QFR No - 8000862973

Defect Details

NC No.	8000862973
NC Date	14/02/2024
NC Submission Date	
Part No.	F2LY02502B
Part Name	SOCKET HEADED BOLT - RE J1A
Supplier Name & Code	100846-SANGKAJ ENGINEERING PVT.LTD.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-PLATING THICKNESS FOUND NOT OK

1. Problem Description

Defect Description	Pinch bolt - J1C plating thickness found 6 to 8 microns against 8 microns minimum
Detection Stage	Customer End
Problem Severity	Aesthetic
NG Quantity	6200
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	sepl.quality@sangkaj.com
Plant Head/CEO Email ID	steel@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	6200	0	0	0	0	6200
Check Qty	6200	0	0	0	0	6200
NG Qty	6200	0	0	0	0	6200

Action taken on NG part

Scrap	0
Rework	6200
Under Deviation	0

Containment Action
rework done on all part

3. Process Flow

Process Flow Description
Wire Draw - Cold Forging - Thread Rolling - HT - Plating - F.I. - Dispatch.

4. Process Details

Process / Operation	Plating
Outsource	Yes
Machine / Cell	Plating
Machine / Cell No.	Auto Line

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Due to excess loading in a batch qty	Cause Verfied	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10 Nos

7. Root Cause Analysis (Occurance)

Why 1	Thickness at lower side
Why 2	Current fluctuation observed
Why 3	Current not properly distributed
Why 4	Due to excess loading in a batch qty (50 Kg against 40 Kg)
Why 5	Manually batch quantity taken on weighting scale
Root Cause (Occurance)	Manually batch quantity taken on weighting scale

Root Cause Analysis (Outflow)

Why 1	Plating Thickness at lower side
Why 2	Not detected at final inspection.
Why 3	Measurement variation observed.
Why 4	in DFT meter plating thickness not get proper reading.
Why 5	
Root Cause (Outflow)	in DFT meter plating thickness not get proper reading.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Online weighting interlock system implementation	Krishna Industries	15/03/2024	07/03/2024	Completed

Outflow	Now every batchwise samples is getting checked by XRF .	Krishna Industries	16/02/2024	16/02/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Now every batch-wise samples is getting checked by XRF
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	30 Nos

10. Evidance of Countermeasure

Occurance (Before)	Manualy batch quantity taken on weighting scale 679_Occurance_Before.pptx
Occurance (After)	We are implementing the online weighting interlock system with over load alarm /buzzer 679_Occurance_After.pptx
Outflow (Before)	We checked batch wise thickness on in house thickness tester 679_Outflow_Before.xlsx
Outflow (After)	Now every batch wise samples is getting checked by XRF. 679_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Plated Parts.

12. Document Review

Documents	ControlPlan, PokayokeCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	567
Reason for submission	Found ok