QFR No - 8000836624

Defect Details

NC No.	8000836624
NC Date	13/07/2023
NC Submission Date	
Part No.	550FA18433
Part Name	FORK PIPE MACHINED - K11
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-QM-VL-KDH - THREADING NG

1. Problem Description

Defect Description	Threading NG found at incoming
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	108
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	irfan@sangkaj.com
Plant Head/CEO Email ID	steel@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	0	0	1000
Check Qty	1000	0	0	0	0	1000
NG Qty	108	0	0	0	0	108

Action taken on NG part

Scrap	108
Rework	0
Under Deviation	0

Containment Action
Segregation of all pipe line material at customer as well as warehouse and SEPL end.

3. Process Flow

Process Flow Description
10. RM Inward inspection 20.Identification groove 30.Induction hardening 40.Bend removal 50.CNC Turning First 60. CNC turning second 70. Drilling 80.Air Cleaning 90.Packing and Dispatch

4. Process Details

Process / Operation	50. CNC Turning First
Outsource	No
Machine / Cell	CNC Fork Pipe Cell
Machine / Cell No.	Cell no.3

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Gauge Wear out	Gauge Wear out	O
Tool	Tool wear out	Insert/tool manufacturer changed	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	5 per hour

7. Root Cause Analysis (Occurance)

Why 1	Thread undersize (Go not pass)
Why 2	Tool wear out before its life
Why 3	Wrong grade insert taken for use
Why 4	Insert grade/Manufacturer not mentioned in control plan.
Why 5	
Root Cause (Occurance)	Due Insert grade/Manufacturer not mentioned in control plan wrong grade insert taken for use.

Root Cause Analysis (Outflow)

Why 1	Thread undersize (Go not pass) not detected
Why 2	Part found ok on gauge
Why 3	Gauge wear out not detected
Why 4	Wear ring gauge not available
Why 5	
Root Cause (Outflow)	Wear ring gauge not available

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Add insert grade and Manufacturer in Control plan	Mr. Krushna Fuke	02/08/2023	01/08/2023	Completed
Outflow	Procure wear ring gauge	Mr.Irfan	30/08/2023	08/09/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	Wear ring added
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	Plan

10. Evidance of Countermeasure

Occurance (Before)	Threading insert specification and Make not available 509_Occurance_Before.pdf
Occurance (After)	Threading insert make and grade updated in control plan 509_Occurance_After.pdf
Outflow (Before)	Wear gauge not available 509_Outflow_Before.xlsx
Outflow (After)	wear gauge ordered and made available up to 30.08.23 509_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All fork pipe model

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	150
Reason for submission	Ok