QFR No - 8000814130

Defect Details

NC No.	8000814130
NC Date	14/12/2022
NC Submission Date	
Part No.	550PC09107
Part Name	UNDER BKT M/C (CT100)
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-STEERING SHAFT SITTING ID UNDERSIZE

1. Problem Description

Defect Description	Under bracket, steering shaft inserting id found undersize
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	643
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	samadhan@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	800	0	0	200	0	1000
Check Qty	800	0	0	200	0	1000
NG Qty	643	0	0	0	0	643

Action taken on NG part

Scrap	0
Rework	643
Under Deviation	0

Containment Action
100% inspection of Pipe line material.

3. Process Flow

Process Flow Description
Forging inward --- Pre-drilling ---- VMC 1St setup ---- VMC 2nd setup ---- VMC 3rd Setup ---- VMC 4th setup ----Final Inspection

4. Process Details

Process / Operation	VMC 1st Setup
Outsource	No
Machine / Cell	VMC machine
Machine / Cell No.	Cell no. 4

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Tool Worn Out	Tool life monitoring not done	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Centre Bore ID Undersize
Why 2	Premature Failure Of Insert (Tool)
Why 3	Insert (Tool) Get Wear Out
Why 4	Insert (Tool) life not Monitoring
Why 5	Insert (Tool) life Not Define.
Root Cause (Occurance)	Insert (Tool) life Not Define.

Root Cause Analysis (Outflow)

Why 1	Centre Bore ID Undersize
Why 2	Not Capture in Final Inspection
Why 3	0.010 mm Dial Bore Gauge used for Final Inspection
Why 4	No Air gauge Used For Final Inspection
Why 5	No Air gauge Used For Final Inspection
Root Cause (Outflow)	No Air gauge Used For Final Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Insert (Tool) life Not Define.	Mr.Dhage	28/12/2022	29/12/2022	Completed

Outflow	No Air gauge Used For Final Inspection	Mr.Pramod Waikos	15/01/2023	18/01/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Air Plug Gauge is used for ID inspection.
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)	Photo Not Available 321_Occurance_Before.png
Occurance (After)	Tool life format 321_Occurance_After.jpeg
Outflow (Before)	Bore Gauge is used to inspect the part. 321_Outflow_Before.png
Outflow (After)	Air gauge is used to inspect the part. 321_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CT100, Caliber

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	Work Instruction

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Verified and found ok next lot