QFR No - 8000873489

Defect Details

NC No.	8000873489
NC Date	06/05/2024
NC Submission Date	
Part No.	F2LG05302B
Part Name	SEAT PIPE - ABWB ENDURO
Supplier Name & Code	100929-HARSHAD ENGINEERING COMPANY
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-THREAD MISSING

1. Problem Description

Defect Description	THREAD MISSING
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	

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	500	200	0	0	0	700
Check Qty	500	200	0	0	0	700
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
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.	164

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Skip While Visual Inspection	Skip While Inspection	X
Machine	Limit Switch setting not ok or Malfunction while working	Limit switch malfunction while working	X
Tool	Tap Worn out or damage	Tap found in OK Condition	O
Man	Inspection or Checking Skipped	As per Sampling plan parts checked by Inspectors	O
Material	Wrong grade material Used	Material grade is ok As per Drawing	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Threading missing
Why 2	During tapping operation tap not performed threading
Why 3	Threading spindle limit switch not working properly
Why 4	Threading limit switch mal-function
Why 5	
Root Cause (Occurance)	Threading limit switch mal-function

Root Cause Analysis (Outflow)

Why 1	Threading missing
Why 2	100% parts not checked at final inspection stage
Why 3	Parts checked on sampling basis
Why 4	
Why 5	
Root Cause (Outflow)	Parts checked on sampling basis

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	In PM check sheet point added for Limit switch checking	MMS	15/05/2024	17/05/2024	Completed
Occurance	Limit switch changed with new one	Production team	10/05/2024	12/05/2024	Completed
Outflow	100% parts visually checked at final inspection	QA Team	03/05/2024	08/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% parts checked at final inspection stage with identification
Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Limit switch mal function 782_Occurance_Before.pdf
Occurance (After)	Limit switch changed and in PM check sheet point added 782_Occurance_After.pdf
Outflow (Before)	Parts Checked on sampling basis 782_Outflow_Before.jpg
Outflow (After)	100% Parts Checked for threading presence 782_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	For all model of seat pipe

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	CP, PM checksheet

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	ok