QFR No - 8000881721

Defect Details

NC No.	8000881721
NC Date	08/07/2024
NC Submission Date	
Part No.	F2DZ00912O
Part Name	FORK BOLT - K8
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-OD

1. Problem Description

Defect Description	OD oversize
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	22
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	540	0	0	2000	2000	4540
Check Qty	540	0	0	2000	2000	4540
NG Qty	22	0	0	0	0	22

Action taken on NG part

Scrap	22
Rework	0
Under Deviation	0

Containment Action
We checked 100% material lying at various stage

3. Process Flow

Process Flow Description
1-Raw Material 2-Part Off 3-Punching 4-Drilling + Counter 5-Tapping 6-CNC Turning 7-Rolling 8-Re -Tapping 9-Finish 10-Fiinal Inspection 11-Packing

4. Process Details

Process / Operation	Punching
Outsource	No
Machine / Cell	Punching
Machine / Cell No.	P-Machine -01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Material to swell in Punching process	Validation And Found NG	X
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL OK	O
Material	RM GRADE AND SIZE NOT OK	VALIDATION AND FOUND OK	O
Tool	Tool may wear	Validated and found ok	O
Method	Inspection Plan Not Effective	Sampling plan for forging has been Not revised	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	as per pla

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-OD
Why 2	Material to swell in Punching process
Why 3	After Punching Process not CLG Process Add
Why 4	
Why 5	
Root Cause (Occurance)	CLG operation not add after Punching process

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-OD
Why 2	Inspection Plan was not Effective
Why 3	Final inspection standard checking Frequency change 100% Gauge implements
Why 4	As per sampling Plan part checking in final inspection
Why 5	Ng part skipped from inspection and machine
Root Cause (Outflow)	Final inspection standard checking Frequency change 100% Gauge implements

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Process Drg Add CLG Operation After Punching Process	Mr Ganesh Maurya	31/07/2024	02/08/2024	Completed
Outflow	final inspection standard checking Frequency change 100% Gauge implements	Mr Ganesh Maurya	31/07/2024	02/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Final inspection standard checking Frequency change 100% Gauge implements
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)	CLG operation not add after Punching process 926_Occurance_Before.jpeg
Occurance (After)	CLG operation add after Punching process 926_Occurance_After.jpeg
Outflow (Before)	final inspection standard checking Frequency 10 pcs 926_Outflow_Before.jpeg
Outflow (After)	final inspection standard checking Frequency change 100% Gauge implements 926_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	clg 01

12. Document Review

Documents	Drawing, ProcessFlowChart
Specify Other Document	no

13. Effectiveness Of Action

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