QFR No - 8000817429

Defect Details

NC No.	8000817429
NC Date	18/01/2023
NC Submission Date	
Part No.	F2DZ09002B
Part Name	FORK BOLT -K17E
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M26 GAUGE AND MATING PART NOT QUALIFY

1. Problem Description

Defect Description	fork bolt threads not qualify to mating part- threads found damage marks
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	240
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	1600	0	0	0	0	1600
Check Qty	1600	0	0	0	0	1600
NG Qty	810	0	0	0	0	810

Action taken on NG part

Scrap	0
Rework	810
Under Deviation	0

Containment Action
100 % MATING PART INSPECTION DONE AT ALL THE MATERIAL LYING AT VARIOUS STAGES.

3. Process Flow

1. RM 2. PART OFF 3. PUNCHING 4. DRILLING+COUNTER 5. TAPPING 6. CNC TURNING 7. FINAL INSPECTION 8. PACKING AND DISPATCH (ROHTAK TO AURANGABAD) 8. SURFACE TREATMENT 9. FINAL SORTING 10. PACKING AND DISPATCH (WAREHOUSE TO ETL)

4. Process Details

Process / Operation	TRANSPORTATION (ROHTAK TO AURANGABAD)
Outsource	No
Machine / Cell	TRANSPORTATION
Machine / Cell No.	TRANSPORTATION

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	INSPECTION PLAN NOT EFFECTIVE	VALIDATED AND FOUND OK	X
Tool	ROLLING DIE WEAR	VALIDATED AND FOUND OK	X
Machine	NUT BOLTS MAY LOOSE	VALIDATED AND FOUND OK	X
Man	MISHANDLING OF MATERIAL	DURING TRANSPORTATION THREAD OF PART WAS NOT PROPERLY COVERED AND THREAD GOT DAMAGE OF SOME PIECES	O
Material	RM SIZE AND GRADE NOT OK	VALIDATED AND FOUND OK	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	ACC PLAN

7. Root Cause Analysis (Occurance)

Why 1	M26 THREAD NOT OK.
Why 2	DURING TRANSPORTATION FROM ROHTAK TO WAREHOUSE THREAD GOT DAMAGE.
Why 3	THREAD WERE NOT PROPERLY COVERED IN PACKING.
Why 4	SO THREAD GOT DAMAGE.
Why 5	
Root Cause (Occurance)	DURING TRANSPORTATION FROM ROHTAK TO WAREHOUSE THREAD GOT DAMAGE.THREAD WERE NOT PROPERLY COVERED IN PACKING.SO THREAD GOT DAMAGE.

Root Cause Analysis (Outflow)

Why 1	M26 THREAD NOT OK
Why 2	TRANSPORT FACILITY WAS FIRST SHARED WITH OTHER COMPANIES.
Why 3	DURING TRANSPORTATION HANDLING OF MATERIAL WAS NOT EFFECTIVE .
Why 4	SO NG PART DISPATCHED TO CUSTOMER.
Why 5	

Root Cause (Outflow)	TRANSPORT FACILITY WAS FIRST SHARED WITH OTHER COMPANIES.DURING TRANSPORTATION HANDLING OF MATERIAL WAS NOT EFFECTIVE .SO NG PART DISPATCHED TO CUSTOMER.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	TRANSPORTATION FACILITY CHANGED. NOW OUR MATERIAL WILL BE DISPATCHED DIRECTLY FROM ROHTAK TO WAREHOUSE WITH SINGLE TRANSPORT TO AVOID THE MISHANDLING OF MATERIAL.	GANESH MAURYA	30/01/2023	31/01/2023	Completed
Occurance	THREADS WERE PROPERLY COVERED WITH CAP AND PROPER BOX USED FOR PACKING TO AVOID THE CONTACT OF MATERIAL WITH EACH OTHER	GANESH MAURYA	30/01/2023	31/01/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NO CHANGE
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	ACC. PLAN

10. Evidence of Countermeasure

Occurance (Before)	THREAD WERE NOT COVERED IN PACKING 338_Occurance_Before.pdf
Occurance (After)	THREADS WERE COVERED PROPERLY WITH CAP 338_Occurance_After.pdf
Outflow (Before)	TRANSPORTATION MATERIAL HANDLING WAS NOT EFFECTIVE 338_Outflow_Before.pdf
Outflow (After)	TRANSPORT FACILITY CHANGED. 338_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	ALL FORK BOLTS

12. Document Review

Documents	PackingStd
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Next lot verified and found ok