QFR No - 7000824219

Defect Details

NC No.	7000824219
NC Date	10/03/2022
NC Submission Date	
Part No.	165FY00422
Part Name	HUB CLUTCH 3W4S MACHINED & BROACHED
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	DIMETER UNDERSIZE-minor dia u/s plug not qualify

1. Problem Description

Defect Description	Minor dia u/s plug not qualify
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	12
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	madhuradiecast@gmail.com
Plant Head/CEO Email ID	madhuradiecast@gmail.com
MD Email ID	madhuradiecast@gaikegroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1350	0	0	500	800	2650
Check Qty	1350	0	0	500	800	2650
NG Qty	12	0	0	2	0	14

Action taken on NG part

Scrap	14
Rework	0
Under Deviation	0

Containment Action
1.100% Stock segregate at customer end and Supplier end stock.

3. Process Flow

Process Flow Description
1.Casting 2.fetling 3. CNC 1st Set-up 4.CNC 2nd Set-up 5.Broaching 6.Final Inspection

4. Process Details

Process / Operation	Broaching
Outsource	No
Machine / Cell	BROACHING
Machine / Cell No.	MDCPL/BROACHING/01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Component was not proper kept on broaching fixture.	Broaching fixture checked and verify found ok	O
Man	Unskilled operator operated machine	Skill matrix plan verify operator is skillful found	O
Tool	Broach tool life monitoring not effectively monitor	Tool life monitoring sheet not available.	X
Material	Hard point impurity material is used for broaching	Component checked found ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1 : 5

7. Root Cause Analysis (Occurance)

Why 1	Broch wear
Why 2	Broach Reshaping not done as per decided frequency
Why 3	
Why 4	
Why 5	
Root Cause (Occurance)	1.Broch wear 2.Broach tool life not monitor

Root Cause Analysis (Outflow)

Why 1	Inspection frequency is less
Why 2	unskilled inspector
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Inspection frequency is less

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	1. Inspection frequency of minor dia by plug gauge increases	QA.Supervisor	04/01/2022		Completed
Occurance	1.Tool life monitoring incorporated in Broaching machine. 2.Broach tool monitoring sheet is available and verify by production supervisor	Production Supervisor	04/01/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Minor dia checking and final inspection by plug gauge on sampling bases and started 100% by plain plug gauge
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:5

10. Evidance of Countermeasure

Occurance (Before)	Broach wear broach life not effectively monitored as per decide frequency 12_Occurance_Before.jpeg
Occurance (After)	Broach life monitoring started as per decide frequency & start verifying pokayoke verification sheet on weekly basis for broach machine counter 12_Occurance_After.pdf
Outflow (Before)	Inspection Frequency less 01:05 on sampling basis 12_Outflow_Before.pdf
Outflow (After)	Control plan updated at final inspection stage for minor dia inspection started 100% by plain plug gauge 12_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Broach Machine

12. Document Review

Documents	ControlPlan, PokayokeCheckSheet, InspCheckSheet
Specify Other Document	Broach life sheet

13. Effectiveness Of Action

Reviewed Quantity	10000

Reason for submission	There is one system we have implemented to monitor broach tool life why it was bypassed pl give explanation and action on same