QFR No - 8000884574

Defect Details

NC No.	8000884574
NC Date	29/07/2024
NC Submission Date	
Part No.	F2FA19033M
Part Name	K0PG FORK PIPE MACHINED
Supplier Name & Code	101223-SANGKAJ BRIGHT WIRES PRIVATE L
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	LENGTH UNDERSIZE-HEIGHT LESS

1. Problem Description

Defect Description	K0PG FORK PIPE TOTAL LENGTH LESS ISSUE
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	Yes
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	2000	0	0	1000	0	3000
Check Qty	1999	0	0	1000	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% Inspection ETL & WIP STOCK

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	CNC 2ND SIDE
Outsource	No
Machine / Cell	CNC CELL
Machine / Cell No.	4

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Clamping not proper rest	Clamping rest Judgement error	O

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5nos

7. Root Cause Analysis (Occurance)

Why 1	Total Height undersize
Why 2	Not proper part rest on stopper
Why 3	At inside of collet stuck loose burr
Why 4	No arrangement to clean stopper & collet
Why 5	
Root Cause (Occurance)	No arrangement to clean stopper & collet

Root Cause Analysis (Outflow)

Why 1	Total Height undersize
Why 2	Rejected material mix-up with ok material
Why 3	Rejection bin provided but not daily rejection rework clear
Why 4	
Why 5	
Root Cause (Outflow)	Rejection bin provided but not daily rejection rework clear

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	No arrangement to clean stopper & collet	Mayur	02/08/2024	04/08/2024	Completed

Outflow	Rejection bin provided but not daily rejection rework clear	Supervisor	04/08/2024	03/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no change
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5nos

10. Evidance of Countermeasure

Occurance (Before)	Air not available at CNC stage 992_Occurance_Before.jpg
Occurance (After)	Air available at CNC stage to clean collet loose burr 992_Occurance_After.jpg
Outflow (Before)	Opl not displayed 992_Outflow_Before.png
Outflow (After)	OPL DISPLAYED 992_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	ALL MODEL

12. Document Review

Documents	WISOP
Specify Other Document	OPL DISPLAYED

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	verified next lots found ok no issue