QFR No - 8000853857

Defect Details

NC No.	8000853857
NC Date	05/12/2023
NC Submission Date	
Part No.	S2HT52107B
Part Name	OUTER SPRING K0PG
Supplier Name & Code	101236-SUMA SPRINGS PRIVATE LIMITED
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	DIMN.U/SIZE.-ID LESS ISSUE

1. Problem Description

Defect Description	K0PG outer spring ID under size issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qc@sumasprings.com
Plant Head/CEO Email ID	vp@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	1000	0	0	0	0	1000
Check Qty	1000	0	0	0	0	1000
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
Quality awareness created amongst team, Segregation at ETL end as well as Suma End

3. Process Flow

Process Flow Description
COILNG + TEMPERING1+GRINDING +SHOT PEENING+TEMPERING 2+SCRAGING+POWDER COATING+PDI+PACKING AND DESPATCH

4. Process Details

Process / Operation	COILING
Outsource	Yes
Machine / Cell	COILING CNC
Machine / Cell No.	SIMCO,SCM6100+HCS

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	End coil shift	Verified and found NG	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	ID under size
Why 2	End coil shift
Why 3	Setting part
Why 4	During initial set up
Why 5	
Root Cause (Occurance)	Setting part

Root Cause Analysis (Outflow)

Why 1	ID under size
Why 2	Stage random inspection
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Stage random inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Setting part will be scrapped and pit in red box before production	Grinding incharge	08/12/2023	08/12/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	During grinding stage 100 % Visual inspection to verify the end coil shift
Inspection Method	Other
Other Inspection Method	VisualInspection
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	IS2500-2K

10. Evidance of Countermeasure

Occurance (Before)	Setup part scrapped at the end of shift 608_Occurance_Before.docx
Occurance (After)	Setup part scrapped immediately 608_Occurance_After.docx
Outflow (Before)	Random inspection during grinding stage 608_Outflow_Before.pdf
Outflow (After)	100 % visual inspection during grinding stage 608_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	F1GN101102B (MAIN SPRING)

12. Document Review

Documents	ControlPlan, ProcessFlowChart, InspCheckSheet
Specify Other Document	Q ALERT

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	