QFR No - 8000802986

Defect Details

NC No.	8000802986
NC Date	06/09/2022
NC Submission Date	
Part No.	520FG07802
Part Name	GEAR PRIMARY DRIVEN (JZ)
Supplier Name & Code	200172-AURANGABAD AUTO ENGG PVT LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	PCD SHIFT-SPRING SPOKET& 3BOSS PCD NOT OK

1. Problem Description

Defect Description	Spring Pocket PCD & Concentricity not OK
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	94
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	verma.aaepl@gmail.com
Plant Head/CEO Email ID	aaepl.pantnagar@sangkaj.com
MD Email ID	steel@sangkaj.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2150	0	0	2588	3500	8238
Check Qty	1150	0	0	2588	3500	7238
NG Qty	2	0	0	0	16	18

Action taken on NG part

Scrap	0
Rework	16
Under Deviation	0

Containment Action
100 % WIP And Customer end all part rechecked by PCD relation gauge

3. Process Flow

Process Flow Description
Forging -CNC 1at setup - CNC 2nd Setup -Trimming - Kidney pocket deburring - CNC 1st setup - CNC 2nd Setup - Inspection -Hobbing -HT-ID Honning -Teeth Honning -Final Inspection - Dispatch

4. Process Details

Process / Operation	Trimming
Outsource	Yes
Machine / Cell	Trimming Press Machine
Machine / Cell No.	CNC Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Jaw boring not done as per frequency	Jaw boring frequency not follow	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	5/Per lot

7. Root Cause Analysis (Occurance)

Why 1	Part not answering to relation gauge
Why 2	Window location shifted
Why 3	Jaw boring out
Why 4	Jaw boring not done as per frequency
Why 5	
Root Cause (Occurance)	Jaw boring frequency not follow as control plan

Root Cause Analysis (Outflow)

Why 1	Sampling inspection done at final stage
Why 2	Inspection done as per control plan
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Sampling inspection done at final inspection stage

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Jaw boring cycle interlocked	Production In charge	16/12/2022	15/12/2022	Completed
Outflow	100% inspection started	final inspector	20/12/2022	12/12/2022	Completed
Occurance	100% inspection started at final inspection stage by relation gauge	Final Inspector	01/12/2022	09/12/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Before we have checked on sampling basis after Complaint received we have started 100% inspection .
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)	Jaw boring not done as per frequency 247_Occurance_Before.xlsx
Occurance (After)	Interlock implemented for jaw boring frequency monitoring 247_Occurance_After.xlsx
Outflow (Before)	Sampling Inspection at final stage 247_Outflow_Before.xlsx
Outflow (After)	100% Inspection done at final inspection stage 247_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	DX101004 - Gear Primary Driven

12. Document Review

Documents	ControlPlan, JHCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	3000
Reason for submission	OK