QFR No - 8000848504

Defect Details

NC No.	8000848504
NC Date	12/10/2023
NC Submission Date	
Part No.	B2SG01026O
Part Name	PUSH ROD FORK FOR M/CYL 2WH,RE J1C
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	THREADING NOT OK-EXCESS THREADING

1. Problem Description

Defect Description	HREADING NOT OK-EXCESS THREADING
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	300
Is Defect Repeatative?	Yes
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	1100	0	0	500	500	2100
Check Qty	1100	0	0	500	500	2100
NG Qty	300	0	0	228	55	583

Action taken on NG part

Scrap	583
Rework	0
Under Deviation	0

Containment Action
Segregation done immediately at ETL and in-house pipeline material

3. Process Flow

Process Flow Description
10) RM Inward 20) RM Storage 30) Parting & Forming 40) Milling Operation 50) Drilling60) Taping (M8x1.25-6G)70) Drilling Operation 80) O.D. Grinding 90)Plating Process 100)Inward Inspection 110) Final Inspection 120)Pre-Dispatch Inspection 130) Packing & Forwarding

4. Process Details

Process / Operation	Drilling Operation
Outsource	No
Machine / Cell	SE/DR/03
Machine / Cell No.	Machine Shop

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Un-skilled Operator	Stage wise skill matrix and operator license are not evident as per F/HR/06	O
Method	Operator Working Method Wrong	SOP/WI available on machine and operator aware about it and being followed.	O
Tool	Excess Tap length	Tapping length was excess	X
Machine	Holding in the fixture with required pin gauge	SOP/WI available on machine and operator aware about it and being followed.	O
Material	Incorrect RM grade	Third part inspection verified for chemical composition and hardness testing as per requirement.	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	THREADING NOT OK-EXCESS THREADING
Why 2	Excess Tap length observed.
Why 3	Non-standard tap used
Why 4	
Why 5	
Root Cause (Occurance)	Non-standard tap used

Root Cause Analysis (Outflow)

Why 1	THREADING NOT OK-EXCESS THREADING
Why 2	Inspector not aware about the defect
Why 3	OPL not displayed at inspection stage
Why 4	New defect phenomena

Why 5	
Root Cause (Outflow)	Inspector not aware about the defect because of new defect phenomena.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Tap length standardized and sizes are being checked before start of the production.	Mr. Vinod Patil	14/10/2023	20/10/2023	Completed
Outflow	OPL displayed at final inspection stage and training given to inspector for awareness purpose.	Mr. Shaikh Laik	12/10/2023	14/10/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	OPL displayed
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	Non-standard tap used 579_Occurance_Before.pptx
Occurance (After)	Tap length standardized and sizes are being checked before start of the production. 579_Occurance_After.pptx
Outflow (Before)	New defect phenomena 579_Outflow_Before.pptx
Outflow (After)	OPL displayed at final inspection stage and training given to inspector for awareness purpose. 579_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	PUSH ROD FORK R121 (B3KC00702O)

12. Document Review

Documents	PFMEA, WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	