QFR No - 8000853854

Defect Details

NC No.	8000853854
NC Date	05/12/2023
NC Submission Date	
Part No.	F1GN01102B
Part Name	MAIN SPRING K86A
Supplier Name & Code	101236-SUMA SPRINGS PRIVATE LIMITED
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	GRINDING MISSING-WITH OUT GRINDING OPERATION

1. Problem Description

Defect Description	K86 Main spring with out grinding operation
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	coycxtkjqoyu1czc1udeygom.jpg

Supplier Communication Details

Quality Head Email ID	qc1@sumasprings.com
Plant Head/CEO Email ID	qc@sumasprings.com
MD Email ID	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	450	0	0	0	0	450
Check Qty	450	0	0	0	0	450
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
Awareness created to the team, Segregated at Customer end as well as Suma End

3. Process Flow

Process Flow Description
COILING+TEMP1+GRINDING+SHOTPEEENING+TEMPERING2+SCRAGGING +BEND CHECK AND OILING+PDI+PACKING AND DESPATC

4. Process Details

Process / Operation	GRINDING
Outsource	No
Machine / Cell	GRINDING MACHINE
Machine / Cell No.	SLM400,SLM 600

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	During laoding Fallout part mixup	Yes verifed	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS2500 2K

7. Root Cause Analysis (Occurance)

Why 1	GRINDING MISSING
Why 2	without process fallen part mix up
Why 3	During laoding in grinding jig parts fallen
Why 4	
Why 5	
Root Cause (Occurance)	During laoding in grinding jig parts fallen

Root Cause Analysis (Outflow)

Why 1	GRINDING MISSING
Why 2	ineffective inspection during stage
Why 3	Random inspection after grinding process
Why 4	
Why 5	
Root Cause (Outflow)	Random inspection after grinding process

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Limited parts will be taken for grinding ,and check for fallen parts and start the machine	Sabari Giri	07/12/2023		Completed
Outflow	100 % visual check for operation miss before moving to next process	Sabari Giri	07/12/2023	08/12/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % visual check for operation miss before moving to next process
Inspection Method	Other
Other Inspection Method	Visual & Tag system
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS2500-2K

10. Evidance of Countermeasure

Occurance (Before)	During laoding in grinding jig parts fallen 604_Occurance_Before.pdf
Occurance (After)	Limited parts will be taken for grinding ,and check for fallen parts and start the machine 604_Occurance_After.pdf
Outflow (Before)	Random inspection after grinding process 604_Outflow_Before.pdf
Outflow (After)	100 % visual check for operation miss before moving to next process 604_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	S2H352107B

12. Document Review

Documents	
Specify Other Document	QALERT & AWARNESS

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	