QFR No - 8000873540

Defect Details

NC No.	8000873540
NC Date	06/05/2024
NC Submission Date	
Part No.	550PC09107
Part Name	UNDER BKT M/C (CT100)
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-ID UNDERSIZE

1. Problem Description

Defect Description	ID UNDERSIZE
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	6
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	irfan@sangkaj.com
Plant Head/CEO Email ID	steel@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	320	0	0	0	0	320
Check Qty	320	0	0	0	0	320
NG Qty	6	0	0	0	0	6

Action taken on NG part

Scrap	6
Rework	0
Under Deviation	0

Containment Action
checked all ETL end and pipe line material

3. Process Flow

Process Flow Description
forging inward-pre drilling- ruff boring-5.1 drill-boss drilling lug milling- slitting-counter drilling-M6 tapping- M8 tapping- final inspection.

4. Process Details

Process / Operation	ruff boring
Outsource	No
Machine / Cell	under bracket semi finish line
Machine / Cell No.	ruff boring

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Inspector did not follow the SOP for inspection	Final inspection report is evident	O
Material	Burr generated at rough boring stage	Verified burr not found	O
Method	master setting ring not ok	verified master setting ring having ovality and tapper	X
Tool	Tool life monitoring not effective	Tool life monitoring found not as per plan	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	28 mm Center bore ID undersize produced
Why 2	due to tool wear tool size gets undersize
Why 3	tool not changed at defined life
Why 4	No any alarm/information to operator after life over
Why 5	
Root Cause (Occurance)	No any alarm/information to operator after life over

Root Cause Analysis (Outflow)

Why 1	28 mm Center bore ID undersize found at customer end.
Why 2	28 mm Center bore ID undersize not detected at final inspection.
Why 3	Air gauge master ring found ovality and tapper before calibration due date.
Why 4	
Why 5	
Root Cause (Outflow)	Air gauge master ring found ovality and tapper before calibration due date.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Interlock mechanism for tool life on boring SPM.	Mr.Sayyed	10/06/2024	11/06/2024	Completed
Outflow	Revise calibration frequency from 1 year to 6 Month	Mr.Sayyed	16/05/2024	15/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	Revise calibration frequency from 1 year to 6 Month
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)	air gauge master setting ring found ovality and tapper 791_Occurance_Before.jpg
Occurance (After)	ok master setting ring provided 791_Occurance_After.jpg
Outflow (Before)	Manual tool life monitoring 791_Outflow_Before.jpg
Outflow (After)	Part counter with buzzer alarm implemented 791_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	SPM ruff boring Machine

12. Document Review

Documents	WISOP
Specify Other Document	work instruction

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok