QFR No - 8000862067

Defect Details

NC No.	8000862067
NC Date	07/02/2024
NC Submission Date	
Part No.	520DZ01712
Part Name	FORK BOLT DF181085
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M26 THREAD FITMENT ISSUE

1. Problem Description

Defect Description	M26 thread fitment NG
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	150
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qualityassurance@sangkaj.com
Plant Head/CEO Email ID	qualityassurance@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	250	0	0	200	0	450
Check Qty	250	0	0	200	0	450
NG Qty	150	0	0	200	0	350

Action taken on NG part

Scrap	0
Rework	150
Under Deviation	0

Containment Action
100 % sorting at ETL end with special identification. Also 100% sorting done at M/s Sangkaj Steel End with special identification.

3. Process Flow

Process Flow Description
RM Store - RM Inspection - Traub - Pre roll dia Grinding -Tapping M10 - Thread Rolling M26 - Plating - Final inspection - Dispatch.

4. Process Details

Process / Operation	Thread Rolling
Outsource	No
Machine / Cell	Thread Rolling
Machine / Cell No.	Rolling - 02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Wrong tool used for operation.	Wrong tool used for operation.	O
Machine	Machine parameter not okay at Grinding stage .	Parameter observed at operation stage & found okay.	O
Machine	Machine parameter not okay at machining stage.	Parameter observed at operation stage & found okay.	O
Method	inspection method not okay	Less sampling frequency.	X
Man	Skipped from inspection.	NG part found at customer end.	X
Material	Wrong material used.	Verified the TC report & Found okay.	O
Machine	Machine parameter not okay at machining stage .	Parameter observed at operation stage & found okay.	O
Machine	Part dimn not as per drawing	Pre roll dimn observed at higher side.	X
Method	Loading & Unloading method not okay.	During Gemba visit at operation stage loading & unloading method observed okay.	O

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	M26 Threading not okay.
Why 2	After plating threading not qualified in mating part.
Why 3	On part minor dia found at higher side.
Why 4	On part Pre roll dia observed at higher side
Why 5	Operator is not aware about effect of parts makes at higher side of specification.
Root Cause (Occurance)	Operator is not aware about effect of parts makes at higher side of specification.

Root Cause Analysis (Outflow)

Why 1	M26 Threading not okay.
Why 2	Skipped from Inspection
Why 3	defect not detect in during final inspection.

Why 4	Less sampling frequency.
Why 5	
Root Cause (Outflow)	Less sampling frequency.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Pre roll diameter to be maintain at lower side of specification.	Mr Raut.	23/01/2024	23/01/2024	Completed
Outflow	Sampling inspection frequency increase at final inspection from 05 nos to 50 nos.	Mrs Mukta	23/01/2024	23/01/2024	Completed
Occurance	Training & Awareness given to operator.	Mr Anil	22/01/2024	22/01/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	N/A
Inspection Method	Other
Other Inspection Method	Mating part
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50 Nos

10. Evidance of Countermeasure

Occurance (Before)	Operator is not aware about effect of parts makes at higher side of specification. 661_Occurance_Before.pdf
Occurance (After)	Pre roll diameter to be maintain at lower side of specification. 661_Occurance_After.pdf
Outflow (Before)	Less inspection sampling frequency on mating part. 661_Outflow_Before.pdf
Outflow (After)	Sampling inspection frequency increase at final inspection from 05 nos to 50 nos 661_Outflow_After.pdf

11. Horizontal Deployment

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

12. Document Review

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

13. Effectiveness Of Action

Reviewed Quantity	596
Reason for submission	Verified and found ok