QFR No - 8000807148

Defect Details

NC No.	8000807148
NC Date	08/10/2022
NC Submission Date	
Part No.	B35206400O
Part Name	BRAKE SHOE ASSLY ASK (ASF4) - EMARKING
Supplier Name & Code	100822-ASK AUTOMOTIVE PVT. LTD. (UNI
ETL Plant	1159-ETL E-71 Disc Brakes
Defect Details	RUNOUT-PERPENDICUALIRITY NOT OK

1. Problem Description

Defect Description	Brake shoe rejected for tapper and run out issue
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	50
Is Defect Repeatative?	Yes
Defect Sketch / Photo	52yu4gaq5goz4pel54r2ct1q.msg

Supplier Communication Details

Quality Head Email ID	bms@askbrake.com
Plant Head/CEO Email ID	am@askbrake.com
MD Email ID	pr@askbrake.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4000	0	0	4000	2413	10413
Check Qty	4000	0	0	4000	2413	10413
NG Qty	50	0	0	0	0	50

Action taken on NG part

Scrap	50
Rework	0
Under Deviation	0

Containment Action
All material laying at ETL & ASK segregated 100%.

3. Process Flow

Process Flow Description
Receiving- Machining- Adhesive Application- Clamping - OD Grinding - Final Inspection & Packing

4. Process Details

Process / Operation	Brake Shoe
Outsource	No
Machine / Cell	OD Grinding Machine
Machine / Cell No.	1202158

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Inspection Frequency	Inproces Inspection frequency of OD grinding is sufficient	O
Method	Sample Size	Sample inspection size of OD grinding need to improve	X
Method	OD grinding process	OD grinding process is automated.	X
Man	New Manpower	No new manpower appointed on OD grinding process	X
Man	Manpower Skill Level	All manpower have skill level III	X
Machine	Wheel dressing frequency	Once in a day, which needs improve	O
Material	Material changed	No change in material	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1set / hr

7. Root Cause Analysis (Occurance)

Why 1	Runout observed more
Why 2	In second shift found some parts out of specification during inspection
Why 3	Wheel dressing frequency less.
Why 4	
Why 5	
Root Cause (Occurance)	Verified the process with every 50th set after setup and observed that in first shift no NG parts found and in mid of second shift we have found 1 or 2 sets NG for runout. Again we have done setup after wheel dressing and no runout observed in the part.

Root Cause Analysis (Outflow)

Why 1	Runout observed more
Why 2	Problem not captured during sampling inspection
Why 3	
Why 4	
Why 5	

Root Cause (Outflow)	Problem not captured during sampling inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. Wheel dressing frequency increased from once in a day to once in shift. 2. Training given to process engineers and also associates to dress the grinding wheel once in a shift.	Prashant	12/10/2023	12/10/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No Change
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	2 set / hr

10. Evidance of Countermeasure

Occurance (Before)	Work Instruction Before 272_Occurance_Before.pdf
Occurance (After)	Work Instruction 272_Occurance_After.pdf
Outflow (Before)	Setup & IIR Before 272_Outflow_Before.pdf
Outflow (After)	Setup & IIR 272_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All machines

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	Setup & IIR

13. Effectiveness Of Action

Reviewed Quantity	

Reason for submission	