QFR No - 8000879364

Defect Details

NC No.	8000879364
NC Date	22/06/2024
NC Submission Date	
Part No.	550PC09107
Part Name	UNDER BKT M/C (CT100)
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	THREADING NOT OK-UNDER BKT RUSTY

1. Problem Description

Defect Description	UNDER BKT RUSTY
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	40
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	598	0	0	600	0	1198
Check Qty	598	0	0	600	0	1198
NG Qty	40	0	0	12	0	52

Action taken on NG part

Scrap	0
Rework	52
Under Deviation	0

Containment Action
checked All ETL End and SEPL End stock

3. Process Flow

Process Flow Description
forging inward- pre drilling- ruff boring- 5.1 drilling -boss drilling-lug milling- slitting-counter drilling-M6 tapping-M8 tapping-final inspection-dispatch.

4. Process Details

Process / Operation	Sliiting
Outsource	No
Machine / Cell	Ubkt semifinish line
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Anti rust oil application not done	verified anti rust oil application not done properly	X
Machine	Coolant concentration not as per Cantrol plan	verified coolant concentration not ok as per cantrol plan	X
Method	INSPECTION NOT DONE AS PER SOP	VERIFRIED INSPECTION DONE AS PER SOP	O
Material	raw material receipt rusty	verified material receipt ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos

7. Root Cause Analysis (Occurance)

Why 1	UNDER BKT RUSTY
Why 2	coolant concentration found at not ok as per cantrol plan
Why 3	operator not top-up cutting oil after water refilling
Why 4	unskilled operator
Why 5	
Root Cause (Occurance)	coolant concentration found at not ok as per control plan.

Root Cause Analysis (Outflow)

Why 1	UNDER BKT RUSTY
Why 2	Anti rust oil application not done properly
Why 3	unskilled inspector
Why 4	
Why 5	
Root Cause (Outflow)	skipped form inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	training given to all new unskilled inspector for anti rust oil application.	mr.sonawane	29/06/2024	02/07/2024	Completed
Occurance	after top-up water & cutting oil checking started.	mr.dhage	29/06/2024	02/07/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no change
Inspection Method	Other
Other Inspection Method	visual inspection.
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos

10. Evidance of Countermeasure

Occurance (Before)	coolant concentration not checked after top-up 883_Occurance_Before.jfif
Occurance (After)	coolant concentration checking started after top-up 883_Occurance_After.jfif
Outflow (Before)	anti rust oil application not done properly 883_Outflow_Before.jfif
Outflow (After)	Training given to all inspector for anti rust oil application 883_Outflow_After.jfif

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	N/A

12. Document Review

Documents	WISOP
Specify Other Document	Work Instruction

13. Effectiveness Of Action

Reviewed Quantity	150
Reason for submission	OK