QFR No - 8000783879

Defect Details

NC No.	8000783879
NC Date	14/04/2022
NC Submission Date	
Part No.	580DL54702
Part Name	FTL HUB CLUTCH VAVE 4 PLATE
Supplier Name & Code	205400-NAMO SAI INDUSTRIES
ETL Plant	1135-ETL 7/10 P Nagar
Defect Details	BLOW HOLES-BLOW HOLE & OTHER CASTING DEFECTS

1. Problem Description

Defect Description	Blow Holes & Multiple Pin Holes on the Insert Back face & in ID of Hub Vave, Rejection %age increased up to 29%, Till Date no rigid Action taken for the prevention & Reduction of same.
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	720
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	namosaiindustries@gmail.com
Plant Head/CEO Email ID	namosaiindustries@gmail.com
MD Email ID	mansingh@namosaiindustries.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1500	0	0	1000	400	2900
Check Qty	1500	0	0	1000	400	2900
NG Qty	720	0	0	10	0	730

Action taken on NG part

Scrap	720
Rework	0
Under Deviation	0

Containment Action
100% Parts are check and putted the identification marks

3. Process Flow

Process Flow Description
PDC

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	PDC Machine
Machine / Cell No.	PDC Machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Machine Parameters	Water Pressure less	X
Tool	Problem in Machine Die	Gasses not release properly	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	No Method
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	1

7. Root Cause Analysis (Occurance)

Why 1	Below hole observed after machining
Why 2	Less water presser in die
Why 3	Less water pressure generate from pump
Why 4	
Why 5	
Root Cause (Occurance)	Less water pressure generate from pump

Root Cause Analysis (Outflow)

Why 1	Below hole observed after machining
Why 2	Gasses not release during die casting
Why 3	No provision for gasses release in Die
Why 4	
Why 5	
Root Cause (Outflow)	No provision for gasses release in Die

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Booster pump added to increase the water pressure	Namo Sai	20/10/2022	20/10/2022	Completed
Outflow	One Piece cut every one hrs to check the blow hole	Namo Sai	20/10/2022	20/10/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	One Piece cut every one hrs to check the blow hole
Inspection Method	Other
Other Inspection Method	Cut Piece Visual
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	1

10. Evidance of Countermeasure

Occurance (Before)	Pump Before 53_Occurance_Before.jpg
Occurance (After)	Pump After 53_Occurance_After.jpg
Outflow (Before)	Die Before 53_Outflow_Before.jpg
Outflow (After)	Die After 53_Outflow_After.jpg

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	OK