QFR No - 8000801908

Defect Details

NC No.	8000801908
NC Date	27/08/2022
NC Submission Date	
Part No.	F2FQ00507B
Part Name	HOLDER HANDLE P/C-XF-1C1
Supplier Name & Code	100001-ANANT ENTERPRISES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-CASTING DEFECTS

1. Problem Description

Defect Description	Handle Holder crack
Detection Stage	Customer End
Problem Severity	Safety
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	v31ykdfkq2upwkxneduumktr.pptx

Supplier Communication Details

Quality Head Email ID	anandkulkarni@anantgroup.co.in
Plant Head/CEO Email ID	pramodgosavi@anantgroup.co.in
MD Email ID	ashwinjoshi@anantgroup.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2112	3638	0	0	0	5750
Check Qty	2112	3638	0	0	0	5750
NG Qty	1	1	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action
Stock segregation done at ETL & Warehouse also Inspection marking implemented in half bore.

3. Process Flow

Process Flow Description
10) RM receiving >>> 20) Storage>>> 30) Melting>>> 40) Degassing>>> 50) Casting>>>60) Cutting>>> 70)Grinding>>> 80) Heat treatment>>>90) Buffing>>>100) Powder coating>>>110) Machining>>> 120) Final inspection 130) Packaging & Forwarding

4. Process Details

Process / Operation	Casting
Outsource	No
Machine / Cell	4
Machine / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Molten metal pouring not OK	Pouring net not implemented during molten metal pouring,	X
Man	Operator skill	Semi skilled Operator - L2	O
Material	Inclusion in metal	Metal cleaning frequency decided, Twice per lot.	O
Tool	Casting eject before solidification	Casting ejection done after solidification timer	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Impurity in Holder due to pouring net not using
Why 2	Pouring net not using
Why 3	Lack of awareness
Why 4	Lack of training
Why 5	
Root Cause (Occurance)	No awareness to use pouring net.

Root Cause Analysis (Outflow)

Why 1	Holder Crack or broken due to strength reduced
Why 2	Impurity in holder.
Why 3	Impurity can not visualize at final inspection.
Why 4	
Why 5	
Root Cause (Outflow)	Impurity can not visualize at final inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	WI modified to Use the Pouring net.	Kailas Adhave	27/08/2022		Pending
Outflow	Inspection marking has been implemented in half bore.	Kailas Adhave	26/08/2022		Pending
Outflow	OPL given to inspector & operator	Kailas Adhave	26/08/2022		Pending
Occurance	Pouring net implement during metal pouring in die	Pramod Gosavi	27/08/2022		Pending
Occurance	Q-Alert displayed at shop floor	Kailas Adhave	27/08/2022		Pending
Occurance	Training has been give to die operator	Mahesh Punde	27/08/2022		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection identification implemented in half bore.
Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Without pouring net 232_Occurance_Before.bmp
Occurance (After)	Pouring net Implemented 232_Occurance_After.bmp
Outflow (Before)	Only DOT mark was implemented 232_Outflow_Before.jpg
Outflow (After)	Inspection mark - Inspector initial implemented 232_Outflow_After.bmp

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Upper bracket

12. Document Review

Documents	ControlPlan, PFMEA, InspCheckSheet
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	

Reason for submission	