QFR No - 8000827040

Defect Details

NC No.	8000827040
NC Date	22/04/2023
NC Submission Date	
Part No.	S3LZ00312B
Part Name	SPACER -TVS KING FRONT
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1116-ETL K-120 Suspension
Defect Details	DIAMETER OVER SIZE-I D OVERSIZE

1. Problem Description

Defect Description	Inner dia. found oversize by 0.1 to 0.18 mm.
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	508
Is Defect Repeatative?	Yes
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	3500	0	0	1000	0	4500
Check Qty	3500	0	0	1000	0	4500
NG Qty	508	0	0	162	0	670

Action taken on NG part

Scrap	670
Rework	0
Under Deviation	0

Containment Action
Segregation by Plug gauge

3. Process Flow

Process Flow Description
RM Receipt Inspection, RM Storage, Parting and Drilling, Chamfering,Taping,Milling,OD Grinding,Plating,Inward Inspection of Plating,Final Inspection,PDIR,Packing and Dispatch.

4. Process Details

Process / Operation	Parting and Drilling
Outsource	No
Machine / Cell	Traub
Machine / Cell No.	7

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	-	-	O
Machine	NG process parameter.	Check sheet verified found OK as per requirement.	O
Tool	Wrong Drill used	Resharpening is done on Drill manually	X
Method	Drill size verification after drill re-sharpening.	Drill size verified found OK, but no any verification check point after drill re-sharpening.	X
Man	Unskilled operator	Operator Level verified, found adequate.	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	As per CP

7. Root Cause Analysis (Occurance)

Why 1	ID 9.7+0.2 observed oversized upto 10 mm
Why 2	Drill size observed on higher side after resharpening
Why 3	Drill re-sharpening was in adequate.
Why 4	Drill re-sharpening to be done manually.
Why 5	No any adequate method.
Root Cause (Occurance)	No any adequate method available for drill re-sharpening & same results to oversize drilling

Root Cause Analysis (Outflow)

Why 1	ID 9.7+0.2 observed oversized upto 10 mm
Why 2	Not detected during in process inspection
Why 3	sample basis inspection during in-process.
Why 4	
Why 5	
Root Cause (Outflow)	Sample basis inpection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Drill inspection at Setup and Tool change	Production Supervisor	25/04/2023	25/04/2023	Completed
Outflow	100% inspection at Q gate	QA Supervisor	25/04/2023	25/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	-
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	is2500

10. Evidance of Countermeasure

Occurance (Before)	- 430_Occurance_Before.pdf
Occurance (After)	- 430_Occurance_After.pdf
Outflow (Before)	- 430_Outflow_Before.pdf
Outflow (After)	- 430_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	-

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	-

13. Effectiveness Of Action

Reviewed Quantity	10
Reason for submission	Corrective action parts submission.