QFR No - 8000896101

## Defect Details

| | |
|---|---|
| **NC No.** | 8000896101 |
| **NC Date** | 17/10/2024 |
| **NC Submission Date** | |
| **Part No.** | F2PH01202B |
| **Part Name** | valve retainer for K10 Ø18 |
| **Supplier Name & Code** | 100161-PREMIER ENGINEERS |
| **ETL Plant** | 1117-ETL K-228/9 Suspension |
| **Defect Details** | NOT AS PER SPECIFICATION-OD OVERSIZE |

## 1. Problem Description

| | |
|---|---|
| **Defect Description** | OD oversize Specification - 38.85 ±0.05 Observed - 39.074 |
| **Detection Stage** | Inprocess |
| **Problem Severity** | Fitment |
| **NG Quantity** | 5 |
| **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** | 1500 | 0 | 0 | 0 | 0 | 1500 |
| **Check Qty** | 1500 | 0 | 0 | 0 | 0 | 1500 |
| **NG Qty** | 5 | 0 | 0 | 0 | 0 | 5 |

Action taken on NG part

| | |
|---|---|
| **Scrap** | 5 |
| **Rework** | 0 |
| **Under Deviation** | 0 |

| **Containment Action** |
|---|
| Available parts at Endurance send Segregated with Meting part. |

## 3. Process Flow

| Process Flow Description |
| --- |
| Raw material+CNC+Forming and Piercing+CNC |

## 4. Process Details

| | |
| --- | --- |
| **Process / Operation** | CNC |
| **Outsource** | No |
| **Machine / Cell** | CNC 03 |
| **Machine / Cell No.** | CNC Machine |

## 5. Problem Analysis

| Type | Possible Cause | Fact Verification | Jud |
| --- | --- | --- | --- |
| Method | Improper part Clamping | During CNC part observed improper clamping during CNC operation | X |

## 6. Inspection Method Analysis (Current)

| | |
| --- | --- |
| **Inspection Method** | Other |
| **Other Inspection Method** | Digital VC |
| **Check Point at Final Inspection** | Yes |
| **Checking Freq.** | Sampling |
| **Sampling** | No |
| **Sample Size** | 20/100 |

## 7. Root Cause Analysis (Occurance)

| | |
| --- | --- |
| **Why 1** | OD oversize |
| **Why 2** | Due to part OD ovality |
| **Why 3** | Due Part loading during CNC |
| **Why 4** | part improper clamping |
| **Why 5** | Operator not aware about Part ovality |
| **Root Cause (Occurance)** | Improper clamping of part during CNC operation. |

## Root Cause Analysis (Outflow)

| | |
| --- | --- |
| **Why 1** | OD oversize |
| **Why 2** | part verification on sampling basis |
| **Why 3** | No Inspector awareness for OD oversize |
| **Why 4** | Awareness training provided to Inspector |
| **Why 5** | |
| **Root Cause (Outflow)** | Sampling basis OD Inspection. |

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

| Type | Countermeasure Details | Responsibility | Target Date | Actual Date | Status |
| --- | --- | --- | --- | --- | --- |

| | | | | | |
|---|---|---|---|---|---|
| Occurance | On CNC part clamping training provided to Operator | Mr.Vilas Kamble | 25/10/2024 | | Completed |
| Outflow | Sampling quantity increased Double sampling followed. | Mrs.Deshmukh | 25/10/2024 | | Completed |

## 9. Inspection Method After Customer Complaint

| | |
|---|---|
| **Change In Inspection System** | Yes |
| **Change Details** | Double sampling followed |
| **Inspection Method** | Other |
| **Other Inspection Method** | 20/100 part Insp |
| **Check Point at Final Inspection** | Yes |
| **Checking Freq.** | Sampling |
| **Sampling** | No |
| **Sample Size** | 20/100 |

## 10. Evidance of Countermeasure

| | |
|---|---|
| **Occurance (Before)** | After Set up no verification<br>1166_Occurance_Before.pdf |
| **Occurance (After)** | After Set Up verification Started.<br>1166_Occurance_After.pdf |
| **Outflow (Before)** | Sampling Basis Inspection<br>1166_Outflow_Before.pdf |
| **Outflow (After)** | Sampling frequency Increased<br>1166_Outflow_After.pdf |

## 11. Horizontal Deployment

| | |
|---|---|
| **Horizontal Deployment Required** | No |
| **Applicable Machine / Model / Plant** | CNC MAchine 02 |

## 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 to cover all 4M |