QFR No - 8000786469

Defect Details

NC No.	8000786469
NC Date	06/05/2022
NC Submission Date	
Part No.	C2FY00233M
Part Name	HUB CL. WITH INSERT MACHINED-D1
Supplier Name & Code	100874-ANUSHRUSHTI AUTO PARTS
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	RUN OUT MORE-TEETH R/O O/S UP TO 0.40 MM

1. Problem Description

Defect Description	Teeth OD Run out observed upto 0.4 mm as against 0.25 mm
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	25
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@anushrushtiautoparts.com
Plant Head/CEO Email ID	anushrushti2011@rediffmail.com
MD Email ID	rrwable@redffmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	300	0	0	0	0	300
Check Qty	300	0	0	0	0	300
NG Qty	25	0	0	0	0	25

Action taken on NG part

Scrap	25
Rework	0
Under Deviation	0

Containment Action
100% inspection done for D1 HUB CL WITH INSERT with marking on TEETH.

3. Process Flow

Process Flow Description
1.)RM INWARD 2) CNC 1ST SETUP 3) CNC 2ND SETUP 4) DRILLING 5)FINAL INSPECTION 6) PACKING & DISPATCH

4. Process Details

Process / Operation	CASTING
Outsource	Yes
Machine / Cell	CNC 2
Machine / Cell No.	CNC 2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Inspector not aware of defect	Inspector skill matrix checked found ok	O
Man	Operator not aware of defect	Operator training was not effective	X
Method	Separate bins not used for storage	Operator is storing Parts in special partision bin	O
Method	Part clamping & decampling not proper	uneven part clamping in jaw	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	MANDRELL& DIAL GAUGE
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5NO`S /LOT

7. Root Cause Analysis (Occurance)

Why 1	uneven part clamping in jaw
Why 2	heavy burr deposited at part clamping location (jaw)
Why 3	part clamping location not clean properly
Why 4	part clamping location cleaning frequency not define properly.
Why 5	
Root Cause (Occurance)	part clamping location cleaning frequency not define properly.

Root Cause Analysis (Outflow)

Why 1	Part inspection frequency not evident
Why 2	Lot wise 5 no`s inspection fequency was define in control plan
Why 3	
Why 4	Part inspection frequency not evident
Why 5	
Root Cause (Outflow)	Part inspection frequency not evident

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Partwise On job training are provided of all operator	Mr.Malhari pawar	18/05/2022	18/05/2022	Completed
Outflow	Part inspection frequency not evident	Deepak singh	27/05/2022	27/05/2022	Completed
Occurance	part clamping location cleaning frequency not define properly	malhari pawar	16/06/2022	16/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1)Before - 5no`s per lot inspection done 2) After customer complaints -per bins 1 nos inspection started in final inspection
Inspection Method	Other
Other Inspection Method	dial+centerbetween
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	PER BINS 1

10. Evidance of Countermeasure

Occurance (Before)	Jaw Burr cleaning frequency not define in control plan 95_Occurance_Before.xlsx
Occurance (After)	Jaw Burr cleaning define & updated in controlplan 95_Occurance_After.xlsx
Outflow (Before)	Face runout insp frequency was 5 no`s per lot 95_Outflow_Before.xlsx
Outflow (After)	Face runout insp frequency revied from 5 no`s per lot to 1 no`s per Bins 95_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Tranmission Division

12. Document Review

Documents	ControlPlan
Specify Other Document	On job training shee

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	OK