QFR No - 8000884335

Defect Details

NC No.	8000884335
NC Date	26/07/2024
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 O/S FITMENT NG

1. Problem Description

Defect Description	OD O/S
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	11
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	11	0	0	0	0	11

Action taken on NG part

Scrap	11
Rework	0
Under Deviation	0

Containment Action
We Checked 100% material lying at Various stage

3. Process Flow

Process Flow Description
Raw material +Part off +Drilling +Punching +Drilling +Tapping +CNC Machine +Rolling +Re-Tapping +Finish +Final Inspection +Packing

4. Process Details

Process / Operation	Punching
Outsource	Yes
Machine / Cell	Punching
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Material to Swell in Punching Process	Validation And Found NG	X
Material	RM GRADE AND SIZE NOT OK	VALIDATION ANF FOUND OK	O
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL LOW	X
Tool	Punching tool wear out	Validation and Found OK	O
Method	Forging Part checking gauge not effective	Validation And Found NG	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	sampling

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
Outflow	final inspection standard checking Frequency change 100% Gauge implements	Mr Ganesh Maurya	31/07/2024	01/08/2024	Completed
Occurance	CLG operation not add after Punching process	Mr Ganesh Maurya	31/07/2024	01/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	final inspection standard checking Frequency change OD -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 975_Occurance_Before.jpeg
Occurance (After)	CLG operation add after Punching process 975_Occurance_After.jpeg
Outflow (Before)	Final Inspection standards as per sampling plan 975_Outflow_Before.jpeg
Outflow (After)	Final Inspection standards 100% OD Dia checked 975_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	clg machine -01

12. Document Review

Documents	Drawing
Specify Other Document	PFMEA ,Final insp St

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	5. Problem Analysis - Need all 4M 7. Root Cause Analysis (Occurance & Outflow) - Not clear