QFR No - 8000870319

Defect Details

NC No.	8000870319
NC Date	05/04/2024
NC Submission Date	
Part No.	550LG06702
Part Name	SEAT PIPE-(HMS-30 & HMP-30)
Supplier Name & Code	100929-HARSHAD ENGINEERING COMPANY
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	THREADING NOT OK-HALF THREAD

1. Problem Description

Defect Description	SEAT PIPE M8 X 1.25 -6G HALF THREAD FOUND AGAINST 14 MIN. REQUIRED
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	3msmklh13r5mlf2ikgv3wqbt.jpg

Supplier Communication Details

Quality Head Email ID	qaharshad@miteshauto.com
Plant Head/CEO Email ID	sjkadam@miteshauto.com
MD Email ID	auto.mitesh@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4100	0	0	7100	4250	15450
Check Qty	4100	0	0	7100	4250	15450
NG Qty	4	0	0	0	0	4

Action taken on NG part

Scrap	4
Rework	0
Under Deviation	0

Containment Action
100 % sorting done for ETL End, HEC WIP & FG material

3. Process Flow

Process Flow Description
Cutting-Draw-Forging(Head Formation)-Rough Grinding-CNC (Head, Boring & Tapping)-Punching-Finish Grinding-Final Inspection-Packing-Dispatch

4. Process Details

Process / Operation	Tapping
Outsource	No
Machine / Cell	Tapping
Machine / Cell No.	SPM2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	NA	NA	X
Machine	Limit switch malfunction	Observed Limit switch Malfunction	O
Man	NA	NA	X
Method	NA	NA	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	IS2500

7. Root Cause Analysis (Occurance)

Why 1	Tap not perform for complete threading length
Why 2	Tap not insert/Pass up to full length
Why 3	Tapping unit not work up to decided 15.0mm length
Why 4	At tapping operation station limit switch malfunction happen
Why 5	Limit switch malfunction happen
Root Cause (Occurance)	Limit switch malfunction happen

Root Cause Analysis (Outflow)

Why 1	Half Threading
Why 2	after tapping operation parts are checked on sampling basis
Why 3	From initial stage it is carried out
Why 4	Skip from Final Inspection
Why 5	Not detected
Root Cause (Outflow)	Not detected

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Limit switch malfunction happen	D.D. Jopale	28/04/2024	10/04/2024	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	Limit switch malfunction while operating 730_Occurance_Before.jpg
Occurance (After)	Limit switch replace by new one 730_Occurance_After.jpg
Outflow (Before)	Parts checked for tapping presence 730_Outflow_Before.jpg
Outflow (After)	Parts checked to ensure complete tapping 730_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All SPM & Tapping Machines

12. Document Review

Documents	ControlPlan
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	