QFR No - 7000891160

Defect Details

NC No.	7000891160
NC Date	19/01/2023
NC Submission Date	
Part No.	S2BG03908B
Part Name	BKT POWDER COATED
Supplier Name & Code	101032-ASM CASTINGS PRIVATE LIMITED (
ETL Plant	1116-ETL K-120 Suspension
Defect Details	THREADING NOT OK-Threading Not ok

1. Problem Description

Defect Description	Ejection pin mark observed on spring resting face. Same causing assembly function not OK.
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	520
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@asmcastings.in
Plant Head/CEO Email ID	skaul@asmcastings.in
MD Email ID	rajiv@asmcastings.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	14000	2500	0	3500	460	20460
Check Qty	14000	2500	0	3500	460	20460
NG Qty	520	0	0	39	0	559

Action taken on NG part

Scrap	559
Rework	0
Under Deviation	0

Containment Action
Segregation & Yellow Marking on Ok Parts

3. Process Flow

Process Flow Description
RM Receiving - Die Casting - Fattling - Reamer- Shot Blasting - Drilling & Threading - Final Inspection & PDI - Dispatch

4. Process Details

Process / Operation	Machining
Outsource	No
Machine / Cell	Machine Shop
Machine / Cell No.	SPM-02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Tool Blunt (Life Over)	Tool History Card verified & Found Ok	X
Machine	Tool Position not ok in machine	Machine P.M. Record verified & Found Ok	X
Material	R.M. of Insert not ok	MTC report verified & Found Ok	X
Method	Cleaning of thread not adequate in Machining	Air Application check point not available in control plan	O
Man	Semi Skilled operator	Skill Matrix verified & Found ok	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05 Nos./hr

7. Root Cause Analysis (Occurance)

Why 1	Thread not cleaned during machining
Why 2	Thread Clean by Coolent only which is not adequate .
Why 3	No Check point added in control plan for Air Cleaning of thread in machining.
Why 4	
Why 5	
Root Cause (Occurance)	No Check Point added in Control Plan for Air Cleaning of Thread in Machining.

Root Cause Analysis (Outflow)

Why 1	Thread NG Parts skipped from Final Inspection
Why 2	Inspector Not aware
Why 3	Limit Sample not displayed at Final Inspection area.
Why 4	
Why 5	
Root Cause (Outflow)	Limit Sample Not Displayed at final Inspection area.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Check Point added in Control Plan for Air Cleaning in machining.	Lalit Sharma	01/02/2023	01/02/2023	Completed
Outflow	Limit Sample displayed at Final Inspection area	Ateev Sharma	01/02/2023	01/02/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	Inspection System is same although Limit sample is displayed .
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Check point not available in control plan for air cleaning 334_Occurance_Before.pdf
Occurance (After)	Check Point added in control plan for Air Cleaning 334_Occurance_After.pdf
Outflow (Before)	Limit sample not available at final inspection area 334_Outflow_Before.jpeg
Outflow (After)	limit sample provided at final inspection area. 334_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	SPM Machine

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	Q-Alert

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	Completed.