QFR No - 8000885867

Defect Details

NC No.	8000885867
NC Date	07/08/2024
NC Submission Date	
Part No.	550DZ05202
Part Name	FORK BOLT :PRFH-006
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1116-ETL K-120 Suspension
Defect Details	NOT AS PER SPECIFICATION-BURR AT GROOVE WIDTH

1. Problem Description

Defect Description	Fork Bolt Groove ID Burr
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	50
Is Defect Repeatative?	Yes
Defect Sketch / Photo	0sppjw30xuq1bpksvo5u13ck.jpg

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	8000	0	0	2000	5000	15000
Check Qty	8000	0	0	2000	5000	15000
NG Qty	50	0	0	0	9	59

Action taken on NG part

Scrap	0
Rework	59
Under Deviation	0

Containment Action
Segregated all pipeline material at customer end and sharp end

3. Process Flow

Process Flow Description
RM incoming-Parting and drilling-Tip grinding-CNC 1st -pre thread drilling and chamfering-OD grinding-Thread rolling-Tapping M10-plating - final inspection-PDI-Packing and forwarding

4. Process Details

Process / Operation	Plating
Outsource	Yes
Machine / Cell	Plating
Machine / Cell No.	Plating Plant

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	New operator	No new operator	O
Man	Unskilled operator	Operator skilled as per skill matrix	O
Material	Material grade change	Material grade is as per requirement	O
Machine	Burr particle deposited in plating tank	Bur particle found in plating tank	X
Machine	Plating process parameter not as per specification	Plating process parameter is as per specification	O
Method	Plating tank cleaning method not followed	Plating tank cleaning method followed as per control plan	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Burr observed in the groove
Why 2	Burr stick on part during process
Why 3	Burr from dangler stick into groove
Why 4	Barrel dangler not clean
Why 5	Barrel dangler cleaning frequency once in week
Root Cause (Occurance)	Barrel dangler cleaning frequency once in week

Root Cause Analysis (Outflow)

Why 1	Burr observed in the groove
Why 2	Skip from inspection
Why 3	Inspection size is less
Why 4	Inspection size was 10 nos per lot
Why 5	
Root Cause (Outflow)	Inspection size was 10 nos per lot

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Barrel dangler frequency changed from one week to Daily basis	Mr.Pradip Bhagwat	10/08/2024	10/08/2024	Completed
Outflow	Inspection size increased to 20 nos per lot	Mr. Pradip Bhagwat	10/08/2024	10/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Dangler Barrel cleaning frequency changed.
Inspection Method	Other
Other Inspection Method	Visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Dangler not clean 1001_Occurance_Before.jpeg
Occurance (After)	Dangler clean 1001_Occurance_After.jpeg
Outflow (Before)	Inspection frequency is 10 nos per lot 1001_Outflow_Before.jpg
Outflow (After)	Inspection frequency ins 20nos per lot 1001_Outflow_After.jpeg

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	OK