QFR No - 7000987844

Defect Details

NC No.	7000987844
NC Date	20/02/2024
NC Submission Date	
Part No.	520JT05102
Part Name	PLATE CLUTCH PIAGGIO
Supplier Name & Code	101138-HINDUSTAN PRESSINGS PVT.LTD.
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	CRACK-Crack issue

1. Problem Description

Defect Description	Plate Clutch observed Crack
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	3900
Is Defect Repeatative?	Yes
Defect Sketch / Photo	odwx25kgwj1e0posgteq0nl2.jpg

Supplier Communication Details

Quality Head Email ID	quality.p1@hpplindia.com
Plant Head/CEO Email ID	spatil@hpplindia.com
MD Email ID	rakesh@hpplindia.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3900	0	0	0	0	3900
Check Qty	3900	0	0	0	0	3900
NG Qty	88	0	0	0	0	88

Action taken on NG part

Scrap	88
Rework	0
Under Deviation	0

Containment Action
We have imidiate action check for crack and NG parts segragation done.

3. Process Flow

Process Flow Description
RM - Blanking/Piercing - Sandering - Nitriding - Dishing - Final Inspection - Packing

4. Process Details

Process / Operation	Dishing
Outsource	No
Machine / Cell	PP 17
Machine / Cell No.	110T

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	FINAL INSPECTION NOT CHECKE DPROPPELY	INSPECTOR CHECKED IN GAUGE AFTER REWOK JOB	X
Method	REWOK JOB NOT PROPERLY DONE	EXCESS PRESSURE GIVEN ON PART OBSERVED IN VISUAL DEFECT	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	LOT SIZE

7. Root Cause Analysis (Occurance)

Why 1	Crack found
Why 2	Parts gets excess pressure during staraightning process
Why 3	Rework parts (Go gauge not Ok) passing through process
Why 4	
Why 5	
Root Cause (Occurance)	Rewok Parts (Go Gauge not Ok) passing througth Straigjtning proces

Root Cause Analysis (Outflow)

Why 1	Crack found
Why 2	100% inspection done ok parts.In rework parts check visual inspection
Why 3	Inspector aware about the checking hair line crack in rework parts.
Why 4	
Why 5	
Root Cause (Outflow)	Inspector aware about the checking hair line crack in rework parts.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	WI for the rework parts (Go gauge not Ok) passed throught straightning and check parts visualyy by 100% and parts indetified seperatly	Mr. Hitendra Patil(HPPL) and Mr, Kiran(HPPL)	07/03/2024	09/03/2024	Completed
Occurance	Traininh give to supervisor and opearartor to rework procedure.	Mr. Hitendra Patil(HPPL) and Mr, Kiran(HPPL)	07/03/2024	09/03/2024	Completed
Outflow	1. Inspector training regarding all final inspection of rework job by 100% 2. 100% checked the gauge passing throught plates and varify the experienced senior QA person for next 3 lot	Mr.Kiran (HPPL	12/03/2024	13/03/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	REWORK PARTS VISUAL INSPECTION DONE AS PER WORK INSTRUCTION.
Inspection Method	Other
Other Inspection Method	VISUAL
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	LOT SIZE

10. Evidance of Countermeasure

Occurance (Before)	Work instruction not avilable 687_Occurance_Before.pdf
Occurance (After)	We have training given to opearator as per work instruction 687_Occurance_After.pdf
Outflow (Before)	Check job visually not q alerat avilable 687_Outflow_Before.pdf
Outflow (After)	Q alert display on finl inspection 687_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All parts

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	OK