QFR No - 8000820735

Defect Details

NC No.	8000820735
NC Date	16/02/2023
NC Submission Date	
Part No.	520FZ01902
Part Name	HUB CLUTCH K70
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	TAPPING O/SIZE.-CRACK & HEAVY TEPAR MACHINING

1. Problem Description

Defect Description	Tapper Machining (Dimn 28.2±0.1 mm found up to 27.89~28.48 mm)
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	2
Is Defect Repeatative?	No
Defect Sketch / Photo	oalbh4q0u5jzjx4ubsgt2ova.jpg

Supplier Communication Details

Quality Head Email ID	madhuradiecast@gmail.com
Plant Head/CEO Email ID	madhuradiecast@gmail.com
MD Email ID	madhuradiecast@gaikegroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	500	600	2100
Check Qty	1000	0	0	500	600	2100
NG Qty	2	0	0	1	1	4

Action taken on NG part

Scrap	4
Rework	0
Under Deviation	0

Containment Action
1.100% All material segregation at customer end and inhouse end with identification blue marking.

3. Process Flow

Process Flow Description
1.Casting 2.fetling 3. CNC 1st Set-up 4.CNC 2nd Set-up 5.Broaching 6.Final Inspection

4. Process Details

Process / Operation	CNC 2nd Set-up
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Component was not rest proper in jaw	Check and verify possibility component rest inproper	X
Man	Unskilled operator was operate machine	Skill Matrix verify found Level-04 operator operate machine	X
Tool	Jaw loose in running	Check and verify found ok	O
Material	Burr and flash on resting face	Found ok	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	1:25

7. Root Cause Analysis (Occurance)

Why 1	Tapper Machining (Dimn 28.2±0.1 mm found up to 27.89~28.48 mm)
Why 2	In 2nd side machining Component was not properly resting in jaw.
Why 3	While operator resting the component in the jaw not properly rest.
Why 4	
Why 5	
Root Cause (Occurance)	While operator resting the component in the jaw not properly rest.

Root Cause Analysis (Outflow)

Why 1	Inspection done by height gauge
Why 2	Inspection frequency was less
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Inspection frequency was less

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Auto loader mechanism is implemented on 2nd side machining stage.	Production supervisior	15/03/2023	28/02/2023	Completed
Outflow	1.Special dial gauge implemented for Taper machining checking 2.Training and awareness given to inspector for checking 100% Taper Machining Checking.	QA Supervisor	15/03/2023	28/02/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Started 100% Checking on special dial gauge
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	Auto loader not available for component resting. 372_Occurance_Before.pdf
Occurance (After)	Auto loader mechanism is implemented on 2nd side machining stage. 372_Occurance_After.pdf
Outflow (Before)	Taper machining Dim checked by Height gauge 372_Outflow_Before.jpeg
Outflow (After)	Taper machining Dim checked by Sp Dial gauge 372_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	PokayokeCheckSheet, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	OK -(Remark-Wrong Defect image upload -Wheel clutch photo upload instead of Hub clutch)