QFR No - 8000821835

Defect Details

NC No.	8000821835
NC Date	25/02/2023
NC Submission Date	
Part No.	530MX00812
Part Name	STEEL BUSH (FeZn8+ Bight Passivation)
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1136-ETL Suspension Sanand
Defect Details	DEEP MARK- ID UNCLEAN, ID LINE MARK .

1. Problem Description

Defect Description	INNER DIA. UNCLEAN SPARIAL MARKS & LINING MARK
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	200
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
Plant Head/CEO Email ID	kurund.ma@sharp-engineers.com
MD Email ID	urkhandelwal@sharp-engineers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5000	0	0	0	5000	10000
Check Qty	5000	0	0	0	5000	10000
NG Qty	200	0	0	0	50	250

Action taken on NG part

Scrap	0
Rework	150
Under Deviation	0

Containment Action
Segregation done all the pipeline material and WIP.

3. Process Flow

Process Flow Description
1) RM Inward inspection 2) 2 Storage 3) Parting and Chamfering 4) Chamfering 5) Plating (Out source) 6) Inward inspection 7) Final Inspection 8) Pre-Dispatch inspection 9) Packing & Dispatch

4. Process Details

Process / Operation	Purchasing
Outsource	Yes
Machine / Cell	NA
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Defective materi i.e. OD line mark/ID line mark/Length& dimensional variation.	Inward inspection as per SSPN IS:2500	X
Man	Judgment error While checking	Master sample/ Limit sample provided for Checking at final as well as process stage	O
Machine	Inadequate check Point in JH check sheet	Monthly JH check sheet available on machine and all the check point is being checked and recorded as	O
Tool	Wrong Tool Insert selection	SOP/WI/CP available on machine and operator aware about it and being followed.	O
Method	Part inspection visually as per control plan and inspection check sheet	Part are being checked as per control plan and inspection check sheet and record updated.	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

7. Root Cause Analysis (Occurance)

Why 1	Steel Bush ID line mark part reached at ETL
Why 2	RM tube Ø18X12.10 ID line mark itself
Why 3	RM defect
Why 4	NO machining for inner diameter
Why 5	By system design
Root Cause (Occurance)	NO machining for inner diameter

Root Cause Analysis (Outflow)

Why 1	ID line mark part reached at ETL
Why 2	Inadequate part/defect knowledge to operator/inspector.
Why 3	New defect phenomena

Why 4	
Why 5	
Root Cause (Outflow)	OPL & Q alert not displayed on machine and final inspection stage and Inadequate part/defect knowledge to operator/inspector.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	OPL & Q alert displayed on machine and final inspection stage and training given to all concerns.	Mr. Shaikh Laik	04/04/2023	04/04/2023	Completed
Occurance	100% inspection started after receipt of RM at machining stage, while loading the tube in the machine collet.	Mr. Datta Pandhre	04/04/2023	04/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	OPL & Q alert displayed on machine and final inspection stage and training given to all concerns.
Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	Check point not added in the control plan at parting stage . 380_Occurance_Before.jpg
Occurance (After)	100% inspection started after receipt of RM at machining stage while loading the tube in the machine collet. 380_Occurance_After.jpg
Outflow (Before)	Check point not evident in CP. OPL & Q alert not displayed on machine and final inspection stage and Inadequate part/defect knowledge to operator/inspector. 380_Outflow_Before.jpg
Outflow (After)	Control plan revised and check point added. OPL & Q alert displayed on machine and final inspection stage and training given to all concerns. 380_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	STEEL BUSH 312 & 412

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	DEEP MARK- ID UNCLEAN, ID LINE MARK