QFR No - 8000895378

Defect Details

NC No.	8000895378
NC Date	13/10/2024
NC Submission Date	
Part No.	530MJ00102
Part Name	SPRING SEAT
Supplier Name & Code	100144-AURANGABAD PRESSINGS
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	DIAMETER OVER SIZE-O/D OVER SIZE SPE=81.0+/-0.50 OBS=83.90

1. Problem Description

Defect Description	DIAMETER OVER SIZE-O/D OVER SIZE SPE=81.0+/-0.50 OBS=83.90
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	5
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@apw3.co.in
Plant Head/CEO Email ID	aurangabadpressings@apw3.co.in
MD Email ID	shashikant@apw3.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	0	10000	13000
Check Qty	3000	0	0	0	0	3000
NG Qty	5	0	0	0	0	5

Action taken on NG part

Scrap	5
Rework	0
Under Deviation	0

Containment Action
All Material segregation at ETL end

3. Process Flow

Process Flow Description
Blanking /Is forming /piercing/Draw /2nd draw /Trimming

4. Process Details

Process / Operation	Trimming
Outsource	No
Machine / Cell	Press Machine
Machine / Cell No.	Press shop

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Without Trimming	Without Trimming passed	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 pic

7. Root Cause Analysis (Occurance)

Why 1	OD Over size 81.0 +/-0.5 Over size 83.9
Why 2	OD Over size 81.0 +/-0.5 Over size 83.9
Why 3	Trimming part size 80.3 & before trimming 83.8
Why 4	Can not inspect by visual inspection
Why 5	
Root Cause (Occurance)	So Without Trimming component MIX up with ok component

Root Cause Analysis (Outflow)

Why 1	OD Over size 81.0 +/-0.5 Over size 83.9
Why 2	OD Over size 81.0 +/-0.5 Over size 83.9
Why 3	Trimming part size 80.3 & before trimming 83.8
Why 4	Can not inspect by visual inspection
Why 5	
Root Cause (Outflow)	So Without Trimming component MIX up with ok component

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Mixup without trimming	Deepak	13/10/2024		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Before -Sampling Inspection .After -100% Inspection by Gauge
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Inspection Method Change 1146_Occurance_Before.pdf
Occurance (After)	Inspection Method Change 1146_Occurance_After.pdf
Outflow (Before)	Inspection Method Change 1146_Outflow_Before.pptx
Outflow (After)	Inspection Method Change 1146_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Press machine / Inspection Gauge

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	PFD

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	diameter found with in specification.