QFR No - 8000830656

Defect Details

NC No.	8000830656
NC Date	26/05/2023
NC Submission Date	
Part No.	F2BZ05712B
Part Name	CAP OIL LOCK - J1D FF (10mm taper)
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-ANGLE FOUND NOT OK

1. Problem Description

Defect Description	Taper angle (1.3 ± 0.30) found not ok.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	133
Is Defect Repeatative?	No
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	4060	0	0	1200	500	5760
Check Qty	4060	0	0	1200	500	5760
NG Qty	133	0	0	0	0	133

Action taken on NG part

Scrap	0
Rework	133
Under Deviation	0

Containment Action
Segregation done immediately for all the suspected material.

3. Process Flow

Process Flow Description
10) RM inward inspection 20) Traub Machining(Drilling & Parting 30) Inspection semi-finish part 40) CNC 1s set up 50) CNC 2nd set up 60) Plating process (Outsource) 70) Inward inspection 80) Final Inspection 90) Pre-dispatch inspection 100) Packing & dispatch

4. Process Details

Process / Operation	CNC machining
Outsource	No
Machine / Cell	SE/CNC/02
Machine / Cell No.	CNC machine shop

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Wrong material grade	Third part inspection for RM testing	O
Method	checking method by visual	Wrong checking method (limit sample not available	X
Man	Un-skilled manpower/Semi-skilled operator	New operator	X
Tool	Tool/insert/drill worn out	Tool life monitoring as per defined frequency	O
Machine	inaccurate machine	JH/PM for CNC machine	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Limit sample
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

7. Root Cause Analysis (Occurance)

Why 1	CAP OIL LOCK J1D FF (10 mm taper) angle out 1.30 degree
Why 2	Burr placed inside the CNC chuck jaw
Why 3	under cut groove not done in the CNC chuck jaw.
Why 4	Design by system
Why 5	
Root Cause (Occurance)	Under cut groove not done in the CNC chuck jaw. (New phenomena, customer complaint occurred first time, after investigation under cut groove provided.

Root Cause Analysis (Outflow)

Why 1	CAP OIL LOCK J1D FF (10 mm taper) angle out 1.30 degree
Why 2	Semi-skilled inspector, not aware about defect
Why 3	Limit sample not displayed.
Why 4	New phenomena
Why 5	
Root Cause (Outflow)	Limit sample not displayed.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Under cut grove provided in the CNC chuck jaw,(New phenomena, customer complaint occurred first time, after investigation under cut groove provided.	Mr. Datta Pandhre	01/06/2023	01/06/2023	Completed
Outflow	Limit sample displayed at FID stage and training given to inspector.	Mr, Shaikh Laik	27/05/2023	27/05/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Under cut groove provided in the CNC chuck jaw.
Inspection Method	Other
Other Inspection Method	NA
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	Under cut groove not done in the CNC chuck jaw. 454_Occurance_Before.pdf
Occurance (After)	Under cut grove provided in the CNC chuck jaw . 454_Occurance_After.pptx
Outflow (Before)	Limit sample not displayed. Semi-skilled inspector, not aware about defect 454_Outflow_Before.jpg
Outflow (After)	Limit sample displayed at FID stage and training given to inspector. 454_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CAP OIL LOCK (DT) 550BZ04302

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, JHCheckSheet, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	100

Reason for submission	Root cause analysis and action for occurrence not linked properly. This part running from so many years and why this problem not occur earlier and why under cut groove provided now,