QFR No - 8000877822

Defect Details

NC No.	8000877822
NC Date	11/06/2024
NC Submission Date	
Part No.	F2DZ03112B
Part Name	FORK BOLT
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-UNCOVER, PEEL OFF, DAMAGE

1. Problem Description

Defect Description	PEEL OFF
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1040	0	0	0	0	1040
Check Qty	1040	0	0	0	0	1040
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
100% SEGGRATION CUSTOMER END AND OUR END

3. Process Flow

Process Flow Description
RAW MATERIAL +PART-OFF CENTER+FORGING +CNC OPERATION IST +CNC OPERATION 2ND+ROLLING+FINAL INSPECTION +PACKING +SURFACE TRATMENT +FINAL INSPECTION+PACKING

4. Process Details

Process / Operation	PLATING
Outsource	Yes
Machine / Cell	TANK NO
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Incorrect temperature and pH levels in the bath can affect the quality of the plating.	Validated and Found Incorrect temperature	X
Material	OILY MATERIAL USE ON PLATING PROCESS	VALIDATION AND FOUND NO OILY	O
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL OK	O
Method	Visual Inspection not effective	Validation and found ok	O
Tool	N/A	N/A	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	NOT AS PER SPECIFICATION-UNCOVER, PEEL OFF, DAMAGE
Why 2	incorrect temperature, current density, or plating time.
Why 3	Incorrect current density can cause uneven plating thickness.
Why 4	Daily not Ensure current density during the electroplating process.
Why 5	
Root Cause (Occurance)	Incorrect temperature, current density, or plating time.

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-UNCOVER, PEEL OFF, DAMAGE
Why 2	No any checked Quality Gate Available After plating
Why 3	only sampling plan according checked only final inspection area
Why 4	Inspection not fix on plated part
Why 5	low skill inspector checked this lot
Root Cause (Outflow)	No any checked Quality Gate Available After plating

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Daily temperature check sheet prepared and control plan add plating parameter	Mr Ganesh MAURYA	20/06/2024	21/06/2024	Completed
Outflow	inspection table arrange near plating area after plating part check 100%	Mr Ganesh maurya	20/06/2024	20/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no change
Inspection Method	Other
Other Inspection Method	visual 100%
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	Sample Siz

10. Evidance of Countermeasure

Occurance (Before)	PM CHECK SHEET NOT UPDATE 848_Occurance_Before.pdf
Occurance (After)	After PM CHECK SHEET UPDATE 848_Occurance_After.pdf
Outflow (Before)	No any checked Quality Gate Available After plating 848_Outflow_Before.xlsx
Outflow (After)	Plating part after currying inspection table provide 848_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	PLATING TANK 3 NO

12. Document Review

Documents	JHCheckSheet
Specify Other Document	PFD

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	5. Problem Analysis - Need all 4M