QFR No - 8000862167

Defect Details

NC No.	8000862167
NC Date	07/02/2024
NC Submission Date	
Part No.	F2LG05902B
Part Name	SEAT PIPE (K17B/D)
Supplier Name & Code	100539-N P ENTERPRISES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-OD OVERSIZE

1. Problem Description

Defect Description	OD oversize
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	10
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@npcindustries.in
Plant Head/CEO Email ID	anand@npcindustries.in
MD Email ID	ajay@npcindustries.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1500	6000	4500	0	0	12000
Check Qty	1500	6000	4500	0	0	12000
NG Qty	10	30	0	0	0	40

Action taken on NG part

Scrap	0
Rework	40
Under Deviation	0

Containment Action
Segregated all material at customer and NPC end.

3. Process Flow

Process Flow Description
PFD

4. Process Details

Process / Operation	Finish Grinding
Outsource	No
Machine / Cell	Centerless grinding
Machine / Cell No.	CG-04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	NG parts skipped at Final Inspection	Verified found not OK	X
Machine	Control wheel Size NG	Verified and found OK. No linkage with defect	O
Method	Wrong parameter use	All parameter was followed as per std.	O
Tool	Wrong Instrument used for measurement	Verified found OK	O
Machine	Non uniform removal of material after Grinding	During defect verification and simulation it was observed that there is less material removal from t	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	as per std

7. Root Cause Analysis (Occurance)

Why 1	Non uniform removal of material after Grinding
Why 2	Non uniform removal of material after Grinding
Why 3	Taper in control wheel
Why 4	Control Wheel Dressing not done after model change
Why 5	
Root Cause (Occurance)	Control Wheel Dressing not done after model change

Root Cause Analysis (Outflow)

Why 1	NG parts skipped at Final Inspection
Why 2	NG parts skipped at Final Inspection
Why 3	Could not be detected at Final Inspection
Why 4	Skipped in Sampling at Final Inspection
Why 5	Sampling plan inadequate
Root Cause (Outflow)	Sampling plan inadequate

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Dressing made mandatory for both wheels (Control wheel & Grinding wheel) after model change at Centre less Grinding machine).	Mr. Gurpreet Singh	10/02/2024	08/02/2024	Completed
Outflow	Single Sampling plan to be replaced with double sampling plan .	Mr. Ankush	08/02/2024	08/02/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Single Sampling plan to be replaced with double sampling plan .
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	as per std

10. Evidance of Countermeasure

Occurance (Before)	Control and grinding wheel dressing done as per freezed qty 665_Occurance_Before.png
Occurance (After)	Dressing made mandatory for both wheels (Control wheel & Grinding wheel) after model change at Centre less Grinding machine). 665_Occurance_After.png
Outflow (Before)	Single Sampling plan used 665_Outflow_Before.jpg
Outflow (After)	Single Sampling plan to be replaced with double sampling plan 665_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All similar models

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	517

Reason for submission	Found ok