QFR No - 7000833423

Defect Details

NC No.	7000833423
NC Date	27/04/2022
NC Submission Date	
Part No.	165PP01317
Part Name	WHEEL CLUTCH -4 PLATE VAVE
Supplier Name & Code	101100-CAST 4 ALUMINIUM PVT LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	PCD SHIFT-4Hole Lug Pcd Not ok

1. Problem Description

Defect Description	4 Hole Lug PCD Not ok
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	148
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	info@cast4aluminium.com
Plant Head/CEO Email ID	info@cast4aluminium.com
MD Email ID	kiran@cast4aluminium.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1560	0	0	2500	3000	7060
Check Qty	1560	0	0	2500	3000	7060
NG Qty	148	0	0	0	0	148

Action taken on NG part

Scrap	148
Rework	0
Under Deviation	0

Containment Action
Recheck all pipeline material to PCD gauge.

3. Process Flow

Process Flow Description
Melting- casting- fettling- Inprocess inspection- CNC machining- 4 hole drilling and tapping- Final inspection- Packaging- Dispatch.

4. Process Details

Process / Operation	4 Hole drilling & tapping.
Outsource	Yes
Machine / Cell	VMC Machine
Machine / Cell No.	VMC Machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	1) 4 Lug Not qualify to PCD Gauge. 2) .Due to Fixture Clamping Loose One side.	Due to Fixture Clamping Loose One side.	O

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	4 Lug not qualify to PCD Gauge.
Why 2	Fixture Clamping Loose from one side.
Why 3	Due to this part not rest properly in fixture.
Why 4	
Why 5	
Root Cause (Occurance)	Fixture Clamping Loose from one side.

Root Cause Analysis (Outflow)

Why 1	100 % inspection at final stage without marking.
Why 2	Operator knowledge not found evident.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	100 % Inspection at Final stage without marking

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Proper Tight Clamping Fixture Both side.	Mr. Thakur.	23/03/2022	23/03/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Start 100% inspection with identification marking.
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Fixture PM check sheet. 73_Occurance_Before.xlsx
Occurance (After)	Fixture PM check sheet & JH check sheet 73_Occurance_After.xlsx
Outflow (Before)	Without marking. 73_Outflow_Before.jpg
Outflow (After)	Inspection marking. 73_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Not applicable

12. Document Review

Documents	PMCheckSheet, JHCheckSheet, InspCheckSheet
Specify Other Document	Fixture check sheet.

13. Effectiveness Of Action

Reviewed Quantity	5000
Reason for submission	OK