QFR No - 8000903666

Defect Details

NC No.	8000903666
NC Date	14/12/2024
NC Submission Date	
Part No.	F2FA30233B
Part Name	FORK PIPE MACHINED
Supplier Name & Code	101223-SANGKAJ BRIGHT WIRES PRIVATE L
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	MATERIAL DEFECT-FORK PIPE CRACK

1. Problem Description

Defect Description	K1KG front fork leakage observed in fork pipe area because of fork pipe material issue(crack)
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	vqoek5tfr3bscmjep4y15qyt.gif

Supplier Communication Details

Quality Head Email ID	kolarbright@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	3920	0	0	2000	3000	8920
Check Qty	3739	0	0	2000	3000	8739
NG Qty	181	0	0	0	0	181

Action taken on NG part

Scrap	181
Rework	0
Under Deviation	0

Containment Action
All material segregated from TI Supplier(ETL+Sangkaj)

3. Process Flow

Process Flow Description
Tube Forming+ Annealing+ Wet Process + Push Pointing + Drawing + Stress releving + Straightening + eddy current testing + cut length + facing & chamfering + final inspection + packing

4. Process Details

Process / Operation	tube forming
Outsource	Yes
Machine / Cell	TI
Machine / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Eddy current testing flaw detection failure	ECT software hanging issue faced while tube testing & re-started the PC	O
Machine	Weld Bond area Low Heat Penetration	During mill running tow bar & impeder unit serviced due to coolant flow blockage	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	eddy current testing
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5 nos

7. Root Cause Analysis (Occurance)

Why 1	Weld Bond area Low Heat Penetration.
Why 2	Impeder to strip edge EMF conductivity Low
Why 3	Insufficient coolant flow to impeder core.
Why 4	Impeder coolant flow line blockage due to oxide chips & sludge.
Why 5	Coolant Flow line orifice diameter insufficient
Root Cause (Occurance)	Coolant Flow line orifice diameter insufficient

Root Cause Analysis (Outflow)

Why 1	Eddy current testing flaw detection failure
Why 2	ECT may accepted the Flaw product.
Why 3	Momentary failure of Ect software TEST ON signal output
Why 4	System software hang while ECT process period
Why 5	
Root Cause (Outflow)	System software hang while ECT process period

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Tow bar inner diameter increased from 3mm to 6mm for free flow of coolant	Mr Maharajan	21/12/2024	21/12/2024	Completed
Outflow	System software hang while ECT process period.	Mr Maharajan	18/12/2024	18/12/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no change
Inspection Method	Other
Other Inspection Method	Eddy current testing
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5 nos

10. Evidance of Countermeasure

Occurance (Before)	Tow bar inner diameter 3mm which is blocked due to fine oxide chips interruption. 1277_Occurance_Before.png
Occurance (After)	Tow bar inner diameter increased from 3mm to 6mm for free flow of coolant. 1277_Occurance_After.png
Outflow (Before)	System software hang while ECT process period. 1277_Outflow_Before.png
Outflow (After)	To prevent defect outflow, the ECT conveyor will be stopped after 3seconds in case of "ECT software hang & TEST signal not indicated 1277_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	no

12. Document Review

Documents	
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	20000
Reason for submission	Reviewed 20000 no`s found ok