QFR No - 8000777813

Defect Details

NC No.	8000777813
NC Date	28/02/2022
NC Submission Date	
Part No.	520FG07802
Part Name	GEAR PRIMARY DRIVEN (JZ)
Supplier Name & Code	100987-FLASH VIVEN MACHINING TECHNOLO
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	RUN OUT MORE-Runout upto 0.25-0.30 against 0.07 mm

1. Problem Description

Defect Description	Face Run out Observed Oversize upto 0.25 ~0.3 mm as against 0.07 mm
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	46
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	sgn.quality@flashgroup.in
Plant Head/CEO Email ID	dkj.mfg@flashgroup.in
MD Email ID	sv.md@flashgroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2500	0	0	1550	1260	5310
Check Qty	2500	0	0	1550	1260	5310
NG Qty	3	0	0	2	1	6

Action taken on NG part

Scrap	0
Rework	6
Under Deviation	0

Containment Action
We have 100% part checked at ETL end Zero defective part found.

3. Process Flow

Process Flow Description
CNC-HOBBING-SHAVING-HEAT TREATMENT-BLASTING-ID HONNING-DFCE ROLLING-FINAL INSPECTION-OILING PACKING&DISPATCH.

4. Process Details

Process / Operation	Heat treatment
Outsource	No
Machine / Cell	CCF-2
Machine / Cell No.	CCF-2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Excess bend near ID.	No provison	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Excess Runout on part
Why 2	Excess bend near ID.
Why 3	RESTING ON OUTER FACE IN STACK OF 5 PARTS IN HT CHARGE. RESTING ON OUTER FACE IN STACK OF 5 PARTS IN HT CHARGE. 1)Resting on outer face in stack of 5 parts in HT charge.
Why 4	1)No resting on face side so possibility Warpage.
Why 5	1) No provision.
Root Cause (Occurance)	No provision

Root Cause Analysis (Outflow)

Why 1	sample basis inspection.
Why 2	sample basis inspection.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	sample basis inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	1)To provide spacer in between two parts first and last part.2)up & down part excess bend found.	Mr.sunil	10/04/2022	09/04/2022	Completed
Outflow	1)100% flatness inspection start as well as honing caseate inspection start.	Mr.Pravin	10/04/2022	09/04/2022	Completed
Occurance	HT loading spacers life to be monitored & defined	Mr. A. G. Deshpande	15/04/2023	31/03/2023	Completed
Outflow	100% inspection with cassette/Gauge. Sampling inspection on comparator stand	Mr. Mahesh K.	10/03/2023	10/03/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1)100% flatness inspection start as well as honing caseate inspection start. 2)Sampling inspection on comparator stand
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	No provision 1_Occurance_Before.xlsx
Occurance (After)	First and last piece spacer add at the time heat treatment. 1_Occurance_After.xlsx
Outflow (Before)	sample basis inspection 1_Outflow_Before.xlsx
Outflow (After)	100% flatness inspection started as well as Honing caseate inspection start. 1_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CCF-2

12. Document Review

Documents	InspCheckSheet
Specify Other Document	inspection sheet.

13. Effectiveness Of Action

Reviewed Quantity	5000
Reason for submission	OK