QFR No - 7000966074

Defect Details

NC No.	7000966074
NC Date	08/12/2023
NC Submission Date	
Part No.	520FW04702
Part Name	CLUTCH HOUSING FULL FINISHED-K70
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	OXDISED-Oxidised issue

1. Problem Description

Defect Description	Heavy Oxidation Issue
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	504
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	madhuradiecast@gmail.com
Plant Head/CEO Email ID	madhuradiecast@gmail.com
MD Email ID	madhuradiecast@gaikegroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	1000	0	500	300	2800
Check Qty	1000	1000	0	500	300	2800
NG Qty	12	0	0	0	0	12

Action taken on NG part

Scrap	12
Rework	0
Under Deviation	0

Containment Action
.100% Stock segregate at customer end and Supplier end stock.

3. Process Flow

Process Flow Description
1.Casting 2. fetling 3. CNC 1st Set-up 4.CNC 2nd Set-up 5.Final Inspection

4. Process Details

Process / Operation	Casting
Outsource	No
Machine / Cell	HPDC
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskill Operator On machine.	Skill Matrix Varified & Found OK.	O
Machine	water was leakage in die	Checking water leakage & Found ok	O
Tool	air spray gun is not in working condition	checking air spray gun found in working condition	O
Method	MIDC regular water supply was not available	MIDC regular water supply was not available	X

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	1:1

7. Root Cause Analysis (Occurance)

Why 1	Oxidised Issue
Why 2	Because water PH value is high.
Why 3	We used Tanker water
Why 4	Because MIDC regular water supply was not available .
Why 5	
Root Cause (Occurance)	Because MIDC regular water supply was not available .

Root Cause Analysis (Outflow)

Why 1	Oxidised Issue
Why 2	100% inspection not done
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	checking was sampling basis

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1.Regular MIDC water supply is started. 2. If MIDC Water is not available we will discuss with Management.	PRODUCTION SUPERVISOR	21/12/2023	20/12/2023	Completed
Outflow	1. 100% die coated part separated & its inspection started. 2.Visual checking Eye Sequence Chart Displayed on Board.	QUALITY SUPERVISOR	21/12/2023	20/12/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1. 100% die coated part separated & its inspection started. 2.Visual checking Eye Sequence Chart Displayed on Board.
Inspection Method	Other
Other Inspection Method	Visual checking
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	1.MIDC regular water supply was not available . 610_Occurance_Before.jpg
Occurance (After)	1.Regular MIDC water supply is started. 2. If MIDC Water is not available we will discuss with Management. 610_Occurance_After.jpg
Outflow (Before)	100% inspection not done 610_Outflow_Before.jpg
Outflow (After)	1. 100% die coated part separated & its inspection started. 2.Visual checking Eye Sequence Chart Displayed on Board. 610_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	EYE SEQUENCE CHART

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Alternative of MIDC Water not available -Again possibility of defect generation if MIDC water not available