QFR No - 8000808405

## Defect Details

| | |
|---|---|
| **NC No.** | 8000808405 |
| **NC Date** | 19/10/2022 |
| **NC Submission Date** | |
| **Part No.** | F2BF26773B |
| **Part Name** | K0NA CBS OUTER TUBE CAST RH |
| **Supplier Name & Code** | 101262-SUNBEAM LIGHTWEIGHTING SOLUTIO |
| **ETL Plant** | 1116-ETL K-120 Suspension |
| **Defect Details** | CENTRE DIST. NOT OK.-AXEL HOLE SHIFT |

## 1. Problem Description

| | |
|---|---|
| **Defect Description** | Wall thickness variation concern reported with major rejection qty. |
| **Detection Stage** | Inprocess |
| **Problem Severity** | Fitment |
| **NG Quantity** | 269 |
| **Is Defect Repeatative?** | Yes |
| **Defect Sketch / Photo** | |

## Supplier Communication Details

| | |
|---|---|
| **Quality Head Email ID** | deepak.rana@sunbeamauto.com |
| **Plant Head/CEO Email ID** | anoop.gupta@sunbeamauto.com |
| **MD Email ID** | |

## 2. Stock Details & action taken for NG parts

| Location | ETL End | Warehouse | Transit | Supplier FG | Supplier WIP | Total |
|---|---|---|---|---|---|---|
| **Total Qty** | 715 | 478 | 0 | 876 | 521 | 2590 |
| **Check Qty** | 715 | 478 | 0 | 870 | 521 | 2584 |
| **NG Qty** | 0 | 0 | 0 | 6 | 0 | 6 |

Action taken on NG part

| | |
|---|---|
| **Scrap** | 6 |
| **Rework** | 0 |
| **Under Deviation** | 0 |

| Containment Action |
|---|
| casting should be catch on FI stage (oil seal coller wall 100% checked by vernier) |

## 3. Process Flow

| Process Flow Description |
|---|
| "1.Alloy Preparation 2.Degassing & Defluxing 3.Casting 4.Riser Cutting 5.Fettling & Filing 6.Leak Testing 7.Final Inspection " "1.Alloy Preparation 2.Degassing & Defluxing 3.Casting 4.Riser Cutting 5.Fettling & Filing 6.Leak Testing 7.Final Inspection " 1.alloy preparation 2.degassing and defuxing 3.casting 4.riser cutting 5.fettling and filling 6.leak testing 7.final inspection |

## 4. Process Details

| | |
|---|---|
| **Process / Operation** | casting |
| **Outsource** | No |
| **Machine / Cell** | gdc/domestic |
| **Machine / Cell No.** | 6 and 8 |

## 5. Problem Analysis

| Type | Possible Cause | Fact Verification | Jud |
|---|---|---|---|
| Machine | hydraulic pressure low | found pressure low | X |

## 6. Inspection Method Analysis (Current)

| | |
|---|---|
| **Inspection Method** | Sp. Gauge |
| **Other Inspection Method** | |
| **Check Point at Final Inspection** | Yes |
| **Checking Freq.** | 100% |
| **Sampling** | No |
| **Sample Size** | 100% |

## 7. Root Cause Analysis (Occurance)

| | |
|---|---|
| **Why 1** | Flash observed at parting line area |
| **Why 2** | Die was not closing |
| **Why 3** | Hydrulic pressure low |
| **Why 4** | Cylinder leakage due to core holder was shaking . |
| **Why 5** | Core holder change frequency was not deciding in pm plan cheek sheet . |
| **Root Cause (Occurance)** | Core holder change frequency was not deciding in pm plan cheek sheet . |

## Root Cause Analysis (Outflow)

| | |
|---|---|
| **Why 1** | Oil Seal area wall thickness ng |
| **Why 2** | Process and final inspector in this problem not captured. |
| **Why 3** | No check point avaiable in set up sheet and final work instruction sheet . |
| **Why 4** | |
| **Why 5** | |
| **Root Cause (Outflow)** | No check point available in set up sheet and final work instruction sheet . |

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

| Type | Countermeasure Details | Responsibility | Target Date | Actual Date | Status |
|---|---|---|---|---|---|

| | | | | | |
|---|---|---|---|---|---|
| Occurance | Holder change frequency decided as per PM check sheet | kishore/mukesh | 05/11/2022 | | Completed |
| Outflow | check point add in process quality & final inspection | kishore/mukesh | 21/10/2022 | | Completed |

## 9. Inspection Method After Customer Complaint

| | |
|---|---|
| **Change In Inspection System** | Yes |
| **Change Details** | 100% part inspection before dispatch |
| **Inspection Method** | Instrument |
| **Other Inspection Method** | |
| **Check Point at Final Inspection** | Yes |
| **Checking Freq.** | 100% |
| **Sampling** | No |
| **Sample Size** | 100% |

## 10. Evidance of Countermeasure

| | |
|---|---|
| **Occurance (Before)** | Earlier core holder frequency not defined<br>292_Occurance_Before.pdf |
| **Occurance (After)** | Holder change frequency decided as per PM check sheet<br>292_Occurance_After.pdf |
| **Outflow (Before)** | No check point avaiable in set up sheet and final work instruction sheet .<br>292_Outflow_Before.pdf |
| **Outflow (After)** | check point add in process quality & final inspection<br>292_Outflow_After.pdf |

## 11. Horizontal Deployment

| | |
|---|---|
| **Horizontal Deployment Required** | Yes |
| **Applicable Machine / Model / Plant** | 08/kona/101262 |

## 12. Document Review

| | |
|---|---|
| **Documents** | ControlPlan, PMCheckSheet, WISOP, InspCheckSheet |
| **Specify Other Document** | na |

## 13. Effectiveness Of Action

| | |
|---|---|
| **Reviewed Quantity** | 100 |
| **Reason for submission** | No any re-occurance. |