QFR No - 8000880715

Defect Details

NC No.	8000880715
NC Date	02/07/2024
NC Submission Date	
Part No.	550FA19533
Part Name	FORK PIPE MACHINED K8
Supplier Name & Code	101222-SANGKAJ ENGINEERING PVT LTD- U
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-SHORT LENGTH

1. Problem Description

Defect Description	SHORT LENGTH
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	26
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	aslam@sangkaj.com
Plant Head/CEO Email ID	pardenshinr@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	2000	0	0	100	0	2100
Check Qty	2000	0	0	100	0	2100
NG Qty	26	0	0	0	0	26

Action taken on NG part

Scrap	26
Rework	0
Under Deviation	0

Containment Action
Segregation done at ETL-K228, and also at M/S Sangkaj engineering.

3. Process Flow

Process Flow Description
Tube Inward - Induction hardening - CNC1st - CNC 2nd - Drilling - Visual inspection - bundling - Dispatch

4. Process Details

Process / Operation	CNC 2nd setup
Outsource	No
Machine / Cell	CNC machine
Machine / Cell No.	CNC machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Loading of component not as per defined method	Component loading as per specified method	X
Material	Rework material , mixed up with ok material	Separate bins are provided for R/W and OK material	X
Machine	Stopper can be loose	Stopper observed loose during running the machine	O
Man	Operator not followed Inspection sequence	Program is provided to control the operation sequence.	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	500:10

7. Root Cause Analysis (Occurance)

Why 1	Machine stopper nut position shifted.
Why 2	Stopper provided nut observed loose.
Why 3	Nut couldn`t sustain the load during running the machine.
Why 4	Single nut is provided to the stopper.
Why 5	
Root Cause (Occurance)	Single Nut provided to the stopper.

Root Cause Analysis (Outflow)

Why 1	Total length observed oversize.
Why 2	Not detected into the final inspection
Why 3	Checking frequency got less. (500:10)
Why 4	
Why 5	
Root Cause (Outflow)	Checking frequency got less. (500:10)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	OPL is provided on machine.	Mr Krushna Phuke	24/07/2024	02/07/2024	Completed
Outflow	Inspection frequency increased by 500:20	Mr Amol Tali	24/07/2024	02/07/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Checking frequency is increased by 500:20
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	500:20

10. Evidance of Countermeasure

Occurance (Before)	Single Nut provided to stopper 898_Occurance_Before.pdf
Occurance (After)	Double Nut provided to stopper. 898_Occurance_After.pdf
Outflow (Before)	Checking frequency got less 898_Outflow_Before.pdf
Outflow (After)	Checking Frequency increased 898_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Same department/ Machine Cell

12. Document Review

Documents	ControlPlan
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	