QFR No - 8000886626

Defect Details

NC No.	8000886626
NC Date	12/08/2024
NC Submission Date	
Part No.	520DZ01203
Part Name	FORK BOLT NiCr PLATED ELIMIN.
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	THREADING MISSING-WITHOUT THREADING

1. Problem Description

Defect Description	Threading Missing
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	No
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	1000	2000	0	2000	3000	8000
Check Qty	1000	2000	0	2000	3000	8000
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	0
Rework	1
Under Deviation	0

Containment Action
we are checked 100% material lying at various stage

3. Process Flow

Process Flow Description
Raw Material +Cutting + Annealing + Forging + CNC Turning + Head Facing + Counter + Buffing + Thread Rolling + Surface Treatment + Final Inspection + Packing

4. Process Details

Process / Operation	Thread Rolling
Outsource	No
Machine / Cell	Rolling
Machine / Cell No.	Rolling machine -02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	INSPECTION METHOD NOT EFFECTIVE	VALIDATION AND FOUND TRG NOT USE 100%IN MACHINE	X
Tool	DIE WEAROUT	VALIDATION AND FOUND DIE OK	O
Machine	ROLLING MACHINE PM NOT DONE AS PER PLAN	VALIDATION AND FOUND PM DONE	O
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL LOW	X
Material	RM GRADE AND SIZE NOT OK	VALIDATION ANF FOUND OK	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	SAMPLING

7. Root Cause Analysis (Occurance)

Why 1	THREADING MISSING-WITHOUT THREADING
Why 2	The part skipped the threading process during production.
Why 3	During Rolling Process 1 piece fell down from output bin
Why 4	input and output material separate rack not provide in machine
Why 5	material handling W.I not display on machine and operator training not given input and output material
Root Cause (Occurance)	input and output material separate rack not provide in machine input output material bin not different use not add point W.I

Root Cause Analysis (Outflow)

Why 1	THREADING MISSING-WITHOUT THREADING
Why 2	The part skipped the Final Inspection during part inspection
Why 3	NG PART SKIPPED FROM INSPECTION
Why 4	Final inspection area Red Bin Lock and key not available
Why 5	
Root Cause (Outflow)	Final inspection area rejection box lock and key not available

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Input and output material separate rack provide in machine	Mr Anil	14/08/2024	14/08/2024	Completed
Outflow	provide All inspection table rejection bin lock and key	Mr Ganesh Maurya	14/08/2024	14/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% THREADING CHECKED IN MACHINE AND FINAL INSPECTION
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)	input and output material separate rack not provide in machine input output material bin not different use not add point W.I 1017_Occurance_Before.xlsx
Occurance (After)	input and output material separate rack provide in machine and input material blue and output material green bin use add point W.I 1017_Occurance_After.xlsx
Outflow (Before)	Final inspection area rejection box lock and key not available 1017_Outflow_Before.xlsx
Outflow (After)	Final inspection area rejection box lock and key available 1017_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	ROOLING MACHINE -01

12. Document Review

Documents	PFMEA, WISOP, PackingStd
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK