QFR No - 8000807947

Defect Details

NC No.	8000807947
NC Date	17/10/2022
NC Submission Date	
Part No.	S2BG02502B
Part Name	BRACKET UN P/C KTEP
Supplier Name & Code	100973-TESMO MOTORCAST PRIVATE LIMITE
ETL Plant	1116-ETL K-120 Suspension
Defect Details	THREADING NOT OK-THREADING NOT OK

1. Problem Description

Defect Description	Bracket KTEP observed with threading not ok concern. In every month major qty. rejected for same.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	967
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rkhare@tesmomotorcast.com
Plant Head/CEO Email ID	harish.bala@tesmomotorcast.com
MD Email ID	svkallani@tesmomotorcast.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	767	0	0	0	0	767
Check Qty	767	0	0	0	0	767
NG Qty	767	0	0	0	0	767

Action taken on NG part

Scrap	500
Rework	100
Under Deviation	67

Containment Action
core pin bend issuse

3. Process Flow

Process Flow Description
pdc , debering ,remer , vibro ,chamfer ,taping , air claning ,pack

4. Process Details

Process / Operation	pdc,debering ,remer ,vibro ,chamfer ,taping
Outsource	No
Machine / Cell	pdc
Machine / Cell No.	pdc 250 1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	core pin bend	Gauge	O
Material	core pin hardness not ok	hardness testing report check	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	every hrs

7. Root Cause Analysis (Occurance)

Why 1	Tap not gone up to required depth
Why 2	Tap jam while completing its cycle
Why 3	Hole pin perpendicularity not ok
Why 4	Die core pin bend
Why 5	Pin hardness not as per requirement
Root Cause (Occurance)	Core pin hardness not freeze.

Root Cause Analysis (Outflow)

Why 1	Tap not gone up to required depth
Why 2	Tap jam while completing its cycle
Why 3	Hole pin perpendicularity not ok
Why 4	Die core pin perpendicularity not ok
Why 5	Perpendicularity not check
Root Cause (Outflow)	Core pin Perpendicularity checking frequency not defined.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	hourly pin hole perpendicularity checking	Rahul	06/07/2023	25/06/2023	Completed
Occurance	Pin hardness freeze	Ravi	10/07/2023	26/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Perpendicularity checking started on hourly check on PDC
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1000

10. Evidance of Countermeasure

Occurance (Before)	Core pin bend 290_Occurance_Before.jpg
Occurance (After)	Due to the pin bend, taping was not done untill the end. 290_Occurance_After.jpg
Outflow (Before)	Guaege install 290_Outflow_Before.jpg
Outflow (After)	Guaege checking strat 290_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Pdc 250 t 1 KTEP Bracket

12. Document Review

Documents	JHCheckSheet, InspCheckSheet
Specify Other Document	Pm check sheet, Ins

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	