QFR No - 8000828138

Defect Details

NC No.	8000828138
NC Date	02/05/2023
NC Submission Date	
Part No.	S2BG00702B
Part Name	BRACKET UN P/C
Supplier Name & Code	100973-TESMO MOTORCAST PRIVATE LIMITE
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	CRACK-CRACK CASTING DEFECT

1. Problem Description

Defect Description	Bracket Broken due to cracked & casting defect
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	3
Is Defect Repeatative?	No
Defect Sketch / Photo	lmxzvtct5sbdx3tor2oddndi.jpg

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	3000	0	4320	2032	10500	19852
Check Qty	3000	0	0	2032	10500	15532
NG Qty	3	0	0	0	0	3

Action taken on NG part

Scrap	3
Rework	0
Under Deviation	0

Containment Action
Check point added in final stage.

3. Process Flow

Process Flow Description
PDC - Reamer - Grinding - Buffing - Tapping - Packing

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	PDC 350 Ton
Machine / Cell No.	PDC-5

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Part eject before core out	Part get tilted in hot condition and hair line crack generated at inner side	O
Tool	Core Slider get jam	Core not out completely before ejection operation	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Checking
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1

7. Root Cause Analysis (Occurance)

Why 1	HMCL Part cracked at its I-section
Why 2	I-section area get weak due to hair crack generation
Why 3	Part get tilted in hot condition while ejection process in PDC
Why 4	Core not completely out and ejection done
Why 5	Core slider Jam due to flash inside core sliding area
Root Cause (Occurance)	Machine run with flash in core area.

Root Cause Analysis (Outflow)

Why 1	HMCL cracked part found at customer end
Why 2	Crack not checked
Why 3	Specified location crack checking not happening in final stage
Why 4	Defect coming first time
Why 5	
Root Cause (Outflow)	Point not available in check point of inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Tool to run with flash free	Sachin	10/05/2023		Pending
Outflow	Crack check point added in inspection	Rahul Khare	10/05/2023		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Crack at I-section check point incorporated in final inspection
Inspection Method	Other
Other Inspection Method	Visual checking
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1

10. Evidance of Countermeasure

Occurance (Before)	CRACKED PART 444_Occurance_Before.jpg
Occurance (After)	OK PART 444_Occurance_After.jpeg
Outflow (Before)	CRACKED PART 444_Outflow_Before.jpg
Outflow (After)	SAMPLE PLACED ON FINAL INSPECTION 444_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	KTEP

12. Document Review

Documents	InspCheckSheet
Specify Other Document	PART DISPLAY

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	