QFR No - 8000839779

Defect Details

NC No.	8000839779
NC Date	08/08/2023
NC Submission Date	
Part No.	B2EH08502O
Part Name	END CONNECTOR MASTER SIDE NTORQ
Supplier Name & Code	101221-SUNREN AUTOMOTIVE PRIVATE LIMI
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	OTHER-LUG NOT OK

1. Problem Description

Defect Description	LUG NOT OK
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	1359
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	shivank@sunren.in
Plant Head/CEO Email ID	dharmbir@sunren.in
MD Email ID	subhashsaini@sunren.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	17000	9000	2000	3000	31000
Check Qty	0	17000	9000	2000	3000	31000
NG Qty	0	243	0	0	0	243

Action taken on NG part

Scrap	243
Rework	0
Under Deviation	0

Containment Action
100% inspection will be carried out at warehouse and green dot marking is placed over the lug for ensurity.

3. Process Flow

Process Flow Description
Inspection of Raw Material - Cutting Multi Operation - Centerless Grinding - Milling - Cross Drill - Neck Drill-Cross Reamer - Pin Drill - Pin Assembly - Brazing - Facing1st - Facing-2nd -Chamfer- 100% Visual Inspection -Bending - Plating - Final Inspection - Packaging - Storage / Dispatch .

4. Process Details

Process / Operation	Bending
Outsource	No
Machine / Cell	Bending Fixture
Machine / Cell No.	10

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Lack of Knowledge	Skill Matrix	O
Method	Inspection Method Not Effective	Gauge Verification	X
Tool	wear and tear of fixtures	Fixture Validation	X

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

7. Root Cause Analysis (Occurance)

Why 1	wear & tear of bending fixture
Why 2	Fixture was not hardened
Why 3	Fixture life was not decided
Why 4	Fixture not validated
Why 5	Lack of awareness
Root Cause (Occurance)	Wear & Tear of bending fixture

Root Cause Analysis (Outflow)

Why 1	Inspection process not effective
Why 2	Checking Gauge found not effective
Why 3	complete profile of the part was not covered in gauge
Why 4	Gauge Design Needs improvement
Why 5	Gauge Design not validated
Root Cause (Outflow)	Checking Gauge Found Not Effective.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Fixture will be replaced , Hardened , Gauge validation will be done and improvement will be done in bending fixture taking pin as a reference for bending.	Shivank	29/09/2023	10/09/2023	Completed
Outflow	Checking gauge will be re-designed considering pin shifting , part profile and pin angle.	Shivank	29/09/2023	27/09/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Lug shift is checked 200% and green dot marking is started over the lug for ensurity.
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

10. Evidance of Countermeasure

Occurance (Before)	Fixture Gets Wear and Tear. 518_Occurance_Before.png
Occurance (After)	New Bending Fixture Implemented. 518_Occurance_After.png
Outflow (Before)	Only Pin was guided as a reference in the block. 518_Outflow_Before.jpg
Outflow (After)	New Checking Fixture Made w.r.t Pin angle , pin shifting , part profile and connector angle concept. 518_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Presently Only single model is there.

12. Document Review

Documents	
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Lug ok observed in corrected lot