QFR No - 8000880024

Defect Details

NC No.	8000880024
NC Date	26/06/2024
NC Submission Date	
Part No.	080FA04433
Part Name	FORK PIPE MACHINED - CT100
Supplier Name & Code	101223-SANGKAJ BRIGHT WIRES PRIVATE L
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	THREADING NOT OK-

1. Problem Description

Defect Description	CT 100 FORK PIPE MACHINED THREADING ISSUE (THREAD PLUG GAUGE GO NOT QUALIFY)
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	165
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	mayursurese11@gmail.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	0	0	0	2000	1000	3000
Check Qty	0	0	0	2000	1000	3000
NG Qty	0	0	0	1	0	1

Action taken on NG part

Scrap	0
Rework	1
Under Deviation	0

Containment Action
LAST 2 YEARS PROCESS REJECTION GIVEN BY K228

3. Process Flow

Process Flow Description
Cnc 1st-Cnc 2nd-Drill-Final Inspection -Dispatch

4. Process Details

Process / Operation	CNC 1ST SIDE
Outsource	No
Machine / Cell	MACHINE
Machine / Cell No.	1,2,3,4,5

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	M26X1P-6H Gauge not pass	Wrong offset given by operator	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	5nos

7. Root Cause Analysis (Occurance)

Why 1	M2X1P-6H Gauge not answered
Why 2	Insert wear out
Why 3	After changing new insert At The Time of correction operator taken 0.3mm offset instead of 0.03mm.
Why 4	Wrong offset given by operators.
Why 5	Wear offset not lock in programm
Root Cause (Occurance)	Wear offset not lock in programm

Root Cause Analysis (Outflow)

Why 1	M26X1P-6H Thread not answered
Why 2	Inspection as a sampling basis
Why 3	Inspection Done On Sampling Basis. (5 Nos / Lot)
Why 4	
Why 5	
Root Cause (Outflow)	Inspection Done On Sampling Basis. (5 Nos / Lot)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Wear Offset locked By 0.03mm In CNC Machine.	Mayur	28/06/2024	29/06/2024	Completed

Outflow	Started 100% Inspection At Machining Stage With The Help Of TPG GO and NOGO.	Pratap Behra	28/06/2024	29/06/2024	Completed
Occurance	Too life decided & Lock in CNC Machine.	Mayur	28/06/2024	29/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	100% inspection at CNC Stage
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

10. Evidance of Countermeasure

Occurance (Before)	NO INTERLOCK CNC MC 893_Occurance_Before.jpg
Occurance (After)	0.03 mm interlock 893_Occurance_After.png
Outflow (Before)	Sampling basis inspection 893_Outflow_Before.png
Outflow (After)	Sampling basic inspection but 50 nos check every lot & OPL dispalyed FID 893_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	K3 FORK PIPE,K17 FORK PIPE,ATHER,Ampere

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	Reviewed next two lots found ok