QFR No - 7000891906

Defect Details

NC No.	7000891906
NC Date	24/01/2023
NC Submission Date	
Part No.	520KN00173
Part Name	RESERVOIR CAP RAW CASTING
Supplier Name & Code	101032-ASM CASTINGS PRIVATE LIMITED (
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	BLOW HOLES-Blow Hole Damages

1. Problem Description

Defect Description	BLOW HOLES-Blow Hole Damages
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	8000
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	8000	12000	0	8000	2580	30580
Check Qty	8000	12000	0	8000	2580	30580
NG Qty	0	72	0	21	14	107

Action taken on NG part

Scrap	107
Rework	0
Under Deviation	0

Containment Action
All Material Re-checked & Dot Marking done on the same for identification.

3. Process Flow

Process Flow Description
R.M. Receiving - Die Casting - Fatling - Lancering & Buffing - Drilling -Shot Blasting - Final - Inspection & PDI - Packing -Dispatch.

4. Process Details

Process / Operation	Die Casting
Outsource	No
Machine / Cell	Die Casting
Machine / Cell No.	PDC-04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Machine P.M. Not done	P.M. Check Sheet verified & Found OK	X
Man	New operator	Verbal Interview taken & Found OK	X
Tool	Die Life Over	Die History Card found Ok	X
Material	Chemical Composition not ok	MTC Verified & Found OK	X
Method	Inspection method not adeqaute	single part inspection not done (4 to 5 parts are kept in hand by inspector & Checked together)	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Blow Holes in Casting
Why 2	Material pouring Method Not ok in PDC Machine
Why 3	Air & Gasses mixed material poured in Production which causes blow holes.
Why 4	Material Pouring Done at the time of Degassing Also
Why 5	Operator not aware about stop production during Degassing. (No Training /Q-Alert Available for the Same)
Root Cause (Occurance)	Training not provided to operator for Stopping production during degassing process.

Root Cause Analysis (Outflow)

Why 1	Inspection Method not adequate
Why 2	Single part Inspection not done by Inspector (4 to 5 Part checked at once which causes flow of NG Parts)
Why 3	Inspector Not aware about singe part inspection
Why 4	Check Point not added in Work Instruction for single Part Inspection
Why 5	
Root Cause (Outflow)	Check Point not added in Work Instruction for single Part Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Training Provided to Operators for Stopping production during degassing	Lalit Sahrma	01/02/2023	01/02/2023	Completed
Outflow	Check point added in Work Instruction for Single Part Inspection .	Ateev Sharma	01/02/2023	01/02/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Single Part Inspection started in-place of 4 to 05 parts in final inspection.
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)	Operator was not aware about Stopping Production during Degassing. 350_Occurance_Before.pdf
Occurance (After)	Training Provided to Operators for Stopping production during Degassing. 350_Occurance_After.pdf
Outflow (Before)	check point was not available in W.I. for Single part Inspection 350_Outflow_Before.pdf
Outflow (After)	Check Point added in W.I. for Single Part Inspection. 350_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	PDC

12. Document Review

Documents	PFMEA, WISOP
Specify Other Document	Training Record

13. Effectiveness Of Action

Reviewed Quantity	24000
Reason for submission	No defect found in 3 lot