QFR No - 8000822306

Defect Details

NC No.	8000822306
NC Date	01/03/2023
NC Submission Date	
Part No.	B2TD00626O
Part Name	ANCHOR PIN 9 MM DIA - REML
Supplier Name & Code	100846-SANGKAJ ENGINEERING PVT.LTD.
ETL Plant	1156-ETL Disc Brake P'Nagar
Defect Details	DIMN.U/SIZE.-OPERATION MISS

1. Problem Description

Defect Description	operation miss & wrong thread pieces received
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	22
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	aslam@sangkaj.com
Plant Head/CEO Email ID	pardeshinr@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	5480	0	0	0	0	5480
Check Qty	4000	0	0	0	0	4000
NG Qty	22	0	0	0	0	22

Action taken on NG part

Scrap	22
Rework	0
Under Deviation	0

Containment Action
Segregation done at ETL-Pantnagar End

3. Process Flow

Process Flow Description
Raw material inward-wire draw-cold forging-CNC machining-Rolling-Heat treatment-plating-final inspection-PDI-dispatch

4. Process Details

Process / Operation	Cold forging
Outsource	No
Machine / Cell	Cold forging
Machine / Cell No.	19B4S

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Semi finished part fallen down in chute and got mix with OK parts at cold forging stage.	Cause verified.	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Anchor pin 9mm, dimn U/S and operation missing found at ETL
Why 2	Incomplete operation part found with ok parts
Why 3	Part fallen down through 3rd station ,where 4th station is final station.
Why 4	Part skipped through part shifting fingers.
Why 5	Fingers worn out.
Root Cause (Occurance)	Part shifting fingers worn out.

Root Cause Analysis (Outflow)

Why 1	Anchor pin 9mm, dimn U/S and operation missing found at ETL
Why 2	NG parts got mixed with Ok parts at final inspection.
Why 3	Final inspection is carried out visually.
Why 4	At visual inspection more than one part holding in hand by inspector.
Why 5	Part holding method while doing visual inspection is wrong.
Root Cause (Outflow)	Part holding method while doing visual inspection is wrong.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Work instruction reviewed and updated to ensure condition of fingers.	Mr. Shrikant Magar	20/03/2023	16/03/2023	Completed
Outflow	OPL displayed to ensure one part at a time should be hold.	Aslam Shaikh	15/03/2023	15/03/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Part holding method has been changed , now only one part at a time is being hold while doing visual inspection.
Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Assuring of condition of fingers of cold forging was not in process as not mentioned in WI for setup. 383_Occurance_Before.pdf
Occurance (After)	WI updated and training also provided to assure condition of fingers of cold forging machine 383_Occurance_After.pdf
Outflow (Before)	No instruction for visual inspection of individual part. 383_Outflow_Before.pdf
Outflow (After)	OPL provided for visual inspection to educate for proper material inspection. 383_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Anchor pin 8mm

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	done