QFR No - 8000818250

Defect Details

NC No.	8000818250
NC Date	24/01/2023
NC Submission Date	
Part No.	F2DZ04603B
Part Name	FORK BOLT J1A & J1D
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-THREAD M38 GO GAUGE & MATING PART NOT QU

1. Problem Description

Defect Description	M38 Threading found damage marks and not qualifying to mating part
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1600
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	2000	0	0	0	0	2000
Check Qty	2000	0	0	0	0	2000
NG Qty	1600	0	0	0	0	1600

Action taken on NG part

Scrap	0
Rework	1600
Under Deviation	0

Containment Action
100% GAUGE INSPECTION DONE ON THE MATERIAL LYING AT VARIOUS STAGES

3. Process Flow

Process Flow Description
1.RM 2. CUTTING 3. O.D CLG 4. DRILLING+FACING 5. TAPPING 6. RE-TAPPING CHECK 7. CNC TURNING 8. BACK FACE BUFFING+MILLING BURR REMOVE 10. FINAL INSPECTION 11. PACKING AND DISPATCH(ROHTAK TO WAREHOUSE AURANGABAD) 12. SURFACE TREATMENT 13.FINAL SORTING 14.PACKING AND DISPATCH (WAREHOUSE TO ETL)

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	RM SIZE AND GRADE NOT OK	VALIDATED AND FOUND OK	X
Machine	NUT BOLTS MAY LOOSE	VALIDATED AND FOUND OK	X
Method	INSPECTION METHOD NOT EFFECTIVE	VALIDATED AND FOUND OK	X
Man	MISHANDLING OF MATERIAL	DURING TRANSPORTATION THREAD OF PARTS WERE NOT PROPERLY COVERED AND THREAD GOT DAMAGE OF SOME PIECES	O
Tool	ROLLING DIE WEAR	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	M38 THREAD NOT OK
Why 2	DURING TRANSPORTATION FROM ROHTAK TO WAREHOUSE THREAD GOT DAMAGE
Why 3	THREAD WERE NOT COVERED DURING PACKING
Why 4	SO THREAD GOT DAMAGE
Why 5	
Root Cause (Occurance)	DURING TRANSPORTATION FROM ROHTAK TO WAREHOUSE THREAD GOT DAMAGE.THREAD WERE NOT COVERED DURING PACKING.SO THREAD GOT DAMAGE.

Root Cause Analysis (Outflow)

Why 1	M38 THREAD NOT OK
Why 2	TRANSPORT FACILITY WAS FIRST SHARED WITH OTHER COMPANIES.
Why 3	DURING TRANSPORT HANDLING OF MATERIAL WAS NOT EFFECTIVE.
Why 4	SO NG PARTS DISPATCHED TO CUSTOMER

Why 5	
Root Cause (Outflow)	TRANSPORT FACILITY WAS FIRST SHARED WITH OTHER COMPANIES.DURING TRANSPORT HANDLING OF MATERIAL WAS NOT EFFECTIVE.SO NG PARTS DISPATCHED TO CUSTOMER.

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

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

Occurance (Before)	THREADS WERE NOT COVERED PROPERLY 347_Occurance_Before.pdf
Occurance (After)	THREADS COVERED WITH CAP PROPERLY 347_Occurance_After.pdf
Outflow (Before)	TRANSPORT FACILITY WAS NOT EFFECTIVE 347_Outflow_Before.pdf
Outflow (After)	TRANSPORT FACILITY CHANGED 347_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	Checked next 3 lot and found ok