QFR No - 8000873537

Defect Details

NC No.	8000873537
NC Date	06/05/2024
NC Submission Date	
Part No.	F2DZ15510B
Part Name	FORK BOLT -ACJA FF
Supplier Name & Code	100505-A B AUTOCOMPONENTS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-MIX-UP

1. Problem Description

Defect Description	Mix-up
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	93
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	headqaabauto@gmail.com
Plant Head/CEO Email ID	kamalabautocomponent@gmail.com
MD Email ID	abautocomponent@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	500	0	0	300	0	800
Check Qty	500	0	0	300	0	800
NG Qty	93	0	0	0	0	93

Action taken on NG part

Scrap	0
Rework	93
Under Deviation	0

Containment Action
Not an regular production, Existing FG verified and segregated.

3. Process Flow

Process Flow Description
RM inward-Cutting-Turining-Milling-Final quality-Dispatch

4. Process Details

Process / Operation	Turning & Milling
Outsource	No
Machine / Cell	CNC & VMC
Machine / Cell No.	CNC20 & VMC2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Similar part production	13510 & 15510 same time FG	O
Man	Unaware & not inspected	Similarity in visual, only length got vary.	O
Tool	Tool offset error	Diffrent parts	O
Machine	Mixup in the work station	Same trays used	O
Material	Same Grade material issued	Same material	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	1-100

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-MIX-UP
Why 2	Both Regular (F2DZ15510B) & Development part (F2DZ12810B) Anodizing done same location.
Why 3	As per customer demand Anodizing done the regular part as well as development part.
Why 4	For regular parts dispatch as per the schedule, during development stage Only 5 to 10 samples are dispatched, Balance parts are sent it later.
Why 5	As per customer requirement.
Root Cause (Occurance)	Parts mix up happened during Anodizing stage.

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-MIX-UP
Why 2	Both Regular (F2DZ15510B) & Development parts (F2DZ12810B) are kept at final inspection area.
Why 3	Before dispatching final inspection to be done.
Why 4	As per ISO / IATF standard requirement.
Why 5	To supply the defect free products.
Root Cause (Outflow)	Due to lack of knowledge & confusion parts got mixed up.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Plan the diffrent interval for machining.	Planning	20/05/2024	10/05/2024	Completed
Outflow	Plan the dedicated person to pack the FG`s	Quality head	20/05/2024	10/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	If similarity in visual, Before packing verify the diameter and length of the parts.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Machine Plan similar parts same intervals 789_Occurance_Before.xlsx
Occurance (After)	Machine plan deffrent intervals. 789_Occurance_After.xlsx
Outflow (Before)	Without part Weight . 789_Outflow_Before.xlsx
Outflow (After)	With part weight.CP AND FMEA UPDATED 789_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	N/A

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	70
Reason for submission	Root cause analysis can do better