QFR No - 8000823619

Defect Details

NC No.	8000823619
NC Date	17/03/2023
NC Submission Date	
Part No.	550LG06702
Part Name	SEAT PIPE-(HMS-30 & HMP-30)
Supplier Name & Code	100929-HARSHAD ENGINEERING COMPANY
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	THREADING NOT OK-HALF THREAD

1. Problem Description

Defect Description	Oil leakage due to half thread in seat pipe
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	2
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qaharshad@miteshauto.com
Plant Head/CEO Email ID	qaharshad@miteshauto.com
MD Email ID	auto.mitesh@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4800	0	0	2500	0	7300
Check Qty	4800	0	0	2500	0	7300
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	0
Rework	2
Under Deviation	0

Containment Action
100 % sorting done for ETL End, HEC WIP & FG material

3. Process Flow

Process Flow Description
Cutting-Draw-Forging(Head Formation)-Rough Grinding-CNC (Head, Boring & Tapping)-Punching-Finish Grinding-Final Inspection-Packing-Dispatch

4. Process Details

Process / Operation	Tapping
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	140

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Hyd. Oil Seal brake	Hyd. Oil Seal observed in brake condition	O
Tool	Tap broken	Tap found ok	X
Man	Unskilled operator	Skilled operator	X
Method	Improper loading	Loading found proper (Complete resting)	X

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	Tap not perform for complete threading length
Why 2	Tap not reached up to complete thread length min. 14 mm
Why 3	Part not clamp at correct position upto head back face
Why 4	Part clamping unit declamp/malfunction at the time setting of auto to manual cycle
Why 5	
Root Cause (Occurance)	Collet clamping unit not properly work because hydraulic oil seal gets break and oil pressure drop down

Root Cause Analysis (Outflow)

Why 1	Incomplete Tapping
Why 2	Only Threading presence checked
Why 3	Not aware about Incomplete Threading
Why 4	
Why 5	
Root Cause (Outflow)	100 % Inspection not done for Threading length.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	OPL displayed & Awareness given about threading incomplete	Vaibhav Shirsath	12/03/2023	12/03/2023	Completed
Occurance	Collet holder assly hydraulic oil seal changed	Yogesh Ugle	15/03/2023	16/03/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	100% Inspection done to ensure complete threading length
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Hydraulic oil seal broken 388_Occurance_Before.jpg
Occurance (After)	Hydraulic oil seal replaced by new one 388_Occurance_After.jpg
Outflow (Before)	NO check point for oil seal condition checking 388_Outflow_Before.pdf
Outflow (After)	Check point added for oil seal condition checking Quarterly 388_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	SPM Machines

12. Document Review

Documents	PMCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok