QFR No - 8000825753

Defect Details

NC No.	8000825753
NC Date	08/04/2023
NC Submission Date	
Part No.	F2PH02212B
Part Name	COVER CAP (Ø33 SPD)
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	HIGHT U/SIZE.-22 MM DIA UINDER SIZE

1. Problem Description

Defect Description	HIGHT U/SIZE.-22 MM DIA UINDER SIZE
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	22
Is Defect Repeatative?	No
Defect Sketch / Photo	42ckgm3bbcuzzla25ogbxw3a.jpg

Supplier Communication Details

Quality Head Email ID	quality@sharp-engineers.com
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	3000	0	0	500	1000	4500
Check Qty	3000	0	0	500	1000	4500
NG Qty	22	0	0	0	7	29

Action taken on NG part

Scrap	29
Rework	0
Under Deviation	0

Containment Action
Segregation done for ETL end Material & FG+WIP material 100% verified.

3. Process Flow

Process Flow Description
RM Receipt Inspection & Storage, Blank Cutting & Drilling, Milling, CNC-I, CNC-II, Grinding, Plating, Inward Inspection, Final Inspection, PDI, Packing & Forwarding.

4. Process Details

Process / Operation	Ist Setup
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	8

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Worn Out	Observed Ok	O
Machine	Machine Parameter variation	Observed OK	O
Material	-	-	O
Method	Wrong loading of parts	Observed chips / burr accumulation in jaw	X
Man	Unskilled	Observed ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	DVC
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS2500.1

7. Root Cause Analysis (Occurance)

Why 1	Wrong loading of parts
Why 2	Part position was not OK
Why 3	Due to Part resting was incomplete in jaw
Why 4	Burr accumulation on Resting face
Why 5	Less space for burr removal in V-Jaw
Root Cause (Occurance)	Burr accumulation on Resting face due to less space for burr/chips removal

Root Cause Analysis (Outflow)

Why 1	HEIGHT U/SIZE part observed at customer end
Why 2	Not detected during inprocess inspection
Why 3	Sample basis inspection with DVC
Why 4	Unavailability of gauge
Why 5	
Root Cause (Outflow)	Sample basis inspection with gauge

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	V Jaw are replaced by T Jaw	Mr. Ingole DN	12/04/2023	11/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Length Gauge Implemented
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	-

10. Evidance of Countermeasure

Occurance (Before)	- 405_Occurance_Before.jpg
Occurance (After)	- 405_Occurance_After.jpeg
Outflow (Before)	- 405_Outflow_Before.xls
Outflow (After)	- 405_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Valve Retainer SPD 31,37

12. Document Review

Documents	ControlPlan, PFMEA, InspCheckSheet
Specify Other Document	-

13. Effectiveness Of Action

Reviewed Quantity	8500
Reason for submission	All part 22 mm diameter found ok