QFR No - 8000787196

Defect Details

NC No.	8000787196
NC Date	11/05/2022
NC Submission Date	
Part No.	520FW04702
Part Name	CLUTCH HOUSING FULL FINISHED-K70
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	OPERATION MISSING-2ND SETUP M/C OPERATION MISSING

1. Problem Description

Defect Description	2ND SETUP MACHINING OPERATION MISSING
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
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	2000	0	0	2500	1500	6000
Check Qty	2000	0	0	0	0	2000
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
1.100% Stock segregate at customer end and Supplier end stock.

3. Process Flow

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

4. Process Details

Process / Operation	CNC 2nd Set-up
Outsource	No
Machine / Cell	JE/CNC NO.02
Machine / Cell No.	JE/CNC NO.02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Component was skipped from 2nd side Cnc operation	verify and checked found ok	O
Man	Unskill operator loading the vechicle	verify found not ok	X
Method	Component was mix up on loading stage	Loading person not aware about part operation	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	100% Visual checking
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

7. Root Cause Analysis (Occurance)

Why 1	2nd side missing component was a mix-up with ok component
Why 2	Vehicle loading operator is was put not ok component to ok bin because one component is required for fulfilling the bin
Why 3	
Why 4	
Why 5	
Root Cause (Occurance)	The vehicle loading operator was put not ok component to the ok bin because one component is required for fulfilling the bin.

Root Cause Analysis (Outflow)

Why 1	Final inspector not put tag in ok component bin
Why 2	Unskill inspector
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Unskill inspector

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. Awareness was created about the defect in the Loading operator. 2. Don`t put the component ready for the dispatch bin without the permission of the dispatch supervisor. 3. Ready for dispatch tag put in the bin for confirmation of ok part for dispatch.	Dispatch Supervisior	15/05/2022	16/05/2022	Completed
Outflow	1. Training and awareness are given to the final inspector. 2. Cross verify by Dispatch component by the inspector before loading the vehicle.	QA Engineer	12/05/2022	13/05/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Cross verify by Dispatch component by the inspector before loading the vehicle.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	The vehicle loading operator was put not ok component to the ok bin because one component is required for fulfilling the bin. 106_Occurance_Before.jpeg
Occurance (After)	1. Awareness was created about the defect in the Loading operator. 2. Don`t put the component ready for the dispatch bin without the permission of the dispatch supervisor. 3. Ready for dispatch tag put in the bin for confirmation of ok part for dispatch. 106_Occurance_After.pdf
Outflow (Before)	Final inspector not put tag in ok component bin 106_Outflow_Before.jpeg
Outflow (After)	1. Training and awareness are given to the final inspector. 2. Cross verify by Dispatch component by the inspector before loading the vehicle. 106_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	ALL ETL COMPONENT

12. Document Review

Documents	PFMEA, InspCheckSheet
Specify Other Document	QA OPL

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Analysis not proper