QFR No - 8000827592

Defect Details

NC No.	8000827592
NC Date	26/04/2023
NC Submission Date	
Part No.	F1LG00902B
Part Name	SEAT PIPE -K86A
Supplier Name & Code	100538-NARINDER PARKASH AND CO
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	LENGTH UNDERSIZE-TOTAL LENGHT LESS

1. Problem Description

Defect Description	Seat pipe total length less issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	2
Is Defect Repeatative?	Yes
Defect Sketch / Photo	myxhb1uoyxroq2e4tssk4rhv.jpg

Supplier Communication Details

Quality Head Email ID	quality@npcindustries.in
Plant Head/CEO Email ID	anand@npcindustries.in
MD Email ID	ajay@npcindustries.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4000	0	0	2000	0	6000
Check Qty	4000	0	0	4	0	4004
NG Qty	2	0	0	4	0	6

Action taken on NG part

Scrap	6
Rework	0
Under Deviation	0

Containment Action
Segregated all parts at ETL, at Warehouse & at NPC Nabha.

3. Process Flow

Process Flow Description
1.Raw Material 2.Cutting & Chamfering 3. Multistation Draw 4.Head Formation 5.Rough Grinding 6.Punching 7.CNC Head Turning 8.CNC Boring & Facing 9.Tapping 10. Chamfering 1&2 11.Finish Grinding 12.Final Inspection 13.Cleaning 14.Oiling 15.Packing & Dispatch

4. Process Details

Process / Operation	CNC Boring
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	CNC-04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Material hardness less/more	After verification we found material Hardness as per spec.	O
Method	Other model mixed during processing	after verification We found material was ok.	O
Machine	Cnc Program was tampered	After verification we found CNC program was ok as per drawing.	O
Method	vernier not calibrated	after Verification vernier was Calibrated	O
Method	Material clamping method inadequate	After verification we found material clamping method inadequate.	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	seatpipe total length Less
Why 2	seat pipe did not proper fit in collet.
Why 3	Part did not clamp as per requirement.
Why 4	Chips stucked with stopper pin
Why 5	no proper cleaning during operation
Root Cause (Occurance)	no proper cleaning during operation

Root Cause Analysis (Outflow)

Why 1	seatpipe total length Less
Why 2	Could not be detected at final inspection
Why 3	Skipped in Sampling at Final Inspection
Why 4	Sampling quantity was less
Why 5	
Root Cause (Outflow)	Sampling quantity was less

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	100% inspection during final inspection	Mr. Ankush	29/04/2023	28/04/2023	Completed
Occurance	freezed cleaning frequency by Air gun during operation.	Mr. Gurpreet Singh	29/04/2023	28/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Inspection During final inspection.
Inspection Method	Other
Other Inspection Method	Use Flat plate
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Chips stucked with stopper 433_Occurance_Before.jpeg
Occurance (After)	freezed cleaning frequency by Air gun during operation. 433_Occurance_After.jpeg
Outflow (Before)	We checked with sampling inspection By Digital vernier 433_Outflow_Before.jpeg
Outflow (After)	Increase sampling quantity at work station & use of surface flat for length checking at final inspection 433_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	CNC Machine

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	Reviewed 2000 no`s found ok