QFR No - 8000822018

Defect Details

NC No.	8000822018
NC Date	28/02/2023
NC Submission Date	
Part No.	C2FY00233M
Part Name	HUB CL. WITH INSERT MACHINED-D1
Supplier Name & Code	100874-ANUSHRUSHTI AUTO PARTS
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	RUN OUT MORE-FACE R/O O/S UP TO 0.13 AGAINST 0.05

1. Problem Description

Defect Description	D1 Hub Clutch run out found oversize up to 0.13 mm against 0.05 mm
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	11
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qlty@anushrushtiautoparts.com
Plant Head/CEO Email ID	anushrushti2011@rediffmail.com
MD Email ID	rrwable@redffmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	300	0	0	100	0	400
Check Qty	300	0	0	100	0	400
NG Qty	11	0	0	0	0	11

Action taken on NG part

Scrap	11
Rework	0
Under Deviation	0

Containment Action
Part segregation done at ETL End

3. Process Flow

Process Flow Description
1. casting inward 2. casting inward inspection 3.STORAGE 4.CNC 1st SETUP 5.CNC 2nd SETUP 6.DRILLING 7.FINAL INSPECTION 8.PACKING & STORAGE 9.PDI 10.DISPATCH & LOGISTICS

4. Process Details

Process / Operation	1.CNC 1st SETUP 2.CNC 2nd SETUP 3.DRILLING
Outsource	No
Machine / Cell	CNC & DRILLING
Machine / Cell No.	CNC 1ST ,CNC 2ND

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	unskilled operator	skilled matrix verified found L1	X
Material	Hub teeth inclined	Teeth inclination verified & found ok	O
Tool	insert wear out	Tool life monitoring verified found ok	O
Machine	jaw boaring not ok	jaw boaring runout 0.1 against 0.01	X
Method	inspection frequency was inadequite	in final inspection part inspection was sampling basis found not evident	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1 no`s/bin

7. Root Cause Analysis (Occurance)

Why 1	RUN OUT MORE-FACE R/O O/S UP TO 0.13 AGAINST 0.05
Why 2	2. Jaw Run out observed oversize up to 0.1mm against 0.01mm.
Why 3	Jaw bo done by machine operator absence of machine supervisor.
Why 4	shift was run in extra working day thatwhy line supersior was absent
Why 5	
Root Cause (Occurance)	Jaw boring done by machine operator absence of machine supervisor.

Root Cause Analysis (Outflow)

Why 1	The process part inspection at final insp is not effective
Why 2	Inspection frequcey is less
Why 3	inspection done at final inspection i.e - one`s in a bins
Why 4	
Why 5	
Root Cause (Outflow)	At final inspection station inspection frequency less

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Jaw boring done by machine operator absence of machine supervisor.	malhari pawar	21/04/2023	10/05/2023	Completed
Outflow	At final inspection station inspection frequency les	A.deshmukh	22/05/2023	16/05/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	At final inspection station inspection frequency revised from one`s in a bins to 2 no`s from every bins
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	2 no`s/Bin

10. Evidance of Countermeasure

Occurance (Before)	OPERATOR SKILL EVALUATION NOT DONE 382_Occurance_Before.xlsx
Occurance (After)	FOR CNC MACHINING STAGE WISE SKILL MATRIX MADE 382_Occurance_After.xlsx
Outflow (Before)	FINAL INSP INSPECTION FREQUENCY REVISED FROM 5 NO`S PER LOT TO 1 NO`S PER BINS 382_Outflow_Before.xlsx
Outflow (After)	FINAL INSP INSPECTION FREQUENCY REVISED FROM 1 NO`S PER BINS TO 2 NO`S PER BINS 382_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	ControlPlan
Specify Other Document	CONTROL PLAN

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Root Cause & Cause side action same -Need to review the action plan .