QFR No - 8000813650

Defect Details

NC No.	8000813650
NC Date	09/12/2022
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	330
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	1000	0	0	1000	1000	3000
Check Qty	330	0	0	1000	1000	2330
NG Qty	30	0	0	0	0	30

Action taken on NG part

Scrap	30
Rework	0
Under Deviation	0

Containment Action
Lot booked after found 30 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.	2

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 (DVC)
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10 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 not effective
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	sampling frequency at FID found not effective (10%)

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	12/12/2022	10/12/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Checking frequency increased to 100 %
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Collet Wear Out drill bit overhanging due to clamping area less. 318_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. 318_Occurance_After.pptx
Outflow (Before)	sampling frequency at FID found not effective (10%) 318_Outflow_Before.jpeg
Outflow (After)	100 % Inspection Lot 318_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Drilling Machine 1 & 2

12. Document Review

Documents	InspCheckSheet
Specify Other Document	FID Checksheet

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Next 3 lot checked and found ok