QFR No - 7000884827

Defect Details

NC No.	7000884827
NC Date	21/12/2022
NC Submission Date	
Part No.	520CE00502
Part Name	CLUTCH SHAFT ASSEMBLY DI ENGINE
Supplier Name & Code	200172-AURANGABAD AUTO ENGG PVT LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	M/CING SHIFT.-Key width position shift

1. Problem Description

Defect Description	Hole Position shift w.r.t key way slot
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	100
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	verma.aaepl@gmail.com
Plant Head/CEO Email ID	aaepl.pantnagar@sangkaj.com
MD Email ID	steel@sangkaj.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	280	0	0	0	0	280
Check Qty	280	0	0	0	0	280
NG Qty	80	0	0	0	0	80

Action taken on NG part

Scrap	80
Rework	0
Under Deviation	0

Containment Action
100% WIP rechecked by visual Inspection

3. Process Flow

Process Flow Description
Pressing - CNC - Bush pressing - OD grinding - Keyway broaching .

4. Process Details

Process / Operation	Keyway broaching
Outsource	No
Machine / Cell	Broaching Machine
Machine / Cell No.	Gear Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Part not located in broaching fixture	Locating pin length short	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	Locating hole Dia. 5mm position shift w.r.t. keyway Broaching.
Why 2	Keyway Broaching shift during broachng operation.
Why 3	Hole not guide in position in pin
Why 4	Less Awareness of operator for process
Why 5	
Root Cause (Occurance)	Less Awareness of operator for process.

Root Cause Analysis (Outflow)

Why 1	Locating hole Dia. 5mm position shift w.r.t. keyway Broaching.
Why 2	Hole w.r.t. Keyway broaching relation gauge done on Sampling basis.
Why 3	Hole w.r.t. Keyway broaching relation gauge done on Sampling basis.
Why 4	
Why 5	
Root Cause (Outflow)	Hole w.r.t. Keyway broaching relation gauge done on Sampling basis.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
	1) Hole guide pin position height incressed from 2mm				

Occurance	to 8mm. 2) Concern operator training provided for this defect.	Mr.BAde	31/12/2022	29/12/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1) Hole w.r.t. Keyway broaching relation gauge done on 100%. 2) After Gauge insection 100% visual inspection with identification line marking with marker putted on face. 3)All final inspector training provided for this defect.
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)	Less Awareness of operator for process. 325_Occurance_Before.xlsx
Occurance (After)	1) Hole guide pin position height increased from 2mm to 8mm. 2) Concern operator training provided for this defect. 325_Occurance_After.xlsx
Outflow (Before)	Hole w.r.t. Keyway broaching relation gauge done on Sampling basis. 325_Outflow_Before.xlsx
Outflow (After)	1) Hole w.r.t. Keyway broaching relation gauge done on 100%. 2) After Gauge insection 100% visual inspection with identification line marking with marker putted on face. 3)All final inspector training provided for this defect. 325_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	No

12. Document Review

Documents	ControlPlan, PokayokeCheckSheet, PFMEA, WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	OK