QFR No - 8000808151

Defect Details

NC No.	8000808151
NC Date	17/10/2022
NC Submission Date	
Part No.	S2BG03908B
Part Name	BKT POWDER COATED
Supplier Name & Code	101032-ASM CASTINGS PRIVATE LIMITED (
ETL Plant	1116-ETL K-120 Suspension
Defect Details	THREADING NOT OK-THREADING NOT OK

1. Problem Description

Defect Description	KHI Bracket observed with step at ID side concern. This causing assembly fitment (Rubber bush fitment) not OK.
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	553
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@asmcastings.in
Plant Head/CEO Email ID	skaul@asmcastings.in
MD Email ID	rajiv@asmcastings.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	1200	0	2800	0	6000
Check Qty	2000	1200	0	2800	0	6000
NG Qty	553	128	0	221	0	902

Action taken on NG part

Scrap	902
Rework	0
Under Deviation	0

Containment Action
100% Segregation at customer as well as ASM End.

3. Process Flow

Process Flow Description
R.M. Receiving - Die Casting - Fattling - Bush Fitting Dia Reamer - Drilling & Tapping - Visual Inspection - PDI -Packing - Dispatch - Powder Coating at Tulza Ent. - Dispatch to ETL.

4. Process Details

Process / Operation	Powder Coating
Outsource	Yes
Machine / Cell	Die Casting
Machine / Cell No.	PDC-01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Hard Particle in Al Ingot.	Chemical Composition	O
Method	Reamer not adequate	Remer Size Checked	O
Man	Un Skilled Operator	Skill Matrix	O
Tool	Pin Bulged in Die	Physical Verification	X
Machine	Play in Machine Platon	Physical Verification	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05 Nos.

7. Root Cause Analysis (Occurance)

Why 1	Step Observed in ID
Why 2	Pin Bulged during Mass Production
Why 3	Not Checked in Process Inspection
Why 4	Check Point not added in Inspection td.
Why 5	
Root Cause (Occurance)	Check point not added in Inspection Std. for Step in I.D.

Root Cause Analysis (Outflow)

Why 1	Step in I.D.
Why 2	Could Not detected during Final Inspection
Why 3	Inspector Not aware about Issue.
Why 4	Check Point not added in Work Instruction.
Why 5	
Root Cause (Outflow)	Check For Step in I.D. , not added in Work Instruction of Final Inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Check Point added for Step In I.D. in Inspection Std. of PDC.	Lalit Sharma	10/11/2022		Completed
Outflow	Check Point added in Work Instruction of Final Inspection	Lalit Sharma	10/11/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Earlier Limit Sample was not there for Compare
Inspection Method	Other
Other Inspection Method	Limit Sample.
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	No Check Point at PDC stage for Step in I.D. 288_Occurance_Before.jpg
Occurance (After)	Check Point added for step in ID at PDC Stage 288_Occurance_After.jpg
Outflow (Before)	No Check Point for Step in I.D. in Work Instruction & No Limit Sample 288_Outflow_Before.jpg
Outflow (After)	Check point added in Work Instruction at Final Stage & Limit Sample Provided. 288_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	PDC Machine

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	Limit Sample

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	No any reoccurance.