QFR No - 7000936274

Defect Details

NC No.	7000936274
NC Date	10/08/2023
NC Submission Date	
Part No.	520AE00300
Part Name	CORE PLATE 3W 4S
Supplier Name & Code	100959-AAR CEE ENGINEERING WORKS UNIT
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	FLATNESS NOT OK.-flatness obs 0.30 against 0.10 mm

1. Problem Description

Defect Description	3W4S Core Plate Not qualify to gap gauge (Flatness found oversize up to 0.3 mm against 0.1 mm)
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	10000
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qc@aarceeengg.com
Plant Head/CEO Email ID	planthead.diecasting@aarceeengg.com
MD Email ID	vaibhav.arora@aarceeengg.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	16000	0	0	7000	0	23000
Check Qty	16000	0	0	7000	0	23000
NG Qty	1200	0	0	55	0	1255

Action taken on NG part

Scrap	0
Rework	1255
Under Deviation	0

Containment Action
Material segregated at the customer end(ETL end) & our end (AAR CEE end)NG parts to be re-shot Blasting

3. Process Flow

Process Flow Description
10.Receipt of raw material 20.Storage of raw material 30.Holding cum melting 40. PDC stage 50.Trimming process 60.Shot Blasting 70. Barrelling process 80.Sound Testing 90.stress reliving 100.Final inspection 110.Storage & Dispatch

4. Process Details

Process / Operation	60.Shot blasting & 100. Final inspection
Outsource	No
Machine / Cell	Shot blasting machine
Machine / Cell No.	SBM-02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Improper shot size used at shot blasting	Obsed SS 0.30 mm shot	O
Man	skipped at final inspection	ok limit sample not displayed at final inspection table	X
Method	Improper stress reliving process	Checked and found fixture flatness found up to 0.35 mm	X
Method	Improper cycle time at shot blasting	Found ok ,6 minutes against 5~7 minutes	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 pcs/lot

7. Root Cause Analysis (Occurance)

Why 1	FLATNESS NOT OK.-flatness obs 0.30 against 0.10
Why 2	shot blasting is not done as per defined frequency.
Why 3	process parameter monitoring not done.
Why 4	lack of awareness of operator
Why 5	
Root Cause (Occurance)	process parameter monitoring not done.

Root Cause Analysis (Outflow)

Why 1	FLATNESS NOT OK.-flatness obs 0.30 against 0.10
Why 2	NG pieces were skipped by final inspection.
Why 3	limit sample not displayed in final inspection area.
Why 4	
Why 5	
Root Cause (Outflow)	limit sample not displayed in final inspection area.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	QC inspection given to the tanning	Mukesh	01/09/2023	01/09/2023	Completed
Outflow	OK LIMIT SAMPLE DISPLAY AT FINAL INSPECTION AREA	MUKESH	03/09/2023	01/09/2023	Completed
Occurance	Fixture corrected	Ajay Malik	20/10/2023	20/10/2023	Completed
Occurance	Heating Fixture validation plan made and adhere for	Ajay Malik	23/10/2023	23/10/2023	Completed
Outflow	Standard operating procedure made and adhere for gap gauge verification & handling	Ajay Malik	23/10/2023	23/10/2023	Completed
Outflow	Standard operating procedure made and adhere for gap gauge verification & handling	Ajay Malik	23/10/2023	23/10/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no change
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	10 pcs 1 h

10. Evidance of Countermeasure

Occurance (Before)	FORMAT AVAILABLE BUT NOT UPDATED 524_Occurance_Before.pdf
Occurance (After)	GIVEN TANNING AND RECORDED STARTED 524_Occurance_After.pdf
Outflow (Before)	LIMIT SAMPLE NOT DISPLAYED 524_Outflow_Before.jpg
Outflow (After)	LIMIT SAMPLE DISPLAY 524_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	10000
Reason for submission	Repeated Occurrence at ETL end -Gap Inspection activity need to strengthen