QFR No - 8000874414

Defect Details

NC No.	8000874414
NC Date	15/05/2024
NC Submission Date	
Part No.	080FA04033
Part Name	FORK PIPE MACHINED
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-THREADING NG

1. Problem Description

Defect Description	THREADING NG
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	14
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	aslam@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	800	0	0	0	0	800
Check Qty	800	0	0	0	0	800
NG Qty	14	0	0	0	0	14

Action taken on NG part

Scrap	14
Rework	0
Under Deviation	0

Containment Action
Segregation done at ETL end.

3. Process Flow

Process Flow Description
Tube RM inward - Induction hardening - CNC 1st - CNC 2nd - Drilling - Visual inspection - Bundling - Dispatch

4. Process Details

Process / Operation	CNC-1st
Outsource	No
Machine / Cell	CNC-05
Machine / Cell No.	CNC-05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	ID of tube is more than TRD ID	Inward inspection done	X
Method	Tool position disturbed	Every thing is controlled by program	X
Man	operator did not follow the measuring procedure	Hourly inspection report is updated	X
Tool	insert worn-out.	Micro program is available.	O
Machine	Turret bearing worn out	PM done on time	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10:500

7. Root Cause Analysis (Occurance)

Why 1	Fork pipe machined -THREADING NG (Go gauge not qualifying)
Why 2	Insert worn out.
Why 3	insert worn out before defined life in micro program
Why 4	Tool life defined is not ok.
Why 5	Validation for tool life is in adequate.
Root Cause (Occurance)	Validation for tool life is in adequate.

Root Cause Analysis (Outflow)

Why 1	Fork pipe machined -THREADING NG (Go gauge not qualifying)
Why 2	Inspection done as per defined frequency ,i.e 10:500.
Why 3	Frequency for inspection is less in CP.
Why 4	CP for final inspection is inadequate.
Why 5	
Root Cause (Outflow)	CP for final inspection is inadequate.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Re-validation to be done for tool life.	Mr. Krushna Phuke	30/05/2024	31/05/2024	Completed
Outflow	CP to be updated for inspection frequency.	Mr. Aslam Shaikh	30/05/2024	31/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Frequency of inspection changed from 10:500 to 50:500.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50:500

10. Evidance of Countermeasure

Occurance (Before)	CNC program before - tool life defined as per previous experience only 813_Occurance_Before.pdf
Occurance (After)	CNC program after- Tool life defined as per validation report. 813_Occurance_After.pdf
Outflow (Before)	CP - Before (inspection frequency 10:500) 813_Outflow_Before.pdf
Outflow (After)	CP - After (inspection frequency increased 10:500 to 50:500 813_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All similar models.

12. Document Review

Documents	ControlPlan
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	Accepted