QFR No - 7000890664

Defect Details

NC No.	7000890664
NC Date	16/01/2023
NC Submission Date	
Part No.	S2BG02502B
Part Name	BRACKET UN P/C KTEP
Supplier Name & Code	100973-TESMO MOTORCAST PRIVATE LIMITE
ETL Plant	1116-ETL K-120 Suspension
Defect Details	THREADING NOT OK-Threading and Casting Defect

1. Problem Description

Defect Description	Major & fitment related defects like threading NG, Blow holes, cracks etc. repetitively observed.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	1100
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rkhare@tesmomotorcast.com
Plant Head/CEO Email ID	harish.bala@tesmomotorcast.com
MD Email ID	svkallani@tesmomotorcast.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1100	0	0	6000	13000	20100
Check Qty	1100	0	0	6000	13000	20100
NG Qty	1100	0	0	20	0	1120

Action taken on NG part

Scrap	20
Rework	0
Under Deviation	0

Containment Action
Perpendicularity checking gauge made and start hourly checking

3. Process Flow

Process Flow Description
PDC - Deburring - Remer - surface treatment - Camper - tapping - Air Cleaning - Packing

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	250-2
Machine / Cell No.	2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	core pin hardness not ok	hardness testing report check	O
Tool	side core not proper open	gauge	O
Tool	Die Core Side Pin Bend	Perpendicularity gauge	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	Every Hr

7. Root Cause Analysis (Occurance)

Why 1	Tap not gone up to required depth
Why 2	Tap jam while completing its cycle
Why 3	Hole pin perpendicularity not ok
Why 4	Die core pin bend
Why 5	Pin hardness not as per requirement
Root Cause (Occurance)	Core pin hardness not freeze.

Root Cause Analysis (Outflow)

Why 1	Tap not gone up to required depth
Why 2	Tap jam while completing its cycle
Why 3	Hole pin perpendicularity not ok
Why 4	Die core pin perpendicularity not ok
Why 5	Perpendicularity not check
Root Cause (Outflow)	Core pin Perpendicularity checking frequency not defined.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Hourly pin hole Perpendicularity checking	Rahul	27/06/2023		Pending
Occurance	Pin hardness freeze	Sachin	27/06/2023		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Perpendicularity checking started on hourly check on PDC
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	500

10. Evidance of Countermeasure

Occurance (Before)	Threading not OK 331_Occurance_Before.jpeg
Occurance (After)	Threading ok 331_Occurance_After.jpeg
Outflow (Before)	THREADING NOTOK 331_Outflow_Before.jpeg
Outflow (After)	THREADING OK 331_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	kwpk

12. Document Review

Documents	InspCheckSheet
Specify Other Document	GAUGE CHEKING

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	