QFR No - 8000884334

Defect Details

NC No.	8000884334
NC Date	26/07/2024
NC Submission Date	
Part No.	F2CK00403B
Part Name	CAP NUT XF1C1_1D1
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	DENT MARK-DENT DAMAGE

1. Problem Description

Defect Description	Hex damage
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	72
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@sharp-engineers.com
Plant Head/CEO Email ID	kurund.ma@sharp-engineers.com
MD Email ID	urkhandelwal@sharp-engineers.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	300	0	3300
Check Qty	1500	0	0	300	0	1800
NG Qty	72	0	0	0	0	72

Action taken on NG part

Scrap	72
Rework	0
Under Deviation	0

Containment Action
All pipe line material segregated at ETL and Sharp end

3. Process Flow

Process Flow Description
RM incoming-Parting and drilling-CNC 1st Turning-CNC 2nd Turning-MPI inspection-plating-Final inspection-PDI- Packing and forwarding

4. Process Details

Process / Operation	RM
Outsource	Yes
Machine / Cell	-
Machine / Cell No.	-

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Fixture not clean properly	Fixture clean properly also Clamping is on Across flat	O
Method	Setting not ok	setting ok, if setting done wrong then all material will get rejected	O
Method	Bright bar not insert properly in traub machine	Bar inserted properly also clamping is on Across flat	O
Tool	Tool wear out	Found tool ok	O
Material	Material grade change	Material found as per specification	O
Material	Rae Material Condition	Raw Material found in damaged condition	X
Machine	Parameter not set as per specification	Verified and found as per specification	O
Man	New manpower	No new manpower	O
Man	Unskill Manpower	Manpower available as per skill matrix	O
Tool	Tool damaged	Found ok condition	O
Machine	Power cut	No power cut	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5

7. Root Cause Analysis (Occurance)

Why 1	Dent Mark-damaged
Why 2	Damaged at Across corner
Why 3	Received RM is damaged condition
Why 4	
Why 5	
Root Cause (Occurance)	Received RM is damaged condition

Root Cause Analysis (Outflow)

Why 1	Dent Mark-damaged

Why 2	Damaged at Across corner
Why 3	skip from inspection
Why 4	inspection on sampling basis
Why 5	
Root Cause (Outflow)	inspection on sampling basis

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Started 100% Verification at incoming stage	Mr. Ravi Pande	05/08/2024	05/08/2024	Completed
Outflow	Started 100% inspection at final inspection	Omkar Bhange	05/08/2024	05/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Started 100% inspection at FI
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Inspection on sampling basis at incoming stage 974_Occurance_Before.jpeg
Occurance (After)	Started 100% inspection of hex bar at incoming stage 974_Occurance_After.jpg
Outflow (Before)	Inspection on sampling basis 974_Outflow_Before.jpeg
Outflow (After)	started 100% inspection at FID with Marking 974_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok