-finish turning-2set up-deburring--final inspection CNC blanks-Inward inspection cnc blank-tracibility marking-hobbing-teeth chamfering-gear shaving-heat treatment-shotblasting-id turning-bush pressing-bush turning-washing-Final Inspection

4. Process Details

Process / Operation	Hard Turning
Outsource	No
Machine / Cell	CNC Jobber 03
Machine / Cell No.	CNC Jobber 03

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Tool Worn Out	Insert Worn out as it is Hard Turning Process, Tool Wear Pattern Is High.	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	Why OD Oversize In Part
Why 2	less Material got Removed From Part than expected in process
Why 3	Insert Worn out
Why 4	Insert Life was less than expected
Why 5	
Root Cause (Occurance)	Insert Life was less that expected

Root Cause Analysis (Outflow)

Why 1	Why Defectives Skipped From Inspection
Why 2	Material Mixed Up
Why 3	New Manpower deployed
Why 4	Manpower needs training on Rejection Handling
Why 5	
Root Cause (Outflow)	New Manpower, needs training on Rejection Handling

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Tool Life monitoring started, Tool Verification by Supervisor Started	Sandip Lahane	02/10/2022	02/10/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % Inspection On Air Gauge with Paint Marking for Confirmation.
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)	No Tool Life Monitoring 256_Occurance_Before.xlsx
Occurance (After)	Tool Life Monitoring Started 256_Occurance_After.xlsx
Outflow (Before)	No Tool Inspection Point In Hourly Inspection Report 256_Outflow_Before.xlsx
Outflow (After)	HIPR Updated 256_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Machine, ALL GPH Parts

12. Document Review

Documents	ControlPlan, WISOP, InspCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	POKA-YOKE to be implement at process side (Air Gauge inspection interlocked with Machine cycle)