QFR No - 8000826358

Defect Details

NC No.	8000826358
NC Date	15/04/2023
NC Submission Date	
Part No.	S2CW00307B
Part Name	D NUT DUKE 200 WITH CANISTER
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	DIAMETER OVER SIZE-O/D OVER SIZE SPE=21.0+0.30 OBS=21.60MM

1. Problem Description

Defect Description	DIAMETER OVER SIZE-O/D OVER SIZE SPE=21.0+0.30 OBS=21.60MM
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	499
Is Defect Repeatative?	No
Defect Sketch / Photo	

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	540	0	0	0	0	540
Check Qty	540	0	0	0	0	540
NG Qty	499	0	0	0	0	499

Action taken on NG part

Scrap	499
Rework	0
Under Deviation	0

Containment Action
Inspection done with DVC for ETL End Material

3. Process Flow

Process Flow Description
RM Receipt & Inspection, Parting and Drilling, CNC I, CNC II, Milling, Deburring, Heat Treatment, Shot Blasting, Powder Coating, Inward Inspection, Final Inspection, PDI, Packing & Forwarding

4. Process Details

Process / Operation	1st Setup CNC
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	8

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Insert wear out	Insert life defined found OK	O
Material	Hard Material	TC verified found OK	O
Machine	Machine parameter not OK	Verified and found all parameter within spec	O
Method	Coating thickness allowance	OD dimn maintained 21+0.3, No Coating allowance	X
Man	Unskilled manpower	Operator level defined, found adequate	O
Method	No checkpoint for OD 21+0.3	Checkpoint added but on sample basis with DVC	X

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	as per CP

7. Root Cause Analysis (Occurance)

Why 1	Fitment issue in D Nut Canister Duke 200
Why 2	OD 21+0.3 mm oversized
Why 3	Dimension maintained 21+0.3 as per CP
Why 4	After coating Diameter oversized
Why 5	No coating allowance kept
Root Cause (Occurance)	Diameter observed oversized Due to No coating allowance

Root Cause Analysis (Outflow)

Why 1	Fitment issue in D Nut Canister Duke 200
Why 2	OD 21+0.3 mm oversized
Why 3	Not detected during inspection
Why 4	sample basis inspection with DVC
Why 5	
Root Cause (Outflow)	Sample basis inspection with DVC

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Plating allowance kept 0.2 mm	QA Suprvisor	20/04/2023	18/04/2023	Completed
Outflow	Checking method changed from DVC to Snap Gauge with Controlled Size 21+0.1mm only	Production Supervisor	20/04/2023	18/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Checking method changed from DVC to Snap Gauge with Controlled Size 21+0.1mm only
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS 2500

10. Evidance of Countermeasure

Occurance (Before)	No powder coating allowance at machining stage 411_Occurance_Before.pdf
Occurance (After)	Considering powder coating allowance Size put as 21.0+0.1mm at machining stage. 411_Occurance_After.pdf
Outflow (Before)	Before no any inspection done for the OD size 21.0+0.30mm at Final inspection. 411_Outflow_Before.pdf
Outflow (After)	After complaint for the OD Size 21.0+0.30mm inspection started by Snap Gauge 100%. 411_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	D Nut XF1C1 1D1- E92

12. Document Review

Documents	ControlPlan, PFMEA, InspCheckSheet
Specify Other Document	-

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	Evidence of Countermeasure not relevant with respect to Action Submitted, Resubmit Again