QFR No - 8000858053

Defect Details

NC No.	8000858053
NC Date	08/01/2024
NC Submission Date	
Part No.	550DZ03302
Part Name	FORK BOLT
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M10 THREAD LENGTH UNDERSIZE OBSERVED VAL

1. Problem Description

Defect Description	M10 thread length undersize
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	1360
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qualityassurance@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	0	0	0	1000	0	1000
Check Qty	0	0	0	1000	0	1000
NG Qty	0	0	0	7	0	7

Action taken on NG part

Scrap	0
Rework	7
Under Deviation	0

Containment Action
100 % sorting done at M/s Sangkaj steel end

3. Process Flow

Process Flow Description
RM store - RM inspection - Traub - CNC 1st - CNC 2nd - Thread rolling -plating - Final inspection -Dispatch.

4. Process Details

Process / Operation	Tapping Operation
Outsource	No
Machine / Cell	Tapping machine
Machine / Cell No.	Tapping machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Coolant Flow is not Proper	Less Coolant flow on Tap	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05 Nos

7. Root Cause Analysis (Occurance)

Why 1	Thread Plug Gauge not Qualify in threading M10X1.25-6H
Why 2	Small Burr stuck in Threading & settled at the bottom thread after Plating.
Why 3	During tapping Small burr not get removed
Why 4	Less Coolant Flow on tap.
Why 5	
Root Cause (Occurance)	Less Coolant Flow

Root Cause Analysis (Outflow)

Why 1	Thread Plug Gauge not Qualify in threading M10X1.25-6H
Why 2	Defective parts get Skipped from Inspection
Why 3	parts Checkied on Sampling Basis.
Why 4	Inadequate Inspection Method
Why 5	
Root Cause (Outflow)	Inspection Method inadequate

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
	Coolant Flow Increased during Tapping. Also Operator				

Occurance	given training about not to do tapping if Coolant Flow is not Proper.	Mr. Pathan K.H.	22/01/2024	22/01/2024	Completed
Outflow	Inspection done on Sampling Basis, But the Sample Size Increased. Previously only 05 Nos were Checked for thread during Final Inspection, now Sample Size increased to 30%.	Mr Mukta	23/01/2024	23/01/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection done on Sampling Basis, But the Sample Size Increased. Previously only 05 Nos were Checked for thread during Final Inspection, now Sample Size increased to 30%.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	30%

10. Evidance of Countermeasure

Occurance (Before)	coolant direction is wrong. 630_Occurance_Before.pdf
Occurance (After)	Correct the coolant direction & coolant is on tap. 630_Occurance_After.pdf
Outflow (Before)	Inadequate Inspection Method 630_Outflow_Before.pdf
Outflow (After)	Inspection done on Sampling Basis, But the Sample Size Increased. Previously only 05 Nos were Checked for thread during Final Inspection, now Sample Size increased to 30%. 630_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Applicable for all fork bolt.

12. Document Review

Documents	ControlPlan, PFMEA, InspCheckSheet
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	184
Reason for submission	Verified and found ok