QFR No - 8000895030

Defect Details

NC No.	8000895030
NC Date	08/10/2024
NC Submission Date	
Part No.	F800506807
Part Name	UNDER BRACKET ASSY-5TSF
Supplier Name & Code	100576-SANGKAJ BRIGHT WIRES PVT LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-STEERING SHAFT & M6 THREAD RUSTY

1. Problem Description

Defect Description	Under bracket rusty
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	223
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	600	0	0	450	225	1275
Check Qty	600	0	0	450	225	1275
NG Qty	223	0	0	0	0	223

Action taken on NG part

Scrap	223
Rework	0
Under Deviation	0

Containment Action
1) At ETL end verified 600 Nos out of 223 nos found defective. 2) At SBWPL end verify 675 nos parts & all parts found ok. 3) For ok parts provided 100 % Verification identification marking on Top face of M6 Tapping.

3. Process Flow

Process Flow Description
Material Receipt - Inward inspection - Rough boring - Boss Drilling LH & RH - Ø5 Drilling - Boss Facing - Ø5 Drilling - Top Boss Tapping - Frant Boss Tapping - Bracket Slitting - Counter Drilling - Bracket Chamfering - Bracket Debarring - Shaft & bracket pressing - Shaft & bracket welding - Wire brushing - Powder coating inward - Fine boring - M6X1-6H Re-tapping - M8X1.25-6H Tapping - Final Inspection - Rust Oil Application - Packaging & Dispatch.

4. Process Details

Process / Operation	Tapping
Outsource	No
Machine / Cell	Tapping
Machine / Cell No.	Tapping Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	There was no any further provision for applying RPO inside M6 threading.	Verified Not Ok	X
Machine	Use rusty M6 Tap	Verified Ok	O
Material	RPO Oil use non standard	Verified Ok	O
Method	Packaging damage	Verified Ok	O
Man	Inspector / Operator New	Verified Ok	O
Man	Inspector/ operator negligence-during Inspection/ process	Verified Not Ok	X
Machine	Tapping Oil use non standard	Verified Ok	O
Material	Inward Material Rusty	Verified Ok	O
Method	Inventory excess	Verified ok	O
Material	RPO Not available	Verified Ok	O
Method	FIFO Not maintained	Verified ok	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	M6X1-6H Threading Rusty
Why 2	Lack of RPO inside M6X1-6H threading.
Why 3	RPO applied only during tapping operation.
Why 4	There was no any further provision for applying RPO inside M6 threading.
Why 5	
Root Cause (Occurance)	There was no any further provision for applying RPO inside M6 threading.

Root Cause Analysis (Outflow)

Why 1	M6X1-6H Threading Rusty
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
Occurance	1.100 % RPO is to be applying inside M6 threading with the help of spl oil bottle. 2) Provided separate bin with RPO for dipping the part after final inspection. 3. Updated in the control plan & PFMEA for M6X1-6H threading Rusty.	Mr. Mukesh Rathod Mr. Manoj Pathe	11/10/2024	11/10/2024	Completed
Outflow	1) For ok parts provide 100 % Verification identification marking on Top face of M6 Tapping. 2) OPL displayed at tapping & final inspection stages for visual inspection.	Mr. Mukesh Rathod Mr. Manoj Pathe	10/10/2024	11/10/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No change in inspection method after customer complaint
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	RPO was applying during tapping only. 1139_Occurance_Before.xlsx
Occurance (After)	1.100 % RPO is to be applying inside M6 threading with the help of spl oil bottle. 2) Provided separate bin with RPO for dipping the part after final inspection. 3. Updated in the control plan & PFMEA for M6X1-6H threading Rusty. 1139_Occurance_After.xlsx
Outflow (Before)	Identification not provided after final inspection for M6 threading rusty. 1139_Outflow_Before.xlsx
Outflow (After)	1.Provide On job Training and awareness given to all inspectors and Tapping Operator for M6X1-6gH Threading rusty & its Importance 2.Display the OPL for M6X1-6H Threading Rusty at Final inspection stage. 3.For ok parts provide 100 % Verification identification marking. 1139_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes

Applicable Machine / Model / Plant	All models

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	OPL Display

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK