QFR No - 8000874506

Defect Details

NC No.	8000874506
NC Date	16/05/2024
NC Submission Date	
Part No.	520DZ00212
Part Name	FORK BOLT K60-(DS181012)
Supplier Name & Code	100189-SANGKAJ STEEL PVT LTD.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-DIMN. 7.5 UNDERSIZE - (4.0+0.1) + (3.5)

1. Problem Description

Defect Description	DIMN. 7.5 UNDERSIZE - (4.0+0.1) + (3.5)
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	402
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qualityassurance@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	1600	0	0	800	1000	3400
Check Qty	1600	0	0	800	1000	3400
NG Qty	402	0	0	36	0	438

Action taken on NG part

Scrap	436
Rework	0
Under Deviation	0

Containment Action
All material at ETL End & at Sangkaj Steel is segregated, Defective Qty is scrapped.

3. Process Flow

Process Flow Description
RM Inward-RM Inward inspection-Traub Machining(Semi-finish Blank)-Grinding-Tapping-Thread Rolling-Plating-Final Inspection-Packing & dispatch

4. Process Details

Process / Operation	Traub Machining
Outsource	Yes
Machine / Cell	Traub machine
Machine / Cell No.	04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Tool Worn Out	Worn Out Tool Doesn`t Cause huge Variation	X
Man	New or Unskilled operator	Experienced & Skilled Operator is deputed for production	X
Material	Input Material not ok	Part manufactured through Continuous bar Feeding & RM Bar Found OK	X
Method	Inadequate Inspection Method	No Checkpoint for the Parameter in the Inprocess & in Final Inspection.	O
Machine	Variation due to Machine	Machine Condition found ok	X
Tool	Wrong Tool Used	part produced by using another tool used for similar category Parts	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	50:500

7. Root Cause Analysis (Occurance)

Why 1	7.50 mm Dimension found undersize
Why 2	Wrong forming Tool used for machining
Why 3	Forming Tools not identified with Part Names.
Why 4	Tool Identification not mentioned in the WI
Why 5	
Root Cause (Occurance)	Tool Identification not mentioned in the WI

Root Cause Analysis (Outflow)

Why 1	7.50 mm Dimension found undersize
Why 2	Defective Parts Skipped from Inspection.
Why 3	During Inspection this parameter is not checked
Why 4	Verification of this parameter not Included in Inspection Checklists.
Why 5	Inspection Checklists are inadequate.

Root Cause (Outflow)	Inspection Checklists are Inadequate

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	7.50mm Dimension Verification added in Following Checklists- 1. Supplier In-process Inspection Report, 2.Supplier PDIR Report, 3.Sangkaj Steel`s Inward Inspection Report 4.PDIR	Mr. Anil Chaudhari	03/06/2024	03/06/2024	Completed
Occurance	1.Forming Tools are identified with Part names. 2.Setting WI Updated, it is mentioned in the WI that Every Tool should have Part Names on them.	Mr. Anil Chaudhari	03/06/2024	03/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Dimension 3.50mm Added In Supplier PDIR, Supplier In-process Inspection Report, Inward Inspection & PDI Report of Sangkaj Steel. Inspection will be Followed on Sampling Basis.
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50:500

10. Evidance of Countermeasure

Occurance (Before)	No Identification of Forming Tool with part Names 809_Occurance_Before.pptx
Occurance (After)	Part Names Engraved on the Tool with manual Engraving Machine 809_Occurance_After.pptx
Outflow (Before)	No Checkpoint Available for this Dimension 809_Outflow_Before.pptx
Outflow (After)	Checkpoint added in the PDIR, Hourly inspection and Inward Inspection Report 809_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Fork Bolt JD, 5TSF

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	PDIR

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	Judgment wrong Occurrence side root cause can do better