QFR No - 8000833966

Defect Details

NC No.	8000833966
NC Date	23/06/2023
NC Submission Date	
Part No.	F2FA15933M
Part Name	FORK PIPE MACHINED (K19 DRUM FF)
Supplier Name & Code	100634-TATA STEEL LIMITED
ETL Plant	1126-ETL Pantnagar
Defect Details	DIMN.U/SIZE.-DIM. U/D OB 8.5 AGINST 11MM

1. Problem Description

Defect Description	Fitment Issue : DIMENSION UNDERSIZE.-OBSERVATION 8.50 MM AGAINST 11.00 MM
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	215
Is Defect Repeatative?	Yes
Defect Sketch / Photo	ri0exybddt0kzupjmkggm1ck.docx

Supplier Communication Details

Quality Head Email ID	bipldholpur@gmail.com
Plant Head/CEO Email ID	harsh.pareek@tatasteel.com
MD Email ID	Praveens@tatasteel.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	500	0	0	0	200	700
Check Qty	500	0	0	0	200	700
NG Qty	100	0	0	0	15	115

Action taken on NG part

Scrap	15
Rework	0
Under Deviation	0

Containment Action
100 % Inspection done at ETL and next lots to be supplied only after 100% inspection at TSL end.

3. Process Flow

Process Flow Description
CNC 1st set up (Threading)

4. Process Details

Process / Operation	CNC Turning
Outsource	No
Machine / Cell	CNC- Marshall
Machine / Cell No.	03

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	No Probable root cause related to material	No Probable root cause related to material	O
Tool	No Probable root cause related to material	No Probable root cause related to material	O
Man	No Probable root cause related to material	No Probable root cause related to material	O
Machine	Hydraullic Pressure Variation	Hydraulic Oil, Internal Leakage in chuck Cylinder	X
Method	Lot of sampling was small	Due to small lot size , Defected Pieces can Skip	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05

7. Root Cause Analysis (Occurance)

Why 1	Fork pipe K19 of Dim under size
Why 2	Hydraullic Oil Presssure Varry
Why 3	Hydraulic Oil, Internal Leakage in chuck Cylinder
Why 4	No Check Point in System
Why 5	
Root Cause (Occurance)	Hydraullic oil Internally leakage in Chuck Cylinder due to this Pressure Varry

Root Cause Analysis (Outflow)

Why 1	Fork pipe K19 of Dim under size
Why 2	Not detected in, Inhouse Inspection
Why 3	Lot of sampling was small (5 Pcs Hourly)
Why 4	
Why 5	
Root Cause (Outflow)	Lot of sampling was small (5 Pcs Hourly)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1- check Point added in daily Maintenance check sheet	QA	12/05/2023	12/05/2023	Completed
Outflow	1.-Lot of Sampling Increases From 5 pcs Hourly to 25 Pcs Hourly 2- Given OPL On this Problem	QA Supervisor	12/05/2023	12/05/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Lot of Sampling Increases (From 5 pcs Hourly to 25 Pcs Hourly)
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05

10. Evidance of Countermeasure

Occurance (Before)	NO CHECK POINT DAILY PM CHECKLIST 492_Occurance_Before.jpg
Occurance (After)	CHECK POINT ADDED INDAILY PM CHECKLIST 492_Occurance_After.jpg
Outflow (Before)	05 Pcs Checked Hourly 492_Outflow_Before.jpg
Outflow (After)	25 Pcs Checked Hourly 492_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	ALL CNC MACHINE

12. Document Review

Documents	ControlPlan, PMCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	OK