QFR No - 8000788627

Defect Details

NC No.	8000788627
NC Date	24/05/2022
NC Submission Date	
Part No.	161FW00233
Part Name	HOUSING CLUTCH DISCOVER 100CC
Supplier Name & Code	200990-OM MAHABALI ENTERPRISES
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	DIAMETER OVER SIZE- DIA O/S UP TO 36.03MM AG.35.966/.991MM

1. Problem Description

Defect Description	OD Ø36 -0.009/-0.034 mm found Oversize up to 27~42 Micron
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	4
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	info@ommahabali.com
Plant Head/CEO Email ID	info@ommahabali.com
MD Email ID	om.mahabali208@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1500	0	0	680	366	2546
Check Qty	1500	0	0	680	366	2546
NG Qty	4	0	0	0	0	4

Action taken on NG part

Scrap	4
Rework	0
Under Deviation	0

Containment Action
Boss OD 100 % Inspection By Air Plug gauge With Marking at Part Right Mark

3. Process Flow

Process Flow Description
CNC Operation

4. Process Details

Process / Operation	CNC Operation
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	06

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	3.0 mm PCD Insert Cornar damge	3.0 mm PCD Insert Cornar damge	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Boss OD Over size
Why 2	Due to PCD 3.0 mm Grooving Insert Minor Corner damage
Why 3	Due to Major Interruption in 3 Boss Face
Why 4	
Why 5	
Root Cause (Occurance)	PCD Insert changed

Root Cause Analysis (Outflow)

Why 1	Frequency of Boss OD inspection 100% Inspection By Air Ring Gauge.
Why 2	No Making on parts for Boss OD inspection.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	started 100 % Boss OD Inspection By Air Ring Gauge with Date & Shift

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	PCD Insert should be change	Mr. Thute.a	27/05/2022	26/05/2022	Completed

Outflow	Boss OD inspection 100% Inspection By Air Ring Gauge.	Mr.Shahare.s	27/05/2022	26/05/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	started 100 % Boss OD Inspection By Air Ring Gauge with Date & Shift
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	3 mm PCD Insert Corner damage 142_Occurance_Before.jpg
Occurance (After)	3 mm PCD Insert should be chnage 142_Occurance_After.jpg
Outflow (Before)	100 % Insertion By Air Ring Gauge with Marking Right Put in Part 142_Outflow_Before.jpg
Outflow (After)	Started Boss OD 100 % Inspection By Air Ring gauge With Making Date and Shift put in Puart 142_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	CNC Machine

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	OK