

Defect Details

NC No.	7001048728
NC Date	31/08/2024
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	CRACK-heavy nonfelling , buckling & crack issu

1. Problem Description

Defect Description	Major Casting defect observed at lot i.e Non filling ,Casting crack & Casting Bend/Buckling
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	25000
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	25000	15000	20000	0	0	60000
Check Qty	25000	15000	20000	0	0	60000
NG Qty	5000	0	0	0	0	5000

Action taken on NG part

Scrap	5000
Rework	0
Under Deviation	0

Containment Action

100% Material segregation with identification

3. Process Flow

Process Flow Description

1)raw material receipt 2)Storage of Raw Material3)Holding Cum Melting 4) PDC 5) 1st trimming 6) Shot Blasting for burr removing 7)Final Inspection & Packing
 8) Stress Relieving 9)Sound Testing10)Shot Blasting 11)Barreling12)2nd Trimming

4. Process Details

Process / Operation	pdc
Outsource	No
Machine / Cell	hpdc
Machine / Cell No.	8

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	lack of experience /training	New inspector	X
Method	insufficient hydraulic fluid flow rate	After verification hydraulic pressure found drop	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	125

7. Root Cause Analysis (Occurance)

Why 1	Non filling in Core Plate
Why 2	Intensification pressure improper
Why 3	hydraulic pressure drop
Why 4	hydraulic valve malfunction
Why 5	insufficient hydraulic fluid flow rate
Root Cause (Occurance)	insufficient hydraulic fluid flow rate

Root Cause Analysis (Outflow)

Why 1	Non filling in Core Plate
Why 2	Improper inspection by final inspectors
Why 3	lack of experience /training
Why 4	New inspector
Why 5	
Root Cause (Outflow)	Training provide to new operators Limit samples will be displayed for better understand.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. Check hydraulic Fluid level and condition on daily basis 2.W.I has been updated for hydraulic oil tank level 3 Training Provided to the Operator . 4 Valve maintenance check point added in pm check list 5 hydraulic level monitoring on daily basis	HIMANSHU	02/09/2024	03/09/2024	Completed
Outflow	start on job training on daily basis poison test started 100% marking has been Implemented on Outside of the Bunch	HIMANSHU	02/09/2024	03/09/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	visuals defects checked magnifying glass
Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

10. Evidence of Countermeasure

Occurance (Before)	1) valve condition not checked before 2)Hydraulic level not monitoring on daily basis 1054_Occurance_Before.xls
Occurance (After)	1. Check hydraulic Fluid level and condition on daily basis 2.W.I has been updated for hydraulic oil tank level 3 Training Provided to the Operator . 4 Valve maintenance check point added in pm check list 5 hydraulic level monitoring on daily basis 1054_Occurance_After.xls
Outflow (Before)	LACK OF TRAINING 1054_Outflow_Before.xls
Outflow (After)	DEFECT awareness training increase & poison test adequate 100% marking has been Implemented on Outside of the Bunch 1054_Outflow_After.xls

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	,LML REDUCED,K-70,K1&K2

12. Document Review

Documents	WISOP
Specify Other Document	traning plan

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Actions not updated Recurrence of defect phenomenon (No sustenance monitored) RCA need revisit

