QFR No - 8000884592

Defect Details

NC No.	8000884592
NC Date	30/07/2024
NC Submission Date	
Part No.	550DZ05202
Part Name	FORK BOLT :PRFH-006
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	THREADING NOT OK-MINOR DIA GO NOT ANSWERING

1. Problem Description

Defect Description	FORK BOLT M10 THREAD MINOR DIA PLUG GAUGE GO NOT ANSWERING
Detection Stage	Receipt
Problem Severity	Safety
NG Quantity	139
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
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	2500	3500	9000
Check Qty	3000	0	0	2500	3500	9000
NG Qty	139	0	0	5	3	147

Action taken on NG part

Scrap	147
Rework	0
Under Deviation	0

Containment Action
Segregation done immediately for all suspected material of pipeline.

3. Process Flow

Process Flow Description
RM incoming-Parting and drilling-Tipm grinding-CNC 1st-Pre thread drilling and tapping-OD grinding - thread rolling-Tapping -Plating-final inspection-Pre dispatch inspection-packing and forwarding

4. Process Details

Process / Operation	Tapping
Outsource	No
Machine / Cell	Tapping
Machine / Cell No.	Tapping

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	New operator	Experienced operator is working	O
Man	Unskilled operator	Operator available as per skill matrix.	O
Method	Wrong setting	Setting done ok	O
Tool	Wrong tool	Tool found ok	O
Machine	Process parameter change	found as per specification	O
Method	Checking Method	Verified and found ok	O
Machine	Plating thickness	found plating thickness oversize	X
Material	Material grade change	found as per specification	O
Material	Material hardness	as per specification found	O
Tool	Wear out	found ok	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	M10 THREAD MINOR DIA PLUG GAUGE GO NOT ANSWERING
Why 2	Minor Dia Undersize
Why 3	Undersize by 20micron
Why 4	Found Excess of plating
Why 5	Barrel time increased due to manual dependency
Root Cause (Occurance)	Barrel time increased due to manual dependency

Root Cause Analysis (Outflow)

Why 1	M10 THREAD MINOR DIA PLUG GAUGE GO NOT ANSWERING
Why 2	Skip from inspection

Why 3	Inspection frequency is less
Why 4	Inspection frequency is 10 nos per lot
Why 5	
Root Cause (Outflow)	Inspection frequency is 10 nos per lot

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Started production on Auto line to avoid Excess of plating due to timing	Mr. Pradeep Bhagwat	14/08/2024	14/08/2024	Completed
Outflow	Inspection frequency was increased to 20 nos per lot, also started 100% of inspection before dispatched	Mr. Omkar Bhange	14/08/2024	14/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection frequency was increased to 20 nos per lot,
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)	Barrel time increased due to manual dependency 989_Occurance_Before.jpeg
Occurance (After)	Started production on Auto line 989_Occurance_After.jpeg
Outflow (Before)	Inspection frequency is 10 nos per lot and sampling inspection. 989_Outflow_Before.jpg
Outflow (After)	Inspection frequency is 20 nos per lot also started 100% gauge inspection before dispatch. 989_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	5000
Reason for submission	reviewed next 2 lots found ok