QFR No - 8000827812

Defect Details

NC No.	8000827812
NC Date	28/04/2023
NC Submission Date	
Part No.	S3GD01938B
Part Name	INNER TUBE BALL PASSED-TVS KING REAR
Supplier Name & Code	100876-ACCRETE ELECTROMECH PVT.LTD.
ETL Plant	1116-ETL K-120 Suspension
Defect Details	STREGHTNESS NOT OK-STREGHTNESS NOT OK

1. Problem Description

Defect Description	Straightness not Ok concern observed.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	507
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qahead@accrete.in
Plant Head/CEO Email ID	ppc@accrete.in
MD Email ID	damodani@accrete.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	800	0	3800
Check Qty	3000	0	0	800	0	3800
NG Qty	507	0	0	100	0	607

Action taken on NG part

Scrap	607
Rework	0
Under Deviation	0

Containment Action
100% inspection done for inner diameter at ETL as well as AEPL end.

3. Process Flow

Process Flow Description
1. Raw tube receipt 2. Tube cutting 3. Washing 4. Tube chamfering 5. Dispatch

4. Process Details

Process / Operation	Raw material
Outsource	Yes
Machine / Cell	NA
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	RM tube defect	RM tube defect	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	10 nos

7. Root Cause Analysis (Occurance)

Why 1	Straightness not ok issue observed
Why 2	RM Defect
Why 3	
Why 4	
Why 5	
Root Cause (Occurance)	RM Defect (Communicated with supplier)

Root Cause Analysis (Outflow)

Why 1	Straightness not ok issue observed
Why 2	Straightness not inspected at AEPL
Why 3	100 percent inspection not performed
Why 4	ID Straightness inspected on sample basis
Why 5	
Root Cause (Outflow)	ID Straightness inspected on sample basis

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	100% inspection started with straightness gauge before dispatch	Prakash ade	03/05/2023	03/05/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection with straightness gauge started
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Not applicable 441_Occurance_Before.xlsx
Occurance (After)	Not applicable 441_Occurance_After.xlsx
Outflow (Before)	SOP of SOCO cutting machine does not contain straightness parameter. 441_Outflow_Before.xlsx
Outflow (After)	SOP of SOCO cutting machine updated and straightness inspection added in it. 441_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Not applicable

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	10
Reason for submission	Corrective action parts submission.