QFR No - 7000839800

Defect Details

NC No.	7000839800
NC Date	30/05/2022
NC Submission Date	
Part No.	C2PP00320B
Part Name	WHEEL CLUTCH_C20009_D1
Supplier Name & Code	100432-BHAKTI AUTO COMP PRIVATE LIMIT
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	PCD SHIFT-PCD GAUGE NOT QUALIFY

1. Problem Description

Defect Description	Part are not qualifying to PCD gauge
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	40
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	sales@bhaktiauto.com
Plant Head/CEO Email ID	sales@bhaktiauto.com
MD Email ID	vinodanin@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	300	0	0	500	0	800
Check Qty	300	0	0	500	0	800
NG Qty	1	0	0	1	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action
100% Inspection at final inspection stage

3. Process Flow

Process Flow Description
Pressure Die casting-fettling-machining-Drilling-Tapping-Inspection-dispatch

4. Process Details

Process / Operation	Drilling/Tapping
Outsource	Yes
Machine / Cell	VMC
Machine / Cell No.	VMC cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Part Orientation of fixture	Part orientation is at casting oil hole	O

6. Inspection Method Analysis (Current)

Inspection Method	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	PCD Not Ok
Why 2	Part not located properly on fixture
Why 3	part locating in on casting oil hole
Why 4	oil hole has more clearance
Why 5	Non precise parameter
Root Cause (Occurance)	part not mounted properly in its position on fixture.

Root Cause Analysis (Outflow)

Why 1	PCD not ok
Why 2	part inspection missing
Why 3	final inspection not done
Why 4	sampling inspection
Why 5	
Root Cause (Outflow)	Sampling inspection hence part not detected in final inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	PCD inspection 100% to be done at final inspection	Bhakti Auto	01/06/2022	01/06/2022	Completed

Occurance	Part orientation locator to be change	OM Mahabali	15/06/2022	15/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	PCD gauge 100% inspection implemented instead of sampling
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Pin Locator 157_Occurance_Before.pdf
Occurance (After)	Spring mechanism locator 157_Occurance_After.pdf
Outflow (Before)	Sampling Inspection 157_Outflow_Before.pdf
Outflow (After)	100% Inspection 157_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	No

12. Document Review

Documents	ControlPlan
Specify Other Document	x

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	OK