QFR No - 8000787195

Defect Details

NC No.	8000787195
NC Date	11/05/2022
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	THREADING MISSING-THREADING MISSING & O/S ISSUE

1. Problem Description

Defect Description	Thread missing to all six lugs
Detection Stage	Inprocess
Problem Severity	Fitment
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	800	0	0	550	330	1680
Check Qty	800	0	0	550	330	1680
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
1.100% All material segregation at customer end and inhouse end with identification blue marking on the lug. 2. Started operator traceability by initial of operator name mentioned on the component.

3. Process Flow

Process Flow Description
1.Casting 2.fetling 3. CNC 1st Set-up 4.CNC 2nd Set-up 5.VMC (6 Hole drilling and tapping) 6.Final Inspection

4. Process Details

Process / Operation	VMC (6 Hole drilling and tapping)
Outsource	No
Machine / Cell	VMC
Machine / Cell No.	VMC NO.01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Input & output material bin not identified on drilling tapping stage	Drilling tapping stage checked found not ok	X
Man	Unskill operator operate machine	Skill matrix verify found ok	O
Machine	Component was Rest wrong position	fixture checked not possiblity to rest wrongly	O
Tool	Wrong grade drill and tapp used for operation	Checked and verify found ok	O
Material	Double drilling and tapping done on component	Component checked found ok	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10/Hr

7. Root Cause Analysis (Occurance)

Why 1	Threading missing -Threading missing and O/s.
Why 2	Drilling and tapping was not done on component.
Why 3	Without drilling and tapping component mix with ok components.
Why 4	
Why 5	
Root Cause (Occurance)	Without drilling and tapping component mix with ok components.

Root Cause Analysis (Outflow)

Why 1	Threading missing -Threading missing and O/s.
Why 2	TPG Checking done was sampling basis.
Why 3	
Why 4	
Why 5	

Root Cause (Outflow)	TPG Checking done was sampling basis.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. Input material and output material Bin identified. 2. We change final inspection table location from away drilling tapping operation. 3. Started operator traceability by initial name mentioned on component & marking on Lug conformation of Threading operation done	Production Supervisor	14/05/2022	12/05/2022	Completed
Outflow	1. Started 100% Thread plug gauging checking and marking on the lug for gauging conformation. 2.QA alert & OPL , Displayed on final inspection table. 3. Defective sample displayed at final inspection table.	QA Supervisior	12/05/2022	12/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Started 100% Thread plug gauging checking.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	Without drilling and tapping component mix with ok components.2. Input material and output material Bin not identified. 111_Occurance_Before.jpeg
Occurance (After)	1. Input material and output material Bin identified. 2. We change final inspection table location from away drilling tapping operation. 3. Started operator traceability by initial name mentioned on component & marking on Lug conformation of Threading operation done 111_Occurance_After.pdf
Outflow (Before)	TPG Checking done was sampling basis. 111_Outflow_Before.jpeg
Outflow (After)	1. Started 100% Thread plug gauging checking and marking on the lug for gauging conformation. 2.QA alert & OPL , Displayed on final inspection table. 3. Defective sample displayed at final inspection table. 111_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	InspCheckSheet
Specify Other Document	Q-Alert,OPL

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Analysis not proper -Input output material handling system should specify with color ,bins / trolleys type etc. for easily distinguish the parts