

Defect Details

NC No.	8000805167
NC Date	22/09/2022
NC Submission Date	
Part No.	F1BF04233M
Part Name	OUTER TUBE M/C RH- KOLA DISC
Supplier Name & Code	100017-DEKSON CASTINGS LIMITED.
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	BLOW HOLES-CASTING BLOW HOLES

1. Problem Description

Defect Description	blow holes
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	21
Is Defect Repeatative?	No
Defect Sketch / Photo	dr3tcca01njs00mekriaf3pk.pptx

Supplier Communication Details

Quality Head Email ID	quality@dekson.co.in
Plant Head/CEO Email ID	mr@dekson.co.in
MD Email ID	chetandekate@dekson.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	200	0	0	0	300	500
Check Qty	200	0	0	0	300	500
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action

All suspected part checked

3. Process Flow

Process Flow Description

Inward-Melting-Degassing-GDC-Riser Cutting-fettling grinding-GDC Q Gate- SPM-HT-VMC-BTA-Inspection- Dispatch

4. Process Details

Process / Operation	GDC
Outsource	No
Machine / Cell	GDC
Machine / Cell No.	3

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Air vent block	found block	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	CASTING BLOW HOLES
Why 2	hot air gas not removed
Why 3	Air vent block
Why 4	
Why 5	
Root Cause (Occurance)	Air vent block

Root Cause Analysis (Outflow)

Why 1	CASTING BLOW HOLES
Why 2	blow hole open after buffing
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	blow hole open after buffing

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Air vent blockage clear	Die Maint. Operator	24/09/2022	24/09/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	check point added in inspection checksheet
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	4

10. Evidence of Countermeasure

Occurance (Before)	Die air vent found block 260_Occurance_Before.jpg
Occurance (After)	Die Air vent open 260_Occurance_After.jpg
Outflow (Before)	No inspection checkpoint 260_Outflow_Before.jpeg
Outflow (After)	inspection checkpoint added 260_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	all die

12. Document Review

Documents	InspCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	blow holes open after buffing at ETL Narasapura plant so need to improve in supplier end casting process