QFR No - 8000785862

Defect Details

NC No.	8000785862
NC Date	30/04/2022
NC Submission Date	
Part No.	16JPP00117
Part Name	WHEEL CLUTCH REML 6 PLATE / 7 PLATE
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	CRACK-LUG CRACK

1. Problem Description

Defect Description	Crack
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	2
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	madhuradiecast@gmail.com
Plant Head/CEO Email ID	madhuradiecast@gmail.com
MD Email ID	madhuradiecast@gaikegroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	500	0	0	200	300	1000
Check Qty	500	0	0	200	300	1000
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action
100% Stock Segregation done at the Customer end, supplier end with blue dot marking on lug side.

3. Process Flow

Process Flow Description
1.Casting 2.fetling 3. CNC 1st Set-up 4.CNC 2nd Set-up 5.Drilling & Tapping 6.Final Inspection

4. Process Details

Process / Operation	Casting
Outsource	No
Machine / Cell	PDC 400T
Machine / Cell No.	04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskill Operator On machine.	Skill Matrix Varified & Found OK.	O
Tool	Die Blue Matching not Done.	Found Not ok	X
Machine	Water Was Leakage in Die	Checking water leakage & Found Ok.	O
Material	Degassing was not done on decide frequency.	Melting cum furnace degassing report verified & found ok.	O

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	1:1

7. Root Cause Analysis (Occurance)

Why 1	Crack Observed on Lug
Why 2	Crack is Generated because of cold shot
Why 3	Die was Flashing
Why 4	Blue Matching not done
Why 5	
Root Cause (Occurance)	Blue Matching not done

Root Cause Analysis (Outflow)

Why 1	Crack Observed on Lug
Why 2	NG Component Was mixed with ok component.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	NG Component Was mixed with ok component.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	1 Tagging to all bin 2 Rejection and ok component area are define 3 Lock and key rejection bin wii be implement	Quality Superviser	20/05/2022	11/07/2022	Completed
Occurance	1 Die Blue matching done. 2 OPL Displayed on casting stage.	Production Superviser	19/05/2022	18/07/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	This defect is monitoring on Q Gate. started 200% Inspection with identification marking
Inspection Method	Other
Other Inspection Method	Visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	Blue Matching not done 81_Occurance_Before.jpeg
Occurance (After)	1 Die Blue matching done. 2 OPL Displayed on casting stage. 81_Occurance_After.jpeg
Outflow (Before)	NG Component Was mixed with ok component. 81_Outflow_Before.jpeg
Outflow (After)	1 Tagging to all bin 2 Rejection and ok component area are define 3 Lock and key rejection bin wii be implement 81_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	no

12. Document Review

Documents	InspCheckSheet
Specify Other Document	QA OPL

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	