QFR No - 8000874016

Defect Details

NC No.	8000874016
NC Date	11/05/2024
NC Submission Date	
Part No.	F20510907B
Part Name	UNDER BRACKET ASSEMBLY K19 DRUM FF
Supplier Name & Code	100297-BAJAJSONS LTD
ETL Plant	1126-ETL Pantnagar
Defect Details	THREADING NOT OK-THREAD LENGTH UNDERSIZE

1. Problem Description

Defect Description	Thread Length Undersize observed 10.50 to 11.20 against the specs. 12+1.0
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	4
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	anuj.saxena@bajajsons.com
Plant Head/CEO Email ID	sahadev.singh@bajajsons.com
MD Email ID	sanjay.bajaj@bajajsons.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1500	0	0	400	2250	4150
Check Qty	1500	0	0	400	2250	4150
NG Qty	4	0	0	0	0	4

Action taken on NG part

Scrap	4
Rework	0
Under Deviation	0

Containment Action
All material has been segregated at ETL end as well as Bajajsons Roorkee end.

3. Process Flow

Process Flow Description
1-Parting 2-Flaring & Reducing 3-Bush Fitting 4-Bush welding 5-CNC turning 6-Grinding 7-Threading 8-To Assembly

4. Process Details

Process / Operation	Threading
Outsource	No
Machine / Cell	TDR-11/Shaft Line
Machine / Cell No.	TDR-11

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator.	Unskilled operator	X
Machine	Part not proper butting with stopper.	Dust particles stick to stopper face at TDR	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Threading process was NG
Why 2	Proper part feeding was not ok
Why 3	Part does not rest at stopper face
Why 4	Dust particles stick to stopper face at TDR
Why 5	
Root Cause (Occurance)	Dust particles stick to stopper face at TDR

Root Cause Analysis (Outflow)

Why 1	Thread length u/s
Why 2	Only sampling inspection being done at final inspection for thread length checking inspection.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	100% Inspection not done at final inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	OPL has been displayed at final inspection. 100% inspection started at FI to check thread length by visually.	Mr. Vikash	23/05/2024	22/05/2024	Completed
Occurance	Training has been given to operator that feeding the part after remove the dust particles at stopper	Mr. Mukesh chauchan	25/05/2024	22/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Visually inspection started
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)	Stopper Pic & On Job Training 797_Occurance_Before.jpg
Occurance (After)	Stopper Pic & On job Training 797_Occurance_After.jpg
Outflow (Before)	No OPL displayed 797_Outflow_Before.pdf
Outflow (After)	OPL 797_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	B104D/B105L

12. Document Review

Documents	ControlPlan
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	OK