QFR No - 8000877797

Defect Details

NC No.	8000877797
NC Date	11/06/2024
NC Submission Date	
Part No.	F2LG05402B
Part Name	SEAT PIPE - J1A & J1D
Supplier Name & Code	100539-N P ENTERPRISES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-ID STEP

1. Problem Description

Defect Description	ID STEP
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	3
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@npcindustries.in
Plant Head/CEO Email ID	anand@npcindustries.in
MD Email ID	ajay@npcindustries.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2080	46000	0	0	0	48080
Check Qty	2080	46000	0	0	0	48080
NG Qty	3	23	0	0	0	26

Action taken on NG part

Scrap	26
Rework	0
Under Deviation	0

Containment Action
Segregate all material at both end

3. Process Flow

Process Flow Description
Process Flow Description 1.0 Raw Material 2.0 Cutting 3.0 Drawing 4.0 Head Formation 5.0 Rough Grinding 6.0 Punching 7.0 CNC Head Turning 8.0 CNC Boring & Facing 9.0 Tapping 10.0 Chamfering 11.0 ID Deburring 12.0 Finish Grinding 13.0 Final Inspection 14.0 Cleaning 15.0 Oiling 16.0 Packing &Dispatch.

4. Process Details

Process / Operation	Forging
Outsource	No
Machine / Cell	Header
Machine / Cell No.	MDM-8

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Operator negligence	Operator found to be non negligent	O
Machine	Non detection of material unclear in ID at final Inspection	Material unclear in ID could not be detected at final inspection	X
Tool	Damage of Pin at Forging	Pin was found to be damaged which lead to accumulation of material in ID	X
Machine	Variation in Forging machine	No variation in Forging machine found	O
Material	Material composition not OK	Material composition found to be OK	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Step in ID
Why 2	accumulation of material in ID
Why 3	Forging Pin got damaged
Why 4	Miss alignment of PC clamping finger on the forging machine.
Why 5	The spring`s clamping finger was loose.
Root Cause (Occurance)	The spring`s clamping finger was loose.

Root Cause Analysis (Outflow)

Why 1	Step in ID
Why 2	Could not be detected at final inspection
Why 3	ID step checkpoint not available at final inspection
Why 4	
Why 5	
Root Cause (Outflow)	ID step checkpoint not available at final inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Sampling Inspection to started with the plug gauge at the final inspection.	Mr. Ankush	15/06/2024	12/06/2024	Completed
Occurance	clamping finger Inspection checkpoint to be added in Daily machine checksheet.	Mr. Princ	15/06/2024	14/06/2024	Completed
Occurance	Quality Alert to be displayed in Forging Shop	Mr. Prince	12/06/2024	11/06/2024	Completed
Outflow	Quality Alert to be displayed at Final Inspection.	Mr. Princ	12/06/2024	11/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	The part should be inspected using a plug gauge and undergo 100% visual inspection.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	As per std

10. Evidance of Countermeasure

Occurance (Before)	clamping finger Inspection was not done at daily basis. 841_Occurance_Before.jpg
Occurance (After)	clamping finger Inspection checkpoint to be added in Daily machine check sheet. 841_Occurance_After.jpg
Outflow (Before)	Only Visual Inspection but Step id checkpoint not available. 841_Outflow_Before.png
Outflow (After)	Sampling Inspection to started with the plug gauge at the final inspection. 841_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Header

12. Document Review

Documents	ControlPlan, PFMEA, JHCheckSheet, InspCheckSheet
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	ok