QFR No - 8000879488

Defect Details

NC No.	8000879488
NC Date	22/06/2024
NC Submission Date	
Part No.	F1LG00902B
Part Name	SEAT PIPE -K86A
Supplier Name & Code	100538-NARINDER PARKASH AND CO
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	HOLE BLOCK-TENSION HOLE BLOCK

1. Problem Description

Defect Description	K86 seat pipe tension hole block issue
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	3
Is Defect Repeatative?	Yes
Defect Sketch / Photo	i2z4kjrrzalkbmbwopa4sgmv.gif

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	9000	15600	0	1500	2500	28600
Check Qty	9000	15600	0	0	0	24600
NG Qty	25	36	0	0	0	61

Action taken on NG part

Scrap	0
Rework	61
Under Deviation	0

Containment Action
Checking parts 100% visually for hole block

3. Process Flow

Process Flow Description
1)Cutting 2)Draw 3)Head Formation 4)Punching 5)Rough Grinding 6)CNC Head Turning 7)CNC Boring & Facing 8)Tapping 9)Chamfering 10)Final Grinding 11)Final Inspection 12)Oiling 13)Packing & Dispatch

4. Process Details

Process / Operation	Punching
Outsource	No
Machine / Cell	Power Press
Machine / Cell No.	Punching Deptt

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Skip during inspection	After verification it was observed that parts was skipped during inspection .	X
Material	Wrong grade material used	After verification we found material grade as per std.	O
Method	Operation Miss part mixed	After verification we found there was no chance of mixing	O
Tool	Punch damage	After verification we found punch was damage during running operation.	X
Machine	DF punch stroke length less	It was observed that this is no linkage with the defect	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	2X Smp std

7. Root Cause Analysis (Occurance)

Why 1	Tension hole block found .
Why 2	punch burr/chips was generated in the tension hole
Why 3	tension punch was damaged during in process.
Why 4	Punch setting was loosed
Why 5	
Root Cause (Occurance)	Punch setting was loosed

Root Cause Analysis (Outflow)

Why 1	Tension hole block found .
Why 2	Could not be detected at final inspection
Why 3	Skipped in Sampling inspection
Why 4	
Why 5	

Root Cause (Outflow)	Skipped in Sampling inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Training will be provided to Satter to check the settings after installing the punch and die on the machine.	Mr. Paramjit	25/06/2024	25/06/2024	Completed
Occurance	The condition of the punch and die should be checked by the setter every hour.	Mr. Rajinder	26/06/2024	25/06/2024	Completed
Occurance	Q-alert to be displayed at the Punching station.	Mr. Princ	24/06/2024	22/06/2024	Completed
Outflow	100% inspection to be start at final inspection by pin plug gauge.	Mr. Ankush	25/06/2024	24/06/2024	Completed
Outflow	Q-alert to be displayed at the Final station.	Mr. Princ	24/06/2024	22/06/2024	Completed
Occurance	Punching WI to be updated	Mr. Princ	26/06/2024	25/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection start with pin plug gauge
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Die frequently monitoring checkpoint was not available in the WI. 876_Occurance_Before.jpg
Occurance (After)	The condition of the punch and die should be checked by the setter every hour. this point to be added in WI. 876_Occurance_After.jpg
Outflow (Before)	Sampling plan followed 876_Outflow_Before.jpg
Outflow (After)	Q-alert to be displayed and 100 % inspection to be started at final Q-gate. 876_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	K-86

12. Document Review

Documents	ControlPlan, PMCheckSheet, PFMEA, WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	20000
Reason for submission	Reviewed next 3 lots found ok