QFR No - 8000887612

Defect Details

NC No.	8000887612
NC Date	20/08/2024
NC Submission Date	
Part No.	B2FP04213O
Part Name	HOLDER BRACKET FINESHED-H105 CBS
Supplier Name & Code	201092-PRANEEL INDUSTRIES
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	BORE DIA O/SIZE.-HOLE DIA OVERSIZE

1. Problem Description

Defect Description	BORE DIA O/SIZE.-HOLE DIA OVERSIZE
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	23
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@praneelgroup.com
Plant Head/CEO Email ID	praneelindustries@rediffmail.com
MD Email ID	anilpatil@praneelgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	225	0	0	75	0	300
Check Qty	225	0	0	75	0	300
NG Qty	23	0	0	9	0	32

Action taken on NG part

Scrap	32
Rework	0
Under Deviation	0

Containment Action
All material at ETL end and In-house sagrigation done by core pin gauge and NG parts rejected.

3. Process Flow

Process Flow Description
Raw material Inward=>Powder Coating=>Powder Coating Inward=>VMC Setup=> De-burring=>Final Inspection=> Packing and Dispatch.

4. Process Details

Process / Operation	VMC Setup
Outsource	No
Machine / Cell	VMC Machine
Machine / Cell No.	VMC Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator and Final Inspector.	Vewrify skill matrix for both Operator and final inspector found ok.	O
Material	Material not as per the standard.	Material found as per standard.	O
Machine	Machine clamping pressure not as required.	Verify the machine clamping pressure found as per CP.	O
Tool	Drill size not as required.	Verify the drill and found inadequate.	X
Method	Method of VMC setup is not as per the PFD.	Verify the process and found Ok.	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	samp.plan

7. Root Cause Analysis (Occurance)

Why 1	Bore dia. O/SIZE.-Hole dia. Oversize.
Why 2	Core pin dia oversize.
Why 3	Before threading drilling size found oversize during operation.
Why 4	Drill corner break during the operation.
Why 5	Machining burr fold on the drill during operation.
Root Cause (Occurance)	Machining burr fold on the drill during operation.

Root Cause Analysis (Outflow)

Why 1	Bore dia. O/SIZE.-Hole dia. Oversize.
Why 2	Core pin dia oversize.
Why 3	Inspection skipped from the final inspection.
Why 4	
Why 5	
Root Cause (Outflow)	Inspection skipped from the final inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Training given to operator operator for checking the core pin gauge on the machine.	Mr. Chandrakant Nanher	23/08/2024	23/08/2024	Completed
Outflow	Training and awareness given to inspector for core pin checking and visual inspection for dia oversize.	Mr.Yogesh Sonune	23/08/2024	23/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Core pin gauge checking started at Machine stage also and at final inspection as per sampling plan
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	samp.plan

10. Evidance of Countermeasure

Occurance (Before)	before no core pin dia checking available in the control plan. 1033_Occurance_Before.xlsx
Occurance (After)	After core pin dia checking method and burr fold on drill check point added in the control plan. 1033_Occurance_After.xlsx
Outflow (Before)	Before no any Q-alert and work instruction for core pin dia checking. 1033_Outflow_Before.pdf
Outflow (After)	Q alert and core pin dia checking added in FFPA and Hourly inspection method for detecting the core pin oversize issue. 1033_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Other all Holder bracket for Threading M8x1.25-6H.

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	Q-Alert

13. Effectiveness Of Action

Reviewed Quantity	110
Reason for submission	No core pin dia oversize found after 23 Nos.