QFR No - 7000829356

Defect Details

NC No.	7000829356
NC Date	02/04/2022
NC Submission Date	
Part No.	520AE00400
Part Name	CORE PLATE REDUCED 612
Supplier Name & Code	100959-AAR CEE ENGINEERING WORKS UNIT
ETL Plant	1135-ETL 7/10 P Nagar
Defect Details	SURFACE FINISH NOT OK-

1. Problem Description

Defect Description	Shot Blasting not done on plates and in some plates Shot blasting done on one side.
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	5000
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qc@aarceeengg.com
Plant Head/CEO Email ID	planthead.diecasting@aarceeengg.com
MD Email ID	vaibhav.arora@aarceeengg.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5000	0	0	0	0	5000
Check Qty	5000	0	0	0	0	5000
NG Qty	5000	0	0	0	0	5000

Action taken on NG part

Scrap	0
Rework	5000
Under Deviation	0

Containment Action
5000 pcs lot return back to supplier end (AAR CEE), New Ok lot provided for the same.

3. Process Flow

Process Flow Description
1. Receipt of Raw Material 20. Storage of Raw Material 30. Holding Cum Melting 40. PDC 50. Trimming 60. Shot Blasting 70. Barrelling 80. Sound Testing 90. Stress Relieving 100. Final Inspection & Packing 110. Storage & Dispatch

4. Process Details

Process / Operation	60. Shot Blasting
Outsource	No
Machine / Cell	Shot Blasting Machine
Machine / Cell No.	SBM-02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05 pieces

7. Root Cause Analysis (Occurance)

Why 1	Shot blasting was not done due to Shot leakage from the shot blasting machine
Why 2	Shot leakage due to machine body wear out from the backside of the machine
Why 3	Machine body wear out due to liner bolt broken
Why 4	
Why 5	
Root Cause (Occurance)	Liner Bolt broke at the inner side of the liner.

Root Cause Analysis (Outflow)

Why 1	Shot blasting was not done on core plates due to final inspectors were not able to detect the pieces
Why 2	Due to barrelling process, it is not possible to detect such kinds of pieces by final inspectors
Why 3	Ra value checks at only PDIR after barrelling process.
Why 4	
Why 5	
Root Cause (Outflow)	Ra value checks at only PDIR after barrelling

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	At final inspection WI Ra value checkpoint to be added to check per hour
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5pcs/hr

10. Evidance of Countermeasure

Occurance (Before)	The liner bolt broke at the inner side of the liner 38_Occurance_Before.jpeg
Occurance (After)	The Liner bolt changed 38_Occurance_After.pdf
Outflow (Before)	At final inspection only PDIR done 38_Outflow_Before.pdf
Outflow (After)	Now at the final inspection Roughness value to be checked for every hour & if roughness found less then lot to be hold & re-shot blasting to be done 38_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All core plate models

12. Document Review

Documents	WISOP
Specify Other Document	No other documents

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok