QFR No - 8000894558

Defect Details

NC No.	8000894558
NC Date	05/10/2024
NC Submission Date	
Part No.	F2FA28133M
Part Name	FORK PIPE MACHINED - Ø37.1
Supplier Name & Code	100576-SANGKAJ BRIGHT WIRES PVT LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-THREADING NG

1. Problem Description

Defect Description	THREADING NG
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	22
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	brightwire.qa@sangkaj.com
Plant Head/CEO Email ID	steel@sangkaj.com
MD Email ID	anirudh.2007@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	750	0	0	450	350	1550
Check Qty	750	0	0	450	350	1550
NG Qty	22	0	0	0	0	22

Action taken on NG part

Scrap	22
Rework	0
Under Deviation	0

Containment Action
1) At ETL end verified the 750 nos out of 22 nos found defective.2) At SBWPL end verified the 800 nos all part found ok. 3) for ok part provided the identification mark.

3. Process Flow

Process Flow Description
Receipt Of Material - Inward Inspection - CNC 1st Setup - CNC 2nd Setup - Drilling - Final Inspection - Air Cleaning - Dispatch

4. Process Details

Process / Operation	CNC 2nd Setup
Outsource	No
Machine / Cell	Machining
Machine / Cell No.	Fork Pipe Machining

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Due to Inspector negligence.	Verified found not ok	X
Tool	Tool holder loose	Verified Ok	O
Tool	Insert Wear Out	Verified Ok	O
Method	Part Touch with stand, No arrangement to avoid the fork pipe contact with stand	Verified found not ok	X
Machine	Spindle run out not ok	Verified Ok	O
Man	New Operator	Verified Ok	O
Material	Material grade not ok	Verified Ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Fork Pipe threading NG
Why 2	Thread ring gauge not qualify
Why 3	Dent on threading
Why 4	Fork pipe directly kept on Metal stand
Why 5	No arrangement to avoid the contact of stand & fork pipe.
Root Cause (Occurance)	No arrangement to avoid the contact of stand & fork pipe.

Root Cause Analysis (Outflow)

Why 1	Fork Pipe threading NG
Why 2	Skipped from inspector.
Why 3	Due to Inspector negligence.
Why 4	

Why 5	
Root Cause (Outflow)	Due to Inspector negligence.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	1) Identification mark provided after final inspection for threading ok 2) Display OPL at machining & final Inspection stage.	Mr. Nitin Puri	11/10/2024	11/10/2024	Completed
Occurance	Blue sheet provided to avoid the threading damage issue.	Mr. Barik & Mr. Nitin Puri	11/10/2024	11/10/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No Change
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	PDIR

10. Evidance of Countermeasure

Occurance (Before)	Fork pipe kept on stand,No arrangement for avoid the threading damage 1138_Occurance_Before.xlsx
Occurance (After)	Blue sheet provided to avoid the threading damage issue. 1138_Occurance_After.xlsx
Outflow (Before)	Identification mark not provided after final inspection. 1138_Outflow_Before.xlsx
Outflow (After)	1) Identification mark provided after final inspection for threading ok 2) Display OPL at machining & final Inspection stage. 1138_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All model

12. Document Review

Documents	WISOP
Specify Other Document	Display OPL

13. Effectiveness Of Action

Reviewed Quantity	120
Reason for submission	Verified next lot observed ok