QFR No - 8000811623

Defect Details

NC No.	8000811623
NC Date	22/11/2022
NC Submission Date	
Part No.	F2DZ09002B
Part Name	FORK BOLT -K17E
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M6 NO-GO PASS

1. Problem Description

Defect Description	M6 No-Go Pass in fork bolt
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	310
Is Defect Repeatative?	Yes
Defect Sketch / Photo	zm1kgsmvtm0a3zv0hsp4bmvd.pptx

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	310	0	0	500	1000	1810
Check Qty	310	0	0	500	1000	1810
NG Qty	5	0	0	0	0	5

Action taken on NG part

Scrap	5
Rework	0
Under Deviation	0

Containment Action
Lot booked after found 5 nos NG at inward end, also re-verified the in-house stock.

3. Process Flow

Process Flow Description
Inward Inspection > Forging blank > CNC 1ST > CNC 2nd > Drilling > Tapping > Rolling > Plating > Final Inspection

4. Process Details

Process / Operation	Drilling
Outsource	No
Machine / Cell	Tapping
Machine / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Collet Wear out	Drill fitment issue	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Sampling basis (DV)
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 OUT 100

7. Root Cause Analysis (Occurance)

Why 1	Drill ID O/S
Why 2	Drill Overhanging
Why 3	Play in collet
Why 4	Collet wear out
Why 5	
Root Cause (Occurance)	Collet wear out found

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
	Collet replaced with new one having close clamping				

Occurance	having facility of clamp more area of drill bit. so that overhanging possibility get eliminate	Mr. Raut Sir	24/11/2022	23/11/2022	Completed

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)	Collet Wear Out drill bit overhanging due to clamping area less. 312_Occurance_Before.pptx
Occurance (After)	Collet replaced with new one having close clamping having facility of clamp more area of drill bit. so that overhanging possibility get eliminate. 312_Occurance_After.pptx
Outflow (Before)	5 % Inspection from lot 312_Outflow_Before.jpeg
Outflow (After)	10 % Inspection from lot 312_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Drilling M/c

12. Document Review

Documents	InspCheckSheet
Specify Other Document	FID Checksheet

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Kindly maintain the same in further production.