QFR No - 8000783465

Defect Details

NC No.	8000783465
NC Date	11/04/2022
NC Submission Date	
Part No.	520AE00200
Part Name	CORE PLATE K1 & K2
Supplier Name & Code	100959-AAR CEE ENGINEERING WORKS UNIT
ETL Plant	1135-ETL 7/10 P Nagar
Defect Details	SURFACE FINISH NOT OK-RA VALUE LESS THAN 2RA

1. Problem Description

Defect Description	Shot Blasting not done on one side of Plates. its Ra value observed as 1.38,1.36,1.39,1.42,1.48 against the minimum specification of 2 to 3 Ra
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	32
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	5000	0	0	2000	0	7000
Check Qty	5000	0	0	2000	0	7000
NG Qty	32	0	0	10	0	42

Action taken on NG part

Scrap	0
Rework	42
Under Deviation	0

Containment Action
All materials are segregated at the customer end (ETL end) as well as supplier FG (AAR CEE end). NG pieces re-shot blasting to be done.

3. Process Flow

Process Flow Description
10. Receipt of Raw Material 20. Storage of Raw Material 30. Holding Cum Melting 40. PDC 50. Trimming 60. Shot Blasting 70. Barrelling 80. Sound Testing 90. Stress Relieving 100. Final Inspection & Packing 110. Storage & Dispatch

4. Process Details

Process / Operation	60. Shot Blasting
Outsource	No
Machine / Cell	Shot Blasting Machine
Machine / Cell No.	SBM-02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	In Shot Blasting Machine one side liner got broken suddenly	One side liner found broken in Shot Blasting Machine	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05 pieces

7. Root Cause Analysis (Occurance)

Why 1	Ra value found less than 2 Ra due to one side liner getting broken suddenly in the shot blasting machine.
Why 2	Operator not aware of such kind of issue
Why 3	The operator was not aware, there was no checkpoint on the check sheet for the shot blasting machine liner
Why 4	
Why 5	
Root Cause (Occurance)	There was no checkpoint in the check sheet for the shot blasting machine liner.

Root Cause Analysis (Outflow)

Why 1	Ra value found less than 2 Ra due to Ra value check at two places of the core plate
Why 2	Quality Person not aware of the same
Why 3	There was no method defined to check the Ra value on the core plate
Why 4	
Why 5	
Root Cause (Outflow)	There was no method defined to check the Ra value on the core plate

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Check point for liner inspection to be added in check sheet	Ankit Gupta	21/04/2022	21/04/2022	Completed
Outflow	Ra value checking method to be defined in control plan, PFEMA & inspection report	Ankit Gupta	21/04/2022	21/04/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Ra value to be checked in process at 4 places of the core plate instead of 2 places
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05 pieces

10. Evidance of Countermeasure

Occurance (Before)	Check sheet before adding the checkpoint for liner 48_Occurance_Before.pdf
Occurance (After)	Check sheet after adding the checkpoint for liner 48_Occurance_After.pdf
Outflow (Before)	Inspection report before defining the method to check the Ra value 48_Outflow_Before.pdf
Outflow (After)	Inspection report after defining the method to check the Ra value 48_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All model core plates

12. Document Review

Documents	ControlPlan, PFMEA, JHCheckSheet, InspCheckSheet
Specify Other Document	No other documents

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok