QFR No - 8000887123

Defect Details

NC No.	8000887123
NC Date	16/08/2024
NC Submission Date	
Part No.	F2DZ04603B
Part Name	FORK BOLT J1A & J1D
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-BIN CONTAMINATION

1. Problem Description

Defect Description	BIN CONTAMINATION
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	528
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@sharp-engineers.com
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	1000	0	0	0	0	1000
Check Qty	1000	0	0	0	0	1000
NG Qty	528	0	0	0	0	528

Action taken on NG part

Scrap	0
Rework	528
Under Deviation	0

Containment Action
Clean all pipeline material

3. Process Flow

Process Flow Description
RM incoming-Parting and drilling-Milling-CNC 1st-Deburring-CNC 2nd-Finish Drilling--Tapping-Plating-Final Inspection-PDIR-Packing and forwarding

4. Process Details

Process / Operation	Dispatch
Outsource	No
Machine / Cell	NA
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	New manpower for packaging	Having existing manpower	O
Tool	Tool change	Not applicable	O
Machine	Machined change	No machine change	O
Method	Bin cleaning not done at defined frequency	Bin cleaning not done as per defined frequency	X
Method	Bin Received in contamination condition from customer	Received in ok condition	O
Material	Material grade change	Material found ok	O
Method	other parts Bin used for dispatched	Having Possibilities	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	5 nos

7. Root Cause Analysis (Occurance)

Why 1	Contamination Bin
Why 2	Oil found in Bin
Why 3	Used other parts Bin for dispatched
Why 4	Shortage of Bins
Why 5	
Root Cause (Occurance)	Shortage of Bins

Root Cause Analysis (Outflow)

Why 1	Contamination Bin
Why 2	Bin condition not verified at PDI stage
Why 3	Check Point not available in PDI report
Why 4	
Why 5	

Root Cause (Outflow)	Check Point not available in PDI report

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Check point added in PDI report	Mr. Omkar Bhange	20/08/2024	20/08/2024	Completed
Occurance	Ordered New 50nos Bins	Mr. Vivek Dewar	11/09/2024	20/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Check point added at PDI stage
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Contamination in Bin 1024_Occurance_Before.png
Occurance (After)	Ordered New 50 Nos Bins 1024_Occurance_After.pdf
Outflow (Before)	Check point not added in PDI report 1024_Outflow_Before.jpeg
Outflow (After)	Check point added in PDI report 1024_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	PFMEA, WISOP, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK But preventive action is required