QFR No - 8000862164

Defect Details

NC No.	8000862164
NC Date	07/02/2024
NC Submission Date	
Part No.	520DZ00212
Part Name	FORK BOLT K60-(DS181012)
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-M10 THREAD GO NOT QUALIFYING & NOGO QUAL

1. Problem Description

Defect Description	M10 THREAD GO NOT QUALIFYING & NOGO QUALIFYING
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	10
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	800	0	0	0	0	800
Check Qty	800	0	0	0	0	800
NG Qty	28	0	0	0	0	28

Action taken on NG part

Scrap	28
Rework	0
Under Deviation	0

Containment Action
Stock Check 100% at our end

3. Process Flow

Process Flow Description
Forging ,CNC-IST, CNC-2ND, BUFFING ,ROLLING ,SURFACE ,TREATMENT, FINAL INSPECTION -PACKING

4. Process Details

Process / Operation	CNC IST
Outsource	No
Machine / Cell	01
Machine / Cell No.	02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	RM GRADE AND SIZE NOT OK	VALIDATED AND FOUND OK	O
Method	INSPECTION METHOD NOT EFFECTIVE	INSPECTION DONE AS PER SAMPLING PLAN SO PART SKIPPED FROM INSPECTION	X
Tool	TOOL WEAROUT	VALIDATED AND FOUND OK	O
Man	UNWAWARENESS OF OPERATOR	VALIDATED AND FOUND OPERATOR WAS LOW LEVEL	X
Machine	WORNG OFFSET	OFFSET NOT INTERLOCK	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

7. Root Cause Analysis (Occurance)

Why 1	M10 thread fitment NG (not qualifying to minor diameter pin 8.647, qualifying minor diameter pin 8.912 -)
Why 2	Part minor dia over size because operator wrong offset give to machine
Why 3	because offset not interlock
Why 4	CNC Machine Programming did not set how much offset the operator could give only for
Why 5	Machine checking Manor dia PPG gauge not 100% checked
Root Cause (Occurance)	Part minor dia over size because operator wrong offset give to machine

Root Cause Analysis (Outflow)

Why 1	M10 thread fitment NG (not qualifying to minor diameter pin 8.647, qualifying minor diameter pin 8.912 -)
Why 2	The Problem occurred at checking method
Why 3	Final inspection only part checked as per sampling plan
Why 4	operator part 100% not checked for ppg
Why 5	
Root Cause (Outflow)	INSPECTION DONE AS PER SAMPLING PLAN SO PART SKIPPED FROM INSPECTION

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	MACHINE OFFSET INTERLOCK	ANIL	09/03/2024	09/03/2024	Completed
Outflow	CHECKING FREQ CHANGE 100 % CHECKING FINAL INSPECTION UPDATE	GANESH MAURYA	09/03/2024	09/03/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection frequency change to 100%
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	no

10. Evidance of Countermeasure

Occurance (Before)	OFFSET NOT INTERLOCK 663_Occurance_Before.xlsx
Occurance (After)	OFFSET INTERLOCK 663_Occurance_After.png
Outflow (Before)	CHECKING FREQ NOT CHANGE AS PER SAMPLING PLAN 663_Outflow_Before.png
Outflow (After)	CHECKING FREQ CHANGE 100 % CHECKING FINAL INSPECTION UPDATE 663_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	CNC MACHINE

12. Document Review

Documents	ControlPlan, PokayokeCheckSheet, InspCheckSheet
Specify Other Document	POKA YOKA & CP

13. Effectiveness Of Action

Reviewed Quantity	150
Reason for submission	8. Countermeasure (Occurrence , Outflow & System side Actions) - NOT UPDATED