QFR No - 8000871813

Defect Details

NC No.	8000871813
NC Date	19/04/2024
NC Submission Date	
Part No.	F1GN01102B
Part Name	MAIN SPRING K86A
Supplier Name & Code	101236-SUMA SPRINGS PRIVATE LIMITED
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	DIAMETER OVER SIZE-OD MORE ISSUE

1. Problem Description

Defect Description	K86 MAIN SPRING OD MORE ISSUE
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	6
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qc@sumasprings.com
Plant Head/CEO Email ID	vp@sumasprings.com
MD Email ID	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	0	0	7200	0	9200
Check Qty	2000	0	0	7200	0	9200
NG Qty	6	0	0	0	0	6

Action taken on NG part

Scrap	6
Rework	0
Under Deviation	0

Containment Action
.Quality Alert prepared and awareness created among Internal CFT team (Production, QC/QA,Stores,Despatch,QC Inspectors) Segregation Process initiated at entire Pipeline to identify the NG part and to prevent the NG part to reach to customer

3. Process Flow

Process Flow Description
COIL+TEM+GRIN+SHOT+SCR+TEM+OILING +PACK+DESPATCH

4. Process Details

Process / Operation	COILING
Outsource	No
Machine / Cell	COILING MACHINE
Machine / Cell No.	COILING M/C

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Coiling	Set Setup part mix up during process	O
Method	Random sampling method	verified and found Sampling ineffective	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%

7. Root Cause Analysis (Occurance)

Why 1	OD more
Why 2	Set up part kept in the regular bin
Why 3	previous shift rejections not cleared
Why 4	
Why 5	
Root Cause (Occurance)	previous shift rejections not cleared

Root Cause Analysis (Outflow)

Why 1	NG Parts Not found during PDI
Why 2	PDI done as per AOI
Why 3	PDI inspection not effective
Why 4	
Why 5	
Root Cause (Outflow)	PDI inspection not effective

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Instruction provided that Daily 4.30 Pm all rejections to be monitored and moved to scrap yard & Set up rejections only kept in the red bin	Vinay	11/04/2024		Completed
Outflow	Sampling quantity % will be increase by 50% more than the existing lot qty at PDI	Moulidharan	10/04/2024	10/04/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling quantity % will be increase by 50% more than the existing lot qty at PDI
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50%

10. Evidance of Countermeasure

Occurance (Before)	previous shift rejections not cleared 751_Occurance_Before.pdf
Occurance (After)	Instruction provided that Daily 4.30 Pm all rejections to be monitored and moved to scrap yard & Set up rejections only kept in the red bin 751_Occurance_After.pdf
Outflow (Before)	PDI inspection not effective 751_Outflow_Before.pdf
Outflow (After)	Sampling quantity % will be increase by 50% more than the existing lot qty at PDI 751_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	F1GN011020

12. Document Review

Documents	
Specify Other Document	Q_ alert - Scrap reg

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	