QFR No - 8000891727

Defect Details

NC No.	8000891727
NC Date	19/09/2024
NC Submission Date	
Part No.	S2MJ01112B
Part Name	SPRING SEAT K0AJ
Supplier Name & Code	100106-SHARP ENGINEERS.
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	RUSTY-RUSTY

1. Problem Description

Defect Description	Rusty issue observed
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	352
Is Defect Repeatative?	No
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	1200	0	2200
Check Qty	1000	0	0	0	0	1000
NG Qty	352	0	0	0	0	352

Action taken on NG part

Scrap	0
Rework	352
Under Deviation	0

Containment Action
All pipeline material segregated at Customer end and Sharp end

3. Process Flow

Process Flow Description
RM Incoming-Parting-Rough lathe turning-Rough Drilling-CNC 1st-CNC 2nd-Plating -Final Inspection-Packing and fowarding

4. Process Details

Process / Operation	Plating
Outsource	Yes
Machine / Cell	Plating cell
Machine / Cell No.	Plating cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Incorrect RM grade	Third part inspection verified for chemical composition and hardness testing as per requirement.	O
Man	Judgment error While checking	Master sample/ Limit sample provided for Checking at final as well as process stage	O
Machine	Inadequate check Point in JH check sheet	Monthly JH check sheet available on machine and all the check point is being checked and recorded as	O
Method	Improper Plating Thickness	Plating thickness defined as per drawing but at lower side	X
Tool	Tool life monitoring	Tool life for all the tool i.e. forming tool, drill, tap and insert are defined and recorded as per	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 NOS PER

7. Root Cause Analysis (Occurance)

Why 1	Rusty issue observed
Why 2	Moisture accumulated because of rainy season
Why 3	Low plating thickness gets rusty
Why 4	low plating thickness upto 8mic against 8-12 micron
Why 5	
Root Cause (Occurance)	low plating thickness upto 8mic against 8-12 micron

Root Cause Analysis (Outflow)

Why 1	Rusty issue observed
Why 2	Moisture accumulated on the part because of rainy season
Why 3	Packaging in only Corrugated Box
Why 4	
Why 5	

Root Cause (Outflow)	Packaging in only Corrugated Box

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Wrapping provided for Inner and outside	Mr. Omkar Bhange	28/09/2024	28/09/2024	Completed
Occurance	Started Marinating Plating Thickness Above 10 micron	Mr. Pradeep Bhagwat	28/09/2024	28/09/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling Size increased 5nos per Box
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5nos/ Box

10. Evidance of Countermeasure

Occurance (Before)	low plating thickness upto 8mic against 8-12 micron 1109_Occurance_Before.jpeg
Occurance (After)	Started Marinating Plating Thickness Above 10 -12 micron From next Lot 1109_Occurance_After.png
Outflow (Before)	Packaging in only Corrugated Box 1109_Outflow_Before.jpeg
Outflow (After)	Wrapping provided for Inner and outside 1109_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	WISOP, PackingStd
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	No any rust observed in this lot.