QFR No - 7000943532

Defect Details

NC No.	7000943532
NC Date	11/09/2023
NC Submission Date	
Part No.	C30400101B
Part Name	GEAR PRIMARY ASSLY
Supplier Name & Code	100237-SANJEEV AUTO PARTS MRFS PVT LT
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	HIGHT U/SIZE.-rusty issue & boss hight obs 24.03 mm

1. Problem Description

Defect Description	Boss Height found undersize up to 24.03~24.07 mm against 24.10~24.20 mm
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	7
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	vpwankhade@sanjeevgroup.com
Plant Head/CEO Email ID	rmtiwari@sanjeevgroup.com
MD Email ID	maithilee@sanjeevgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1280	0	0	300	270	1850
Check Qty	1280	0	0	300	270	1850
NG Qty	513	0	0	11	6	530

Action taken on NG part

Scrap	0
Rework	17
Under Deviation	0

Containment Action
Cleaning done & 100% inspection done for suspected defective batch

3. Process Flow

Process Flow Description
Sn Process Flow 1 Raw Material Inward 2 Bar Cutting 3 Billet Heating 4 Hot Forging 5 Normalizing 6 Shotblasting 7 Coining 8 Preturning 9 Peircing-1 10 Peircing-2 11 Shaving-1 12 Shaving-2 13 Milling-1 14 Milling-2 15 Finish turning 1st setup 16 Finish turning 2nd setup 17 Finish turning 3rd setup 18 Deburring 19 Final Inspection CNC Blank 20 Inward Inspection CNC Blank 21 Traciability Marking 22 Hobbing 23 Teeth Chamfering 24 Gear Shaving 25 Heat tratment 26 Shotblasting 27 ID Turning 28 Bush Pressing 29 Bush Turning 30 Washing 31 Final inspection 32 Dispatch

4. Process Details

Process / Operation	Shot blasting
Outsource	No
Machine / Cell	Heat treatment
Machine / Cell No.	HT/Shot blasting

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Dust & Moisture in shots	Dust & Moisture in shots	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	20 / lot

7. Root Cause Analysis (Occurance)

Why 1	Rusty issue / rusty spots observed on parts
Why 2	Parts observed uncleaned after shot blasting
Why 3	Excess dust and moisture in shots
Why 4	Shots screening freqency not followed
Why 5	
Root Cause (Occurance)	Shots screening freqency not followed

Root Cause Analysis (Outflow)

Why 1	Rusty issue / rusty spots observed on parts
Why 2	Parts observed uncleaned after shot blasting
Why 3	Skipped from inspection
Why 4	Sample inspection
Why 5	
Root Cause (Outflow)	Sample inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Shots cleaning / screening done	Mr. Shelke	15/09/2023		Completed
Outflow	100% visual inspection	vpw	12/09/2023		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100 % visual inspection & sample millipore inspection
Inspection Method	Other
Other Inspection Method	Visual & millipore i
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Moisture & dust in shots 547_Occurance_Before.pdf
Occurance (After)	Moisture & dust removed by shot screening & dosing lime powder 547_Occurance_After.pdf
Outflow (Before)	No check point for rust 547_Outflow_Before.pdf
Outflow (After)	Check point added to check rusty part 547_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	GPH all models

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	WI eye sequence char

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	OK