QFR No - 8000884570

Defect Details

NC No.	8000884570
NC Date	29/07/2024
NC Submission Date	
Part No.	080FA04433
Part Name	FORK PIPE MACHINED - CT100
Supplier Name & Code	101223-SANGKAJ BRIGHT WIRES PRIVATE L
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	DRILL OUT-DOUBLE DRILL

1. Problem Description

Defect Description	CT 100 FROK PIPE DOUBLE DRILL ISSUE
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	mayursurse11@gmail.com
Plant Head/CEO Email ID	steel@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	2000	0	3000
Check Qty	999	0	0	2000	0	2999
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
100% Segregation at ETL End

3. Process Flow

Process Flow Description
Recipe Raw material + Incoming RM inspection + CNC1ST Turning + CNC 2nd Turning + Drilling + Air Cleaning + Final Inspection + PDI + Dispatch

4. Process Details

Process / Operation	Drilling
Outsource	No
Machine / Cell	Drill cell
Machine / Cell No.	Drill mc no 1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Fixture loose condition found	not ok found	O
Man	Lack of operator awareness	traing not doen	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	DRILL OUT-DOUBLE DRILL
Why 2	At the time of drill all material ok
Why 3	but 1 part drill fixture loose condition
Why 4	Fixture loss condition
Why 5	
Root Cause (Occurance)	Fixture loss condition

Root Cause Analysis (Outflow)

Why 1	DRILL OUT-DOUBLE DRILL
Why 2	Inspection as a sampling basis
Why 3	Inspection Done On Sampling Basis. (5 Nos / Lot)
Why 4	
Why 5	
Root Cause (Outflow)	Inspection Done On Sampling Basis. (5 Nos / Lot)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Fixture loss condition found due to Hourly check to fixture tight	Mr Pratap	04/08/2024	05/08/2024	Completed
Occurance	At the time NG Produce operator kept red bin,training to operator	Mr Mayur	04/08/2024	05/08/2024	Completed
Outflow	Check point added final inspection* aware to operator	Mr Mayur	03/08/2024	05/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	No change
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos

10. Evidance of Countermeasure

Occurance (Before)	Weekly PM NOT DONE JULY MONTH 993_Occurance_Before.png
Occurance (After)	PM DONE STILL DATE 993_Occurance_After.jpg
Outflow (Before)	Training not done 993_Outflow_Before.png
Outflow (After)	Training done opearator & inspector 993_Outflow_After.jpg

11. Horizontal Deployment

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

12. Document Review

Documents	PMCheckSheet, WISOP
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	5000
Reason for submission	Reviewed next two lots found ok