QFR No - 8000881730

Defect Details

NC No.	8000881730
NC Date	08/07/2024
NC Submission Date	
Part No.	F20519007B
Part Name	UNDER BRACKET ASSEMBLY H107B PHASE 1
Supplier Name & Code	100073-SINGLA FORGING (P) LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	THREADING NOT OK-Step observed

1. Problem Description

Defect Description	THREADING NOT OK-Step observed
Detection Stage	Customer End
Problem Severity	Fitment
NG Quantity	5
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaforging.in
Plant Head/CEO Email ID	quality@singlaforging.in
MD Email ID	jain@singlaforging.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	100	500	0	0	0	600
Check Qty	100	500	0	0	0	600
NG Qty	70	370	0	0	0	440

Action taken on NG part

Scrap	0
Rework	440
Under Deviation	0

Containment Action
100% THREADING DIE ANSWER IN THE THREAD TILL THE GROOVE END ,WHICH AVAILABLE BELOW THE THREAD

3. Process Flow

Process Flow Description
STEERING SHAFT PFD:- 10-RECEIPT OF MATERIAL 20-RECEIPT INSPECTION , 30-STORAGE , 40-DMC OPERATION, 50-CNC TURNING 1ST ,60-BUSH PRESSING, 70-HOLE BUSH WELDING, 80-CNC TURNING 2ND , 90-CNC TURNING 3RD, 100-CNC TURNING 4TH

4. Process Details

Process / Operation	100-CNC TURNING
Outsource	No
Machine / Cell	CNC TURNING
Machine / Cell No.	CNC

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator.inspector	skill matrix	O
Machine	wrong correction in machine eprogram	thraed length 21.5 is mention in the machjine program and drawing requirement 21.5-1.0 mm	O
Method	Limitation of drawing	during verification of the drawing ,it observed that groove dia is more than the thread minor dia	X
Machine	Incomplete operation	Program completion logic is available at machine as part will not de-clamp without complete of opera	O
Machine	wrong offset	offset value locked in 0.005mm	O
Method	inspection frequecy not followed	100% inspection done by TRG	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Matting part mot answering on the thread till the groove end
Why 2	Groove diameter is more than the thread minor diameter
Why 3	Specification given as per the drawing
Why 4	
Why 5	
Root Cause (Occurance)	Groove diameter is more by the thread minor diameter by which matting part not answering till groove end

Root Cause Analysis (Outflow)

Why 1	Part not detected in the final inspection stage
Why 2	TRG gauge answering till the thread end.
Why 3	
Why 4	

Why 5	
Root Cause (Outflow)	NO

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Customer drawing need to revise either for thread length or for the groove depth.	ETL	10/08/2024		Inprocess
Occurance	Thread length raised by the 1mm in the machine program by which minor diameter profile machined in the groove & gauge or matting part answer till the groove end. effective date 25.06.2024	QA	01/08/2024	01/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No change point
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)	Machine program in which thread length was 21.5mm 925_Occurance_Before.jpeg
Occurance (After)	Machine program in which thread length is 22.5mm,which is out of the drawing but meeting the customer requirement. 925_Occurance_After.jpeg
Outflow (Before)	TRG 925_Outflow_Before.jpeg
Outflow (After)	TRG 925_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	Drawing, ControlPlan
Specify Other Document	Need revise Cust Drg

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	