QFR No - 8000886627

Defect Details

NC No.	8000886627
NC Date	12/08/2024
NC Submission Date	
Part No.	F2LG05402B
Part Name	SEAT PIPE - J1A & J1D
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-MIX-UP

1. Problem Description

Defect Description	Mix-up Issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	37
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	2000	3000	0	5000	5000	15000
Check Qty	2000	3000	0	5000	5000	15000
NG Qty	37	0	0	0	0	37

Action taken on NG part

Scrap	0
Rework	37
Under Deviation	0

Containment Action
STOCK CHECK 100% AT OUR END

3. Process Flow

Process Flow Description
1-RM 2- FORGING 3-PUNCHING -IST 4-ROUGH CLG 5-CNC-IST 6-CNC-II 7-PUNCHING -II 8-I.D CHIP REMOVE 9-REAMING IST 10-REAMING-IIND 11-TAPPING 12-FINAL GRINDING 13-ALKLINE WASHING 14- FINAL INSPECTION 15 - PACKING

4. Process Details

Process / Operation	Packing
Outsource	No
Machine / Cell	no
Machine / Cell No.	no

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	material mix-up machine stage	validation and found ok	O
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND MACHINE OPERATOR AWARENESS FOR J1A & J1D MATERIAL HANDLING	O
Method	PACKING STANDARDS NOT EFFECTIVE	VALIDATION FOUND MATERIAL MIX-UP FOR PACKING STAGE	X
Material	RM GRADE AND SIZE NOT OK	VALIDATED AND FOUND OK O	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	PACKING OTHERS STAGE
Check Point at Final Inspection	No
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-MIX-UP
Why 2	The problem occurred at packing stage
Why 3	Material handling not properly rust preventive oil stage
Why 4	Rust preventive oil stage as per part wise specification bin not use so parts mix-up at this stage
Why 5	No any quality gate available after rust preventive oil material handling
Root Cause (Occurance)	No any quality gate available after rust preventive oil stage W I not update as per part wise specification bin

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-MIX-UP
Why 2	100% inspection is not done at packing stage
Why 3	Inspection is also as per sampling plan
Why 4	So final inspection person not caught this defect
Why 5	So NG parts dispatched to customer end
Root Cause (Outflow)	Seat pipe J1D material identification groove require as per process drg. same implement but at packing stage this point not highlight in packing std.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	prepared quality gate and W I update point after rust preventive oil stage same specification bin use for input /output material	Anil	14/08/2024	14/08/2024	Completed
Outflow	packing std. change and highlight groove identification mark and all packging opr. training provide	Ganesh mourya	14/08/2024	14/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	AFTER MATERIAL INSPECTION SOME TABLE PACKING DONE
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)	No any quality gate available after rust preventive oil stage W I not update as per part wise specification bin 1019_Occurance_Before.pdf
Occurance (After)	quality gate available after rust preventive oil stage W I update as per part wise specification bin 1019_Occurance_After.pdf
Outflow (Before)	PACKING STANDARDS NOT UPDATE AS PER PART WISE IDENTIFICATION MARK 1019_Outflow_Before.pdf
Outflow (After)	PACKING STANDARDS UPDATE AS PER PART WISE IDENDITFICATION MARK 1019_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	J1A ~ J1D MODLE

12. Document Review

Documents	ControlPlan, PFMEA, PackingStd
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	Occurrence side action plan?