QFR No - 8000807222

Defect Details

NC No.	8000807222
NC Date	08/10/2022
NC Submission Date	
Part No.	550DZ05202
Part Name	FORK BOLT :PRFH-006
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1116-ETL K-120 Suspension
Defect Details	DIMN.O/SIZE.-DIM 3.2 OVERSIZE

1. Problem Description

Defect Description	Groove width oversize concern observed. After allowing segregation 620 nos. observed not OK.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	620
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qualityassurance@sangkaj.com
Plant Head/CEO Email ID	steel@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5000	0	0	1000	1500	7500
Check Qty	5000	0	0	1000	1500	7500
NG Qty	620	0	0	0	0	620

Action taken on NG part

Scrap	620
Rework	0
Under Deviation	0

Containment Action
Suspected qty verified at customer end and In-house.

3. Process Flow

Process Flow Description
Inward Inspection > Cold Draw > Straightning > Traube > Deburring > Grinding > CNC Turn > Tapping > Thread Rolling > Plating > Final Inspection

4. Process Details

Process / Operation	CNC
Outsource	No
Machine / Cell	CNC cell
Machine / Cell No.	25

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Vibrations in tool Holder	Tool holder found loose	X

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5%

7. Root Cause Analysis (Occurance)

Why 1	Groove Dimension o/s
Why 2	Insert viable while machining
Why 3	Insert not tighten properly
Why 4	Insert holder pocket found wear out
Why 5	
Root Cause (Occurance)	Insert holder pocket found wear out

Root Cause Analysis (Outflow)

Why 1	NG Piece not traced in sampling basis
Why 2	sampling frequency found less
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	sampling frequency at FID found less

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Tool holder chnaged	Mr. Raut Sir	10/10/2022		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling frequency increased to 10 %
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10%

10. Evidance of Countermeasure

Occurance (Before)	Insert holder pocket found wear out 278_Occurance_Before.pptx
Occurance (After)	Tool holder chnaged 278_Occurance_After.pptx
Outflow (Before)	sampling frequency at FID found less 278_Outflow_Before.jpeg
Outflow (After)	Sampling frequency increased to 10 % 278_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	CNC

12. Document Review

Documents	InspCheckSheet
Specify Other Document	FID Checksheet

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	