QFR No - 8000895946

Defect Details

NC No.	8000895946
NC Date	17/10/2024
NC Submission Date	
Part No.	520BZ01102
Part Name	CAP OIL LOCK (K3)
Supplier Name & Code	100161-PREMIER ENGINEERS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-MIXUP

1. Problem Description

Defect Description	Specification - No identification groove required Observed – Identification groove observed
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	3
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	Quality.premier@sanghavigroup.co.in
Plant Head/CEO Email ID	prabhune.girish@sanghavigroup.co.in
MD Email ID	sanghavi.rajesh@sanghavigroup.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	0	0	1000
Check Qty	1000	0	0	0	0	1000
NG Qty	3	0	0	0	0	3

Action taken on NG part

Scrap	3
Rework	0
Under Deviation	0

Containment Action
Available lot Segregated at customer end for Identification marking On OD.

3. Process Flow

Process Flow Description
Raw Tube+Angle forming + close end forming+Grinding

4. Process Details

Process / Operation	Grinding
Outsource	No
Machine / Cell	Grinding Machine 01
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Identification provided on part on sampling basis	Identification ring provided on part	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	Ring mark On cap Oil Lock OD
Why 2	For part identification, sampling basis ring provided on part.
Why 3	sample part mixed with regular part
Why 4	
Why 5	
Root Cause (Occurance)	Identification groove ID part mixed with regular part

Root Cause Analysis (Outflow)

Why 1	Ring mark on oD
Why 2	Inspector not identified Groove on part
Why 3	Sampling basis Inspection
Why 4	
Why 5	
Root Cause (Outflow)	Sampling basis Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Trial part will be kept separately	Mr.Balraj	28/10/2024		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Separate Identification
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)	No Ring mark Verification 1158_Occurance_Before.pdf
Occurance (After)	Ring mark verification at Set up started 1158_Occurance_After.pdf
Outflow (Before)	No Inspector Training 1158_Outflow_Before.pdf
Outflow (After)	Final Inspector Training provided 1158_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Grinding machine

12. Document Review

Documents	WISOP
Specify Other Document	One point lesson

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	5. Problem Analysis - Need all 4M