QFR No - 8000894559

Defect Details

NC No.	8000894559
NC Date	05/10/2024
NC Submission Date	
Part No.	550FA12233
Part Name	FORK PIPE MACHINED - K3
Supplier Name & Code	100576-SANGKAJ BRIGHT WIRES PVT LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-SHORT LENGTH

1. Problem Description

Defect Description	SHORT LENGTH
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	27
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	brightwire.qa@sangakj.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	1200	650	2600
Check Qty	750	0	0	0	0	750
NG Qty	27	0	0	0	0	27

Action taken on NG part

Scrap	27
Rework	0
Under Deviation	0

Containment Action
1) At ETL end verified 750 nos out of 27 nos found defective 2) At SBWPL end verified 1850 nos foun ok. 3) Provided identification mark on ok part.

3. Process Flow

Process Flow Description
Receipt of Material - inward inspection - CNC 1st Setup - CNC 2nd Setup - Ø5 Drilling - Final Inspection - Air Cleaning - Dispatch

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	New Operator	Verified Ok	O
Machine	Wrong offset	Verified ok	O
Material	Wrong material Received	Verified Ok	O
Man	Inspector/ operator negligence-during Inspection/ process	Verified found not ok	X
Method	No arrangement to remove the stopper stick burr	Verified found not ok	X
Tool	Insert Wear Out	Verified found ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Sp. 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 short length
Why 2	Fork pipe not properly rest on stopper face
Why 3	Machining loose burr stack on stopper face
Why 4	No arrangement to remove the stopper stack burr.
Why 5	
Root Cause (Occurance)	No arrangement to remove the stopper stack burr.

Root Cause Analysis (Outflow)

Why 1	Fork pipe short length
Why 2	Skipped from operator & inspector.
Why 3	Due to operator & inspector negligence.
Why 4	
Why 5	
Root Cause (Outflow)	Due to operator & inspector negligence.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Air flushing provided on CNC machining to remove the stack burr.	Mr. Barik & Mr. Nitin Puri	11/10/2024	11/10/2024	Completed
Outflow	1) 100% inspection with the help of Spl gauge at machining stage 100% & final inspection doing 15 days.	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 in inspection method
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	No arrangement of air flushing to remove the stuck burr. 1135_Occurance_Before.xlsx
Occurance (After)	Provided Air flushining rrangement to remove the stuck burr. 1135_Occurance_After.xlsx
Outflow (Before)	Identification mark not provided after final inspection. 1135_Outflow_Before.xlsx
Outflow (After)	1) Identification mark provided after final inspection. 2) 100% inspection with the help of spl. height gauge. 3) Sampling Basis inspection with the help of DHG 1135_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Applicable all model & machine

12. Document Review

Documents	WISOP
Specify Other Document	Display OPL

13. Effectiveness Of Action

Reviewed Quantity	58

Reason for submission	Verified lot found Ok