QFR No - 8000852795

Defect Details

NC No.	8000852795
NC Date	24/11/2023
NC Submission Date	
Part No.	D3AD00500M
Part Name	SHAFT CUT LENGTH (R122C MAXIMA Z)
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1152-ETL L-6/3/1DrivShaft
Defect Details	DIAMETER OVER SIZE-OD O/S & SCRTCH MARK ON OD

1. Problem Description

Defect Description	DIAMETER OVER SIZE-OD O/S & Taper & SCRTCH MARK ON OD - Shaft Maxima
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	514
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	7000	0	0	1000	0	8000
Check Qty	4500	0	0	1000	0	5500
NG Qty	514	0	0	0	0	514

Action taken on NG part

Scrap	0
Rework	514
Under Deviation	0

Containment Action
segregate pipe line material at ETL end & inhouse.

3. Process Flow

Process Flow Description
BAR CUTTING- TURNING -STRAIGHTENING-GRINDING- FINAL INSPECTION-PACKING-DISPATCH

4. Process Details

Process / Operation	OD grinding
Outsource	No
Machine / Cell	Grinding m/c
Machine / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	OD gauge not available.	OD checked by micrometer as OD gauge given for calibration.	X
Machine	Grinding wheel wear out	Wheel Frequency not defined	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	DIAMETER OVER SIZE-OD O/S & SCRTCH MARK ON OD
Why 2	Grinding wheel wear out
Why 3	Grinding wheel dressing frequency not defined.
Why 4	
Why 5	
Root Cause (Occurance)	Grinding wheel dressing frequency not defined.

Root Cause Analysis (Outflow)

Why 1	DIAMETER OVER SIZE-OD O/S & SCRTCH MARK ON OD
Why 2	OD Not checked by Gauge
Why 3	OD gauge given for calibration.
Why 4	Gauge calibration was due.
Why 5	
Root Cause (Outflow)	Gauge calibration was due.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	New OD Snap gauge purchased, OD 100 % Check by snap gauge.	Inspector	25/11/2023	27/11/2023	Completed
Occurance	Grinding wheel dressing frequency defined after	operator	25/11/2023	27/11/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	OD check by snap gauge
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100 %

10. Evidance of Countermeasure

Occurance (Before)	Grinding wheel dressing frequency not defined. 600_Occurance_Before.jpeg
Occurance (After)	Grinding wheel dressing frequency defined . 600_Occurance_After.jpeg
Outflow (Before)	OD checked by micrometer as OD gauge given for calibration. 600_Outflow_Before.jpeg
Outflow (After)	New OD Snap gauge purchased, OD 100 % Check by snap gauge. 600_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Machine,Man

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	G.wheel dress.Record

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	