QFR No - 8000889510

Defect Details

NC No.	8000889510
NC Date	02/09/2024
NC Submission Date	
Part No.	F2CK00403B
Part Name	CAP NUT XF1C1_1D1
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	DENT MARK-DENT DAMAGE

1. Problem Description

Defect Description	DENT DAMAGE
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	43
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	43	0	0	0	0	43

Action taken on NG part

Scrap	43
Rework	0
Under Deviation	0

Containment Action
All pipeline material segregated at Customer and Supplier end

3. Process Flow

Process Flow Description
RM inward inspection-Parting and drilling-CNC 1st turning-CNC 2nd Turning-MPI inspection-Plating-Final Inspection-PDI-Packing and forwarding

4. Process Details

Process / Operation	RM incoming
Outsource	Yes
Machine / Cell	Incoming stage
Machine / Cell No.	10

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Die clean properly	Die cleaning done Once in shift	X
Method	Setting not OK	Setting done ok and verified	O
Tool	Tool wear out	Tol found ok	O
Material	Raw material condition	RM condition in damage condition	X
Machine	Process parameter not set as per specification	Found as per specification	O
Man	Unskill manpower	skill Manpower deployed as per skill matrix	O
Tool	Tool damaged	Tool found ok	O
Machine	Power cut	No any effect even power cut	O
Material	Material Grade change	Material found as per specification	O
Man	Manpower change	Manpower not changed	O

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	5

7. Root Cause Analysis (Occurance)

Why 1	Dent mark damage
Why 2	Damage at Across flat
Why 3	Deep line mark found on RM
Why 4	Burr observed in Tool
Why 5	Tool cleaning twice in shift
Root Cause (Occurance)	Tool cleaning twice in shift

Root Cause Analysis (Outflow)

Why 1	Dent mark damage
Why 2	skip from inspection

Why 3	Inspection is on sampling basis 5 bar per lot.
Why 4	
Why 5	
Root Cause (Outflow)	Inspection is on sampling basis 5 bar per lot.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Started tool cleaning hourly basis	Mr. Govind	04/09/2024	04/09/2024	Completed
Occurance	Onjob Training given to Operator for Tool cleaning	Mr. Govind	04/09/2024	04/09/2024	Completed
Outflow	RM Sampling increased from 5 bar per lot to 10 bar per lot	Mr. Afsar	04/09/2024	04/09/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	RM Sampling increased from 5 bar per lot to 10 bar per lot
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10Bar

10. Evidance of Countermeasure

Occurance (Before)	Tool cleaning twice in shift 1065_Occurance_Before.jpg
Occurance (After)	Started tool cleaning hourly basis 1065_Occurance_After.jpg
Outflow (Before)	5 Bar PER LOT before dispatch 1065_Outflow_Before.jpg
Outflow (After)	10 bar per lot before dispatch 1065_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	For 17m Hex.

12. Document Review

Documents	WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK