QFR No - 8000896112

Defect Details

NC No.	8000896112
NC Date	17/10/2024
NC Submission Date	
Part No.	F2KH01002B
Part Name	REBOUND SPRING-XF121
Supplier Name & Code	101159-TECHNOMAT SPRINGS
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	BEND-BEND

1. Problem Description

Defect Description	Bend
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	6
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@technomatsprings.com
Plant Head/CEO Email ID	technomatsprings@gmail.com
MD Email ID	patilsadanand@technomatsprings.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	15000	0	0	28000	0	43000
Check Qty	15000	0	0	28000	0	43000
NG Qty	6	0	0	0	0	6

Action taken on NG part

Scrap	6
Rework	0
Under Deviation	0

Containment Action
Checked all material at customer end and pipeline material also.

3. Process Flow

Process Flow Description
R/m In-warding Inspection > Coiling > Stress Relieving-1 > Grinding > Shot Peening > Stress Relieving-2 > Final Inspection > Oiling > Packing > Dispatch.

4. Process Details

Process / Operation	coiling
Outsource	No
Machine / Cell	-
Machine / Cell No.	-

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Wrong Material / Grade	Supplier RMTC Report checked found Ok	O
Man	Unskilled Operator	Skilled matrix found ok	O
Tool	Tool Loose / Tool thread wear out	found pitch tool locking bolt thread wear out	X
Machine	Machine check Sheet not followed	Found machine JH activity done as per the mentioned freq.	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50 Nos

7. Root Cause Analysis (Occurance)

Why 1	Un-Grounded Spring observed.
Why 2	Grinding operation not done.
Why 3	spring length undersized in coiling operation.
Why 4	Due to pitch tool locking thread wear out.
Why 5	No check point available for thread locking wear out in JH check sheet.
Root Cause (Occurance)	No check point available for thread locking wear out in JH check sheet.

Root Cause Analysis (Outflow)

Why 1	Un-Grounded Spring observed.
Why 2	Defective parts escaped from inspection.
Why 3	Defective parts was few due to that not arrested in insp.
Why 4	Inspection Done on sampling Basis.
Why 5	
Root Cause (Outflow)	Inspection done on sampling basis and defective parts were less so not arrested in final inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	100% Visual Inspection started.	Mr. Anuj Shelke	07/11/2024	07/11/2024	Inprocess
Occurance	Check point added in JH check sheet.	Mr. Khandare	07/11/2024	07/11/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% visual inspection started.
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)	In the JH check sheet,the nut bolt looseness point was not mentioned. 1167_Occurance_Before.xlsb
Occurance (After)	In the JH check sheet, nut bolt looseness point has been added. 1167_Occurance_After.xlsb
Outflow (Before)	Inspection done as per the sampling plan. 1167_Outflow_Before.xlsb
Outflow (After)	100% inspection has started. 1167_Outflow_After.xlsb

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Horizontally deployed for the all similar machines.

12. Document Review

Documents	JHCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	