QFR No - 8000808535

Defect Details

NC No.	8000808535
NC Date	19/10/2022
NC Submission Date	
Part No.	550LG06202
Part Name	SEAT PIPE -K23A/PRFH-006
Supplier Name & Code	100929-HARSHAD ENGINEERING COMPANY
ETL Plant	1116-ETL K-120 Suspension
Defect Details	DIMN.O/SIZE.-GROOVE WIDTH OVERSIZE

1. Problem Description

Defect Description	In PRFH Seat pipe - Groove width observed oversize. (No-go gauge qualifies.)
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	1021
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qaharshad@miteshauto.com
Plant Head/CEO Email ID	sjkadam@miteshauto.com
MD Email ID	auto.mitesh@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	6400	5800	0	8800	9600	30600
Check Qty	6400	5800	0	8800	9600	30600
NG Qty	1011	59	0	117	21	1208

Action taken on NG part

Scrap	0
Rework	0
Under Deviation	1208

Containment Action
100 % sorting done for ETL End, HEC WIP & FG material

3. Process Flow

Process Flow Description
Cutting-Draw-Forging(Head Formation)-Rough Grinding-CNC (Head, Boring & Tapping)-Punching-Finish Grinding-Final Inspection-Packing-Dispatch

4. Process Details

Process / Operation	CNC Head Turning
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	CNC 1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	In CNC Programm Groove width set to higher side	In CNC Programm Groove width observed higher side at the time of insert change	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	IS2500

7. Root Cause Analysis (Occurance)

Why 1	Groove width found oversize
Why 2	At the time of insert change, 80 to 90 nos found light NOGO enters due to entry chamfer.
Why 3	In CNC programm groove width set to higher side.
Why 4	To avoid Gr. Width undersize fitment issue.
Why 5	To avoid Gr. Width undersize fitment issue. (entry chamfer minor excess observed in said lot)
Root Cause (Occurance)	To avoid Gr. Width undersize fitment issue. (entry chamfer minor excess observed in said lot)

Root Cause Analysis (Outflow)

Why 1	Groove width found oversize
Why 2	Part skip in FI
Why 3	100% check not done
Why 4	Sampling done/Inspection method not adequete
Why 5	
Root Cause (Outflow)	Sampling done/Inspection method not adequete

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	In CNC programe correction done and width size maintained at mean side and radius at entry point corrected to prevent the over size concern.	D.D. Jopale	19/10/2022		Completed
Outflow	Groove width 100% check just before packing to avoid NG part mix-up in lot.	Vaibhav Shirsath	18/10/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Groove width 100% check
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)	In CNC Program Groove width maintain at higher side 286_Occurance_Before.jpg
Occurance (After)	In CNC Program Groove width maintain at Mean 286_Occurance_After.jpg
Outflow (Before)	Groove width checked on Sampling basis 286_Outflow_Before.jpg
Outflow (After)	100% insp. to be done for Groove width 286_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CNC Machines

12. Document Review

Documents	
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Effectiveness observed.