QFR No - 7000916467

Defect Details

NC No.	7000916467
NC Date	19/05/2023
NC Submission Date	
Part No.	165PP00517
Part Name	WHEEL CLUTCH-XCD
Supplier Name & Code	100729-EESHWAR METALS
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	HIGHT O/SIZE.-lug ht obs 24.74 against 24.40-0.20 mm

1. Problem Description

Defect Description	1.Friction Face to Lug Height Oversize upto 24.74 mm against 24.4 -0.2 mm 2.Machining Face to Friction Face Height 7.2-0.1 mm found up to 6.78~6.80 mm
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	120
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	eeshwarwaluj@emmesmetals.com
Plant Head/CEO Email ID	eeshwarwaluj@emmesmetals.com
MD Email ID	lalitmohan@emmesmetals.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	860	0	0	1020	560	2440
Check Qty	860	0	0	1020	560	2440
NG Qty	106	0	0	5	0	111

Action taken on NG part

Scrap	111
Rework	0
Under Deviation	0

Containment Action
100% Inspection By Height Gauge with Identification Marking at Back Face

3. Process Flow

Process Flow Description
CNC Operation

4. Process Details

Process / Operation	CNC
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Machine Breakdown due to Production Running condition	Machine Brakedown	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	5 Nos /h

7. Root Cause Analysis (Occurance)

Why 1	Lug Height Over size
Why 2	due to Mechanical Turret Tool Alignment `z` axis Disturb
Why 3	Due to Production Running Condition
Why 4	
Why 5	
Root Cause (Occurance)	CNC Machine PM Complete

Root Cause Analysis (Outflow)

Why 1	Frequency of Lug Height Inspection 100% By height Gauge
Why 2	No Marking On Part For Lug Height Inspection
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	started 100 % Lug Height Inspection By Height Gauge

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Machine Breakdown correct	Mr. Kailash Ladone	20/05/2023	19/05/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	started 100 % Lug Height Inspection By Special Gauge
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)	Lug Height sampling Inspection done By Height Gauge 452_Occurance_Before.xlsx
Occurance (After)	Started 100 % Lug Height Inspection By Special gauge 452_Occurance_After.xlsx
Outflow (Before)	CNC Machine Breakdown due to Production running Condition 452_Outflow_Before.jpg
Outflow (After)	Corrected Mechanical Turret Tool Alignment ` Z` Axis 0.01 to 0.02 mm 452_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	CNC SHOP

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	10000
Reason for submission	Cause side Action not up to the mark & Need to provide attribute type gauge for 100% Inspection