QFR No - 8000873485

Defect Details

NC No.	8000873485
NC Date	06/05/2024
NC Submission Date	
Part No.	F2LG03302B
Part Name	SEAT PIPE (B104E
Supplier Name & Code	100648-JOTIBA TECHNOLOGIES PVT.LTD.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-GROOVE OD RUNOUT MORE

1. Problem Description

Defect Description	GROOVE OD RUNOUT MORE
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	52
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	accjotiba@gmail.com
Plant Head/CEO Email ID	sanghavi.rajesh@sanghavigroup.co.in
MD Email ID	jotibatech@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	450	0	0	0	0	450
Check Qty	450	0	0	0	0	450
NG Qty	52	0	0	0	0	52

Action taken on NG part

Scrap	52
Rework	0
Under Deviation	0

Containment Action
Boring set-up approval time inspect thread runout wrt groove diameter, if runout is ok then start boring operation.

3. Process Flow

Process Flow Description
10.Raw material Inspection ,20.Parting Off 30.Chamfer,40.Weighing,50.Draw Forging,60.Hex Forging,70.Rough Grinding,80.Collar Machining,90.Total length facing and Boring,100.Piercing,110.DF Hole chamfering,120. Compression Hole chamfering, 130.ID Reaming,140.Tapping,150.Finish Grinding,160.Final Inspection,170.ID Cleaning,180.Ultrasonic Cleaning,190.Apply antirust oil,200.Packing and Dispatch

4. Process Details

Process / Operation	Total length facing and Boring
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	CNC01, CNC02, CNC05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Job slip in holding split collet due to collet wear out.	Collet condition is found ok.	O
Machine	Axial runout of job and spindle body above 0.1 mm.	Found runout within 0.05 mm	O
Man	Chuck jaw was break due to minor accident on machine.	Operator not inspect jaw condition	X
Method	Thread runout not inspect at boring setup approval time.	Thread runout inspect at tapping operation done.	X
Material	Boring time ID runout excess.	Boring ID runout found 0.12 mm.	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	Sampling

7. Root Cause Analysis (Occurance)

Why 1	Thread runout wrt groove diameter is more
Why 2	line mark on boring face.
Why 3	insert corner break.
Why 4	boring time job not clamp properly.
Why 5	chuck jaw was break due to minor accident on the machine but this time jaw condition not inspect.
Root Cause (Occurance)	Chuck jaw was break that why job not clamp properly and insert corner is break.

Root Cause Analysis (Outflow)

Why 1	Thread runout wrt groove diameter is more.
Why 2	Excess runout piece not detect at final inspection side.
Why 3	due to inspect runout at final inspection sampling basis.
Why 4	
Why 5	
Root Cause (Outflow)	Runout inspection frequency is low at final inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Runout sampling inspection frequency increase at final inspection time.	Gopinath Gore	17/06/2024	17/06/2024	Completed
Occurance	Start inspection at time boring done and also start daily chuck jaw condition.	Gaurav Mhaske	11/05/2024	11/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	start inspection at time of boring setup approval.
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	Sampling.

10. Evidance of Countermeasure

Occurance (Before)	Thread runout wrt groove diameter inspection not done boring setup approval time. 778_Occurance_Before.xlsx
Occurance (After)	Thread runout wrt groove diameter inspection done boring setup approval time and CNC Chuck jaw inspection done. 778_Occurance_After.xlsx
Outflow (Before)	Before Sampling plan inspection frequency. 778_Outflow_Before.xlsx
Outflow (After)	Revise sampling plan frequency change. 778_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	No

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	OK