QFR No - 8000873486

Defect Details

NC No.	8000873486
NC Date	06/05/2024
NC Submission Date	
Part No.	F2LG03702B
Part Name	SEAT PIPE (K1 UG)
Supplier Name & Code	100648-JOTIBA TECHNOLOGIES PVT.LTD.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-THREADING INCOMPLETE

1. Problem Description

Defect Description	THREADING INCOMPLETE
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	1
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	1050	0	0	1200	2000	4250
Check Qty	1050	0	0	1200	2000	4250
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
Model wise marking on spacer plate of job stopper.

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	140.Tapping
Outsource	No
Machine / Cell	Tapping
Machine / Cell No.	Tapping 01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Tap use excess compare to tap life set that why wear out coating of tap.	Set interlock of machine tap life.	O
Tool	No model wise marking on spacer plate.	Not inspect spacer plate size.	O
Machine	PM not done on time.	PM done on time.	O
Material	Input size of bore diameter undersize.	Input size of bore is found ok.	O
Man	Not inspect spacer plate before assembly of stopper.	Operator knows only who to assembly of stopper.	X
Method	There is no cross verification of after setup ok or not ok	Operator not know how to check setup ok or Not ok.	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Half tapping part produce.
Why 2	While set-up changing time wrong width spacer plate use.
Why 3	Operator not check width of spacer plate during set-up time.
Why 4	
Why 5	
Root Cause (Occurance)	No model wise marking on spacer plate of stopper.

Root Cause Analysis (Outflow)

Why 1	Half tapping part not detect at final inspection.
Why 2	Inspect part at final inspection is visually.
Why 3	Available thread plug gauge for inspection thread but length GO thread gauge is less.
Why 4	No special gauge for inspection half tapping job.

Why 5	
Root Cause (Outflow)	No special gauge for inspection of half tapping job.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	After setup change cross check setting is ok or not ok use setting block.	Gopinath Gore	06/06/2024	03/06/2024	Completed
Occurance	Model wise mark on spacer plate.	Gopinath Gore	08/05/2024	08/05/2024	Completed
Outflow	Add special gauge for inspection with 100% identification mark on job.	Gopinath Gore	11/05/2024	11/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection with identification mark on job and add special gauge for inspection of tapping.
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	sampling

10. Evidance of Countermeasure

Occurance (Before)	No identification mark on spacer plate of stopper. 779_Occurance_Before.xlsx
Occurance (After)	Identification mark on spacer plate of stopper. 779_Occurance_After.xlsx
Outflow (Before)	Inspect part as per sampling plan and visually. 779_Outflow_Before.xlsx
Outflow (After)	100% Visually inspection with identification mark and use special gauge for checking. 779_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan
Specify Other Document	Special Gauge

13. Effectiveness Of Action

Reviewed Quantity	150
Reason for submission	Ok