QFR No - 8000859453

## Defect Details

| | |
|---|---|
| **NC No.** | 8000859453 |
| **NC Date** | 18/01/2024 |
| **NC Submission Date** | |
| **Part No.** | F2LG03702B |
| **Part Name** | SEAT PIPE (K1 UG) |
| **Supplier Name & Code** | 100648-JOTIBA TECHNOLOGIES PVT.LTD. |
| **ETL Plant** | 1117-ETL K-228/9 Suspension |
| **Defect Details** | NOT AS PER SPECIFICATION-OPERATION MISSING |

## 1. Problem Description

| | |
|---|---|
| **Defect Description** | Compression and DF hole missing |
| **Detection Stage** | Inprocess |
| **Problem Severity** | Function |
| **NG Quantity** | 1 |
| **Is Defect Repeatative?** | No |
| **Defect Sketch / Photo** | |

## Supplier Communication Details

| | |
|---|---|
| **Quality Head Email ID** | accjotiba@gmail.com |
| **Plant Head/CEO Email ID** | sanghavi.rajesh@sanghavigroup.co.in |
| **MD Email ID** | jotibatech@gmail.com |

## 2. Stock Details & action taken for NG parts

| Location | ETL End | Warehouse | Transit | Supplier FG | Supplier WIP | Total |
|---|---|---|---|---|---|---|
| **Total Qty** | 1000 | 0 | 0 | 1500 | 2500 | 5000 |
| **Check Qty** | 1000 | 0 | 0 | 1500 | 2500 | 5000 |
| **NG Qty** | 1 | 0 | 0 | 0 | 0 | 1 |

Action taken on NG part

| | |
|---|---|
| **Scrap** | 0 |
| **Rework** | 1 |
| **Under Deviation** | 0 |

| Containment Action |
|---|
| Add special gauge for inspection of D.F Hole and Compression Hole at final inspection. |

## 3. Process Flow

| Process Flow Description |
|---|
| 10. RM Inspection,20.Parting off,30.Chmafering,40.Weighing,50.Draw forging,60.Hex Forging,70.Rough Grinding, 80.Collar Machining,90.Total length facing and boring, 100 Piercing, 110.DF hole Chamfer, 120.Compression hole Chamfer, 130.ID Reaming, 140.Tapping, 150.Finish Grinding, 160.Final Inspection, 170.ID brush Cleaning, 180.Ultrasonic Cleaning, 190.Apply antirust oil, 200.Packing and dispatch. |

## 4. Process Details

| | |
|---|---|
| **Process / Operation** | 100. Piercing. |
| **Outsource** | No |
| **Machine / Cell** | Mechanical Press |
| **Machine / Cell No.** | PM-01 |

## 5. Problem Analysis

| Type | Possible Cause | Fact Verification | Jud |
|---|---|---|---|
| Method | Inspect part at final inspection visually. | ok | O |

## 6. Inspection Method Analysis (Current)

| | |
|---|---|
| **Inspection Method** | Sp. Gauge |
| **Other Inspection Method** | |
| **Check Point at Final Inspection** | Yes |
| **Checking Freq.** | 100% |
| **Sampling** | No |
| **Sample Size** | Sampling |

## 7. Root Cause Analysis (Occurance)

| | |
|---|---|
| **Why 1** | D.F Hole and Compression hole missing part produces. |
| **Why 2** | While set-up during stroke adjustment some parts produced of half punch & No punch |
| **Why 3** | Operator Not able to setup and produced first piece OK. (In setup by operator half punch and no punch parts produce). |
| **Why 4** | |
| **Why 5** | |
| **Root Cause (Occurance)** | Need to change responsibility of setup change from operator to supervisor. |

## Root Cause Analysis (Outflow)

| | |
|---|---|
| **Why 1** | D.F Hole and Compression Hole missing not detected at outflow. |
| **Why 2** | Inspect part at outflow is visually |
| **Why 3** | No special gauge for inspection. |
| **Why 4** | |
| **Why 5** | |
| **Root Cause (Outflow)** | No special gauge for inspection of D.F Hole and Compression Hole inspection. |

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

| Type | Countermeasure Details | Responsibility | Target Date | Actual Date | Status |
|---|---|---|---|---|---|

| | | | | | |
|---|---|---|---|---|---|
| Outflow | Add special gauge for inspection of compression hole 100% and D.F hole sampling. | Gore | 23/01/2024 | 18/01/2024 | Completed |
| Occurance | Change Responsibility of die setup loading and unloading operator to supervisor. | Mr. Gaurav | 23/01/2024 | 18/01/2024 | Completed |

## 9. Inspection Method After Customer Complaint

| | |
|---|---|
| **Change In Inspection System** | Yes |
| **Change Details** | By using special gauge. |
| **Inspection Method** | Sp. Gauge |
| **Other Inspection Method** | |
| **Check Point at Final Inspection** | Yes |
| **Checking Freq.** | 100% |
| **Sampling** | No |
| **Sample Size** | Chart |

## 10. Evidance of Countermeasure

| | |
|---|---|
| **Occurance (Before)** | Due operator setup of piercing and machine.<br>640_Occurance_Before.xlsx |
| **Occurance (After)** | Responsibility of supervisor setup die and machine.<br>640_Occurance_After.xlsx |
| **Outflow (Before)** | Inspect part as per sampling plan and visually.<br>640_Outflow_Before.xlsx |
| **Outflow (After)** | Using special gauge for inspection.<br>640_Outflow_After.xlsx |

## 11. Horizontal Deployment

| | |
|---|---|
| **Horizontal Deployment Required** | No |
| **Applicable Machine / Model / Plant** | NA |

## 12. Document Review

| | |
|---|---|
| **Documents** | |
| **Specify Other Document** | Special Gauge |

## 13. Effectiveness Of Action

| | |
|---|---|
| **Reviewed Quantity** | 251 |
| **Reason for submission** | Verified and found ok |