QFR No - 8000817072

Defect Details

NC No.	8000817072
NC Date	13/01/2023
NC Submission Date	
Part No.	520LG03002
Part Name	SEAT PIPE (K3)
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-BURR BACK SIDE OF DF HOLE (INNER SIDE)

1. Problem Description

Defect Description	Burr found inside the seat pipe ID (Back side of the DF Hole), causing fitment issue during assembly
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	75
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1200	600	0	0	0	1800
Check Qty	1200	600	0	0	0	1800
NG Qty	75	2	0	0	0	77

Action taken on NG part

Scrap	75
Rework	2
Under Deviation	0

Containment Action
100 % SEGRATION DONE ON MATERIAL LYING AT VARIOUS STAGES AND MARKING TOBE DONE.

3. Process Flow

Process Flow Description
1.R.M INSPECTION 2.HEAD FORGING 3.PUNCHING-1 4.ROUGH GRINDING 5.CNC-1 6.CNC-2 7.COUNTER 8.PUNCHING-II 9. I.D CHIPS REMOVE 10.REAMING (IF NECESSARY) 11.TAPPING 12. FINAL GRINDING 13.CLEANING 14.FINAL INSPECTION 15.PACKING

4. Process Details

Process / Operation	I.D BURR REMOVING
Outsource	No
Machine / Cell	DRILL
Machine / Cell No.	DRILL05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	UNSKILLED OPERATOR	VALIDATED AND FOUND OK	X
Tool	DRILL MAY WEAR	VALIDATED AND FOUND OK	X
Material	RM GRADE NOT OK	VALIDATED AND FOUND OK	X
Machine	NUT BOLTS MAY LOOSE	VALIDATED AND FOUND OK	X
Method	BURR MAY FOLD IN I.D	Burr formed during punching operation and stuck in I.D and not visible. It comes out during filing	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	5 PCS/HOUR

7. Root Cause Analysis (Occurance)

Why 1	Heavy burr found back side of the DF hole.
Why 2	Burr formed during punching operation
Why 3	It stuck in I.D and not visible
Why 4	It comes out during filing and pin operation and rise in I.D
Why 5	
Root Cause (Occurance)	Burr formed during punching operation and stuck in I.D and not visible. It comes out during filing and pin operation and rise in I.D.

Root Cause Analysis (Outflow)

Why 1	Inspection plan was not effective.
Why 2	NG part skipped from detection
Why 3	So NG part dispatched to customer
Why 4	
Why 5	

Root Cause (Outflow)	Inspection plan was not effective. NG part skipped from detection .So NG part dispatched to customer

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Inspection frequency changed to 100% at final inspection	Ganesh Maurya	19/01/2023	19/01/2023	Completed
Occurance	1- WORK INSTRUCTIONS GIVEN TO OPERATOR AND INSPECTOR REGARDING THE DEFECT OF BURR IN I.D 2. WE STARTED 100% DIA 15.10 mm PIN APPLIED IN I.D TO REMOVE THE BURR.	Ganesh Maurya	19/01/2023	19/01/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	WE STARTED 100% DIA 18.10 mm PIN APPLIED IN I.D TO REMOVE THE BURR.
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)	NO PIN APPLICATION 329_Occurance_Before.jpeg
Occurance (After)	PIN APPLIED 329_Occurance_After.jpeg
Outflow (Before)	INSPECTION WAS ACC TO SAMPLING 329_Outflow_Before.jpeg
Outflow (After)	SAMPLING PLAN CHANGED TO 100% 329_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All seat pipes

12. Document Review

Documents	ControlPlan
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	Ensure 100% inspection with insert pin as per commitment