QFR No - 8000874661

Defect Details

NC No.	8000874661
NC Date	16/05/2024
NC Submission Date	
Part No.	F2DZ10910B
Part Name	FORK BOLT Ø33 SPD
Supplier Name & Code	100002-CAST AND ALLOYS
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	THREADING NOT OK-THREADE M12X16H UNDER SIZE

1. Problem Description

Defect Description	M12 Threading under size
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	115
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	niyati@cast-alloys.com
Plant Head/CEO Email ID	shiv.k@cast-alloys.com
MD Email ID	dipen@cast-alloys.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1680	0	0	0	0	1680
Check Qty	1564	0	0	0	0	1564
NG Qty	116	0	0	0	0	116

Action taken on NG part

Scrap	116
Rework	0
Under Deviation	0

Containment Action
100 % Checked 3 Lots after Complaint

3. Process Flow

Process Flow Description
At Machining Stage

4. Process Details

Process / Operation	Machining
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	CNC

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Untrained Operator	Skilled Manpower Available	X
Man	SOP not Followed	Part Made as per SOP	X
Machine	Inadequate Machine Parameters	Machining Parameters are Verified and Found as per Control Plan	X
Tool	Tool Wear Out	Tool Condition Found Satisfactory	X
Tool	Wrong Tool Selection	Tooling Used as per Process Parameter Checksheet	X
Man	Incorrect Tool Offseting	Operator Mistake in Providing Offset for Tool	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 / Batch

7. Root Cause Analysis (Occurance)

Why 1	M12X1 6 H Gauge Under Size
Why 2	During Machining .
Why 3	Incorrect Tool Offset .
Why 4	Operator Error Mistake During Offset Setting .
Why 5	
Root Cause (Occurance)	Operator Error Mistake During Offset Setting .

Root Cause Analysis (Outflow)

Why 1	M12X1 6 H Gauge Under Size
Why 2	Missed at Final Inspection stage`
Why 3	Sampling Base Inspection at FI Stage
Why 4	
Why 5	
Root Cause (Outflow)	Sampling Base Inspection at FI Stage

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. Retraining Provided to Machining Operator. 2. Supervisor to verify the part after providing any offset .	Naitik Vachani	19/05/2024	19/05/2024	Completed
Outflow	100 % Inspection Started at Machining Stage & At Final Inspection Stage Three Lots to be 100% Verified	Nitin Chaudhari	19/05/2024	19/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Inspection Started at Machining Stage
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 / Batch

10. Evidance of Countermeasure

Occurance (Before)	
Occurance (After)	
Outflow (Before)	
Outflow (After)	

11. Horizontal Deployment

Horizontal Deployment Required	
Applicable Machine / Model / Plant	

12. Document Review

Documents	
Specify Other Document	

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	