QFR No - 8000882518

Defect Details

NC No.	8000882518
NC Date	16/07/2024
NC Submission Date	
Part No.	550FA18733
Part Name	FORK PIPE MACHINED-
Supplier Name & Code	101030-TUBE INVESTMENTS OF INDIA LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	MATERIAL DEFECT-YOGESH B - THREADING SIDE ID US OS

1. Problem Description

Defect Description	THREADING SIDE ID US OS
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	544
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	AmitVD@tii.murugappa.com
Plant Head/CEO Email ID	guptaajay@tii.murugappa.com
MD Email ID	mukeshahuja@tii.murugappa.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	544	0	0	0	0	544
Check Qty	544	0	0	0	0	544
NG Qty	10	0	0	0	0	10

Action taken on NG part

Scrap	10
Rework	0
Under Deviation	0

Containment Action
All Stock available at ETL end & Inhouse checked for the Threading Counter ID Parameter

3. Process Flow

Process Flow Description
Raw Material Inspection- Machining (Cualking & Threading)-Drilling-Oiling-Final Inspection-Dispatch

4. Process Details

Process / Operation	Machining
Outsource	No
Machine / Cell	Machining Cell
Machine / Cell No.	M/c No: 21

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Gauging not done by using PPG	PPG gauge observed in Wear out condition	X
Machine	Threading side spindle Bearing got Wear out	By analysing CNC Bearing Wear out & checking frequency was decided as	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1 Nos./30

7. Root Cause Analysis (Occurance)

Why 1	Threading S ide Counter ID Observed U/S & O/S
Why 2	The CNC turret was Spinning out.
Why 3	There was a gap in the size of CNC bearing
Why 4	There was a gap in the size of CNC bearing.
Why 5	Bearing Wear out Checkpoint not added in PM Plan Sheet.
Root Cause (Occurance)	Bearing Wear out Checkpoint not added in PM Plan Sheet.

Root Cause Analysis (Outflow)

Why 1	Threading S ide Counter ID Observed U/S & O/S
Why 2	Due to not getting detected by the operator during the inspection by using a plug gauge.
Why 3	Due to the plug gauge no go size is not ok.
Why 4	The plug gauge wears out.
Why 5	
Root Cause (Outflow)	The plug gauge wears out.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	New Plug gauge procurement to be done to avoid the plug gauge wearout Issue.	Mr. Shshikant Dethe	23/07/2024	23/07/2024	Completed
Occurance	CNC Bearing Wear out Check point added in PM Sheet & checking frequency was decided as per the PM Plan (Yearly basis)	Mr. Madhav Shinde	23/07/2024	23/07/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection Frequency revisied from 1Nos./10 Nos. to 1 Nos./30 Nos. with New Carbide Plug Gauge
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1Nos./10

10. Evidance of Countermeasure

Occurance (Before)	Bearing Wear out Checkpoint not added in PM Plan Sheet. 946_Occurance_Before.pdf
Occurance (After)	CNC Bearing Wear out Check point added in PM Sheet & checking frequency was decided as per the PM Plan (Yearly basis) 946_Occurance_After.pdf
Outflow (Before)	The plug gauge wears out. 946_Outflow_Before.pdf
Outflow (After)	New Plug gauge procurement to be done to avoid the plug gauge wearout Issue. 946_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Models

12. Document Review

Documents	PMCheckSheet, WISOP, InspCheckSheet
Specify Other Document	PM Checksheet

13. Effectiveness Of Action

Reviewed Quantity	152
Reason for submission	ok