QFR No - 8000787544

Defect Details

NC No.	8000787544
NC Date	14/05/2022
NC Submission Date	
Part No.	520KS00102
Part Name	RIVET BR 100 CLUTCH
Supplier Name & Code	100049-METAFORGE ENGG.(I) PVT.LTD.
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	CRACK-HEAD CRACK

1. Problem Description

Defect Description	Head Crack
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	110
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qa@metaforgeindia.com
Plant Head/CEO Email ID	kaustubh@metaforgeindia.com
MD Email ID	prajakt@metaforgeindia.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	9000	0	0	0	0	9000
Check Qty	9000	0	0	0	0	9000
NG Qty	9000	0	0	0	0	9000

Action taken on NG part

Scrap	0
Rework	9000
Under Deviation	0

Containment Action
VIsual inspection- In sampling

3. Process Flow

Process Flow Description
Forging-Annealing-

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Line marks on wire coil	Line mark shankand head	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	-
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

7. Root Cause Analysis (Occurance)

Why 1	Head found crack
Why 2	During Head forging upsetting head found crack
Why 3	Line mark on RM coil surface are on some portion
Why 4	
Why 5	
Root Cause (Occurance)	Line mark on RM coil surface are on some portion

Root Cause Analysis (Outflow)

Why 1	head found crack
Why 2	Not detect in visual inspection
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Not detect in visual inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Not defined	Adarsh	15/06/2022	20/07/2022	Completed

Outflow	Vision base system (proposal sent to ETL)	Adarsh	15/06/2022	31/03/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	0
Inspection Method	Other
Other Inspection Method	-
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

10. Evidance of Countermeasure

Occurance (Before)	- 118_Occurance_Before.pdf
Occurance (After)	- 118_Occurance_After.pdf
Outflow (Before)	- 118_Outflow_Before.pdf
Outflow (After)	- 118_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All rivet family

12. Document Review

Documents	
Specify Other Document	-

13. Effectiveness Of Action

Reviewed Quantity	50000
Reason for submission	1.OK-No Repetition of Defect Phenomenon (Outflow side action OK) 2.Occurrence Side action to be submit