QFR No - 7000876117

Defect Details

NC No.	7000876117
NC Date	11/11/2022
NC Submission Date	
Part No.	520AE05702
Part Name	CORE PLATE - SHINE & UNICORN
Supplier Name & Code	101145-STAR PROJECTS INDIA
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	FLATNESS NOT OK.-Ga gauge not qualify due to flatness o/s

1. Problem Description

Defect Description	Flatness Not OK -Not Qualify to gap gauge
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	9250
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qualityhead@starprojectsindia.com
Plant Head/CEO Email ID	engineering@starprojectsindia.com
MD Email ID	ishant@starprojectsindia.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	15000	150000	0	0	0	165000
Check Qty	15000	0	0	0	0	15000
NG Qty	9250	0	0	0	0	9250

Action taken on NG part

Scrap	9250
Rework	0
Under Deviation	0

Containment Action
All Material has been hold for 100% Re-Inspection for same with proper identification.

3. Process Flow

Process Flow Description
Receipt of Raw Material-Storage of raw material-Melting-PDC-1st Trimming-shot Blasting-1-2nd Trimming-Barreling-Shot Blasting-2-Sound Testing-Stress relieving-Final Inspection & packing-Storage & Dispatch.

4. Process Details

Process / Operation	Stress Relieving
Outsource	No
Machine / Cell	Oven-02
Machine / Cell No.	No

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Lug Matching Sequence	Lug Matching Sequence was Disturb	X
Man	Negligency Done by Inspector	Semi-Skilled operator was there	X
Tool	Receiving Gauge Wear out	Base Size and lug size of slip gauge found at higher point.	X
Method	Heating parameter disturb	Heating Parameter Observed 261°C against 270±20°C	O
Method	Receiving Gauge Validation Plan	Receving Gauge Validation Plan was Available but not done Properly	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Flatness Found NG in core Plate C-101
Why 2	Due to Lug Matching Sequence was Disturb
Why 3	Due to improper material handling during heating
Why 4	Semi-Skilled operator was there
Why 5	
Root Cause (Occurance)	Due to Lug Matching Sequence was disturbed

Root Cause Analysis (Outflow)

Why 1	100% parts was checked by receiving gauge
Why 2	Receiving gauge was not detected the defective parts
Why 3	Due to Base Size and lug size of Receiving gauge found at higher point
Why 4	Receiving Gauge wear out
Why 5	
Root Cause (Outflow)	Receiving Gauge wear out

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Receiving gauge validation plan has been updated and adhered	Ajay Malik	10/11/2022	10/11/2022	Completed
Outflow	Training has been provided to Inspectors & Operator	Ajay malik	09/11/2022	09/11/2022	Completed
Occurance	Receiving Gauge Rectification Has been done..	Ajay Malik	10/11/2022	10/11/2022	Completed
Occurance	Check Point added in heating WI	Ajay Malik	10/11/2022	10/11/2022	Completed
Outflow	Inspectior & Gauger Identification Code has been marked on every Boxes	Ajay Malik	10/11/2022	10/11/2022	Completed
Outflow	100% marking Implemented on every lot	Ajay malik	10/11/2022	10/11/2022	Completed
Outflow	Quality Alert made and displayed at concerned area	Ajay malik	09/11/2022	09/11/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspector & Gauger Identification Code has been marked on every Boxes With 100% Marking on parts
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	Per Lot

10. Evidance of Countermeasure

Occurance (Before)	Check Point Not added in Heating WI 300_Occurance_Before.pdf
Occurance (After)	Check Point added in Heating WI 300_Occurance_After.pdf
Outflow (Before)	No Check Point Available for Proper Identification 300_Outflow_Before.pdf
Outflow (After)	Inspector & Gauger Identification Code has been marked on every Boxes. 300_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	In All Model of Core Plate

12. Document Review

Documents	WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	5000
Reason for submission	OK