QFR No - 8000862165

Defect Details

NC No.	8000862165
NC Date	07/02/2024
NC Submission Date	
Part No.	F2DZ14903B
Part Name	FORK BOLT ACAA FF
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-COLLAR OD OVERSIZE

1. Problem Description

Defect Description	Collar OD oversize
Detection Stage	Customer End
Problem Severity	Fitment
NG Quantity	28
Is Defect Repeatative?	No
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	4000	0	0	0	0	4000
Check Qty	3972	0	0	0	0	3972
NG Qty	28	0	0	0	0	28

Action taken on NG part

Scrap	28
Rework	0
Under Deviation	0

Containment Action
we are checked 100% material lying at various stage

3. Process Flow

Process Flow Description
FORGING + CNC-Ist+ CNC-2nd+BUFFING +ROLLING+SURFACE TREATMENT+FINAL INSPECTION +PACKING

4. Process Details

Process / Operation	CNC-1st
Outsource	No
Machine / Cell	CNC-MACHINE
Machine / Cell No.	CNC-01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	INSPECTION PLAN NOT EFFECTIVE	COLLOR DIA CHECKED BEFORE VC AND AFTER PROVIDE SNAP GAUGE	X
Tool	Tool may wear	Validated and found ok	O
Material	RM GRADE AND SIZE NOT OK	VALIDATION ANF FOUND OK	O
Machine	Due to insert Loose.	Validated and Found Operator insert change not properly awareness	X
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL LOW	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	no

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-COLLAR OD OVERSIZE
Why 2	Due to insert Loose.
Why 3	Operator insert change not properly awareness
Why 4	Insert Change W.I not Available in Machine
Why 5	As per W.I insert Change Operator Training not Done
Root Cause (Occurance)	CNC MACHINE DUE TO INSERT LOOSE

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-COLLAR OD OVERSIZE
Why 2	INSPECTION PLAN NOT EFFECTIVE ONLY FOR SAMPLING PLAN ACCORDING TO PART CHECKED
Why 3	NG PART SKIPPED FROM INSPECTION
Why 4	SO NG PART DELIEVERED TO CUSTOMER
Why 5	
Root Cause (Outflow)	100% PART NOT CHECKED ONLY FOR PART CHECKED AS PER SAMPLING

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	SNAP GAUGE PROVIIDE FINAL INSPECTION AREA AND 100% MATERIAL CHECKED FOR FINAL INSP	GANESH MAURYA	08/02/2024	08/02/2024	Completed
Occurance	INSERT SETTING W.I PROVIDE ON MACHINE AND AS PER W.I OPERATOR TRAINING DONE	ANIL SAGAR	08/02/2024	08/02/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	CHECKING FREQUNCY CHANGE (100% MATERIAL CHECKED FOR FINAL INSPECTION)
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	0

10. Evidance of Countermeasure

Occurance (Before)	INSERT W.I NOT AVAILABLE 664_Occurance_Before.xlsx
Occurance (After)	INSERT W.I AVAILABLE 664_Occurance_After.pdf
Outflow (Before)	CONTROL PLAN CHECKING FREQUENCY NOT UPDATE 664_Outflow_Before.pdf
Outflow (After)	CONTROL PLAN CHECKING FREQUENCY UPDATE 664_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	ALL FORK BOLT SOME MODLE

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	244
Reason for submission	Verified and found ok