QFR No - 8000889012

Defect Details

NC No.	8000889012
NC Date	29/08/2024
NC Submission Date	
Part No.	S2KH01402B
Part Name	REBOUND SPRING U101
Supplier Name & Code	101159-TECHNOMAT SPRINGS
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	M/CING SHIFT.-NOTCH BURR

1. Problem Description

Defect Description	INSIDE ID NOTCH BURR
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	439
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@technomatsprings.com
Plant Head/CEO Email ID	technomatsprings@gmail.com
MD Email ID	patilsadanand@technomatsprings.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	6000	0	0	840	0	6840
Check Qty	6000	0	0	840	0	6840
NG Qty	439	0	0	0	0	439

Action taken on NG part

Scrap	0
Rework	439
Under Deviation	0

Containment Action
All material checked 100% for nose burr issue at ETL end and Technomat end also.

3. Process Flow

Process Flow Description
RM In warding > RM Inspection > Coiling > Stress Relieving-1 > Grinding > De-Burring > Shot Peening > Stress Relieving-2 > Final Inspection > Oiling > Packing > Dispatch.

4. Process Details

Process / Operation	Coiling
Outsource	No
Machine / Cell	-
Machine / Cell No.	-

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	NA	NA	O
Material	Wrong Material / Grade	Supplier RMTC Report checked found Ok	O
Man	Unskilled Operator	Skill Matrix verified found Ok	O
Tool	Tool Wear Out	Tool Monitoring Card Verified found ok	O
Method	Nose Burr Operation Skipped.	Process re-verified & observed that the nose burr operation skipped.	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	30 Nos

7. Root Cause Analysis (Occurance)

Why 1	NOSE BURR OBSERVED.
Why 2	INSPECTION SKIPPED AT THE TIME OF SET-UP APPROVAL.
Why 3	DUE TO NOSE BURR OPERATION NOT MENTIONED ON THE SET-UP REPORT.
Why 4	OPERATOR NOT AWARE ABOUT THE NOSE BURR OPERATION.
Why 5	
Root Cause (Occurance)	THE NOSE BURR OPERATION NOT MENTIONED ON THE SETUP REPORT DUE TO THAT OPERATOR NOT AWARE ABOUT NOSE BURR OPERATION.

Root Cause Analysis (Outflow)

Why 1	NOSE BURR OBSERVED.
Why 2	DEFECTIVE PART SKIPPED FROM INSPECTION
Why 3	PARTS NOT CHECKED FOR THE NOSE BURR DEFECT AT FINAL INSPECTION.
Why 4	
Why 5	

Root Cause (Outflow)	PARTS NOT CHECKED FOR THE NOSE BURR DEFECT AT FINAL INSPECTION.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. NOSE BURR OPERATION POINT ADDED IN SET UP REPORT 2. PART-WISE LIST FOR THE NOSE BURR PROCESS DISPLAYED ON THE MACHINE.	MR. ANUJ SHELKE	25/09/2024	25/09/2024	Completed
Outflow	1. TRAINING GIVEN TO THE INSPECTORS 2. OPL DISPLAYED AT FINAL INSPECTION STAGE.	MR. ANUJ SHELKE	25/09/2024	25/09/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1. NOSE BURR OPERATION LIST DISPLAYED ON THE MACHINE. 2. TRAINING GIVEN TO THE OPERATORS AND INSPECTORS AND OPERATORS
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)	De-burring point was not mentioned on the control plan. 1049_Occurance_Before.pdf
Occurance (After)	De-burring point mentioned on the control plan. 1049_Occurance_After.pdf
Outflow (Before)	Material Checked on the sampling basis. 1049_Outflow_Before.pdf
Outflow (After)	100% inspection started. & OPL Displayed at the final inspection table. 1049_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Horizontally deployed for all the same parts.

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	After taking action no notch burr observed on part.