QFR No - 8000884336

Defect Details

NC No.	8000884336
NC Date	26/07/2024
NC Submission Date	
Part No.	F2DZ04603B
Part Name	FORK BOLT J1A & J1D
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	THREADING MISSING-M10 THREAD MISSING

1. Problem Description

Defect Description	THREAD MISSING
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
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	2400	0	0	2500	2500	7400
Check Qty	2400	0	0	2500	2500	7400
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	0
Rework	1
Under Deviation	0

Containment Action
We checked 100% Material lying at various stage

3. Process Flow

Process Flow Description
Tapping

4. Process Details

Process / Operation	Tapping
Outsource	No
Machine / Cell	Tapping
Machine / Cell No.	TM-02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	MACHINE ROLLING PROCESS THREAD NOT CHECKED 100%	VALIDATION AND FOUND NG	X
Tool	ROLLING TOOL WEAROUT	VALIDATION AND FOUND OK	O
Material	RM GRADE AND SIZE NOT OK	VALIDATION AND FOUND OK	O
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL OK	O
Machine	MACHINE INPUT AND OUTPUT MATERIAL LOACTION NOT DESIDE	VALIDATION FOUND NG	X

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	THREADING MISSING-M10 THREAD MISSING
Why 2	Setting pcs mix-up and Machine Rejection box lock and key not available
Why 3	The threading machine did not setting part rejection box available , or the part skipped the threading process.
Why 4	The machine may not have been properly set up, or the operator failed to detect the missing operation during inspection
Why 5	The operator may not have followed the work instructions correctly or missed the setup check.
Root Cause (Occurance)	Setting pcs mix-up and Machine Rejection box lock and key not available

Root Cause Analysis (Outflow)

Why 1	THREADING MISSING-M10 THREAD MISSING
Why 2	Final Inspection table lux level not effective
Why 3	Final inspection part not checked 100%
Why 4	FINAL INSPECTION STANDARDS NOT ADD THREAD 100% CHECKED
Why 5	
Root Cause (Outflow)	FINAL INSPECTION STANDARDS NOT ADD THREAD 100% CHECKED

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	100% part are checked add final inspection standards & fork bolt check special Q-gate alone decide suppurate table	Mr Ganesh Maurya	06/08/2024	05/08/2024	Completed
Occurance	All Rolling Machine lock and key rejection bin provide	Mr Anil	06/08/2024	06/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Thread gauge
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)	Setting pcs mix-up and Machine Rejection box lock and key not available 976_Occurance_Before.xlsx
Occurance (After)	Setting pcs mix-up and Machine Rejection box lock and key available 976_Occurance_After.xlsx
Outflow (Before)	FINAL INSPECTION STANDARDS NOT UPDATE 976_Outflow_Before.xlsx
Outflow (After)	FINAL INSPECTION STANDARDS UPDATE 976_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	FORK BOLT

12. Document Review

Documents	WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK