QFR No - 8000862169

Defect Details

NC No.	8000862169
NC Date	07/02/2024
NC Submission Date	
Part No.	520AT00302
Part Name	BEARING CONE ELIMINATOR
Supplier Name & Code	100264-SAI INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-SCALING OBSERVED

1. Problem Description

Defect Description	Scaling observed
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	186
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	info@sai-industries.com
Plant Head/CEO Email ID	info@sai-industries.com
MD Email ID	umesh.honap@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	800	640	0	1000	640	3080
Check Qty	800	640	0	1000	640	3080
NG Qty	186	0	0	0	0	186

Action taken on NG part

Scrap	0
Rework	186
Under Deviation	0

Containment Action
In ETL found 186 nos. Scaling on Track side face out of 800 Nos. Logistic 640 nos. finish stock verify to Scaling on Track side face found all are ok & marked green dot on o/d 51 In SAI - 1000 nos. finish stock for inhouse verification found all are ok.Mark green dot on o/d 51

3. Process Flow

Process Flow Description
Blank - Drilling - CNC Ist set up - CNC IInd set up - Heat Treatment - Vibro Finishing/Cleaning - O/D Grinding - I/D & Hard Track - Final Inspection - Packing & Dispatch.

4. Process Details

Process / Operation	Vibro Finishing/Cleaning
Outsource	No
Machine / Cell	Vibro
Machine / Cell No.	SI/VB/01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Uneven media(Media warn out) use in vibro cleaning.	Verify Media Size & Shape	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Scaling on Track side face observed
Why 2	In Line Inspection not addressed the above defect.
Why 3	Some parts clean properly some part not clean.
Why 4	Uneven media(Media warn out) use in vibro cleaning.
Why 5	
Root Cause (Occurance)	Uneven media(Media warn out) use in vibro cleaning.

Root Cause Analysis (Outflow)

Why 1	Scaling on Track side face observed.
Why 2	In Final Inspection not detect the above defect.
Why 3	May by mix up in ok qty.
Why 4	Separated parts mix up in ok part during packing stage.
Why 5	
Root Cause (Outflow)	Separated parts mix up in ok part during packing stage.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	On job training given to final inspection person as well as packing person. Do not mix up without vibro cleaning part in ok qty. Display OK not ok photo.	Santosh/Tajane	08/02/2024	08/02/2024	Completed
Occurance	We are already implementing Vibro cleaning, which is extra operation after heat treatment .	Santosh/Tajane	08/02/2024	08/02/2024	Completed
Occurance	Replaced warn out Media(stone) immediately. Follow Media changed frequency strictly as per revised work instruction.	Santosh/Tajane	08/02/2024	08/02/2024	Completed
Outflow	OK component marked with Green dot mark on O/D 51.	Devendra	08/02/2024	08/02/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NA
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Warn out Media 667_Occurance_Before.jpg
Occurance (After)	New Media 667_Occurance_After.pdf
Outflow (Before)	Withuot Frequency WI 667_Outflow_Before.pdf
Outflow (After)	With Frequency WI 667_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Applicable for all Model

12. Document Review

Documents	WISOP
Specify Other Document	Ok & not ok display

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	