QFR No - 8000831090

Defect Details

NC No.	8000831090
NC Date	31/05/2023
NC Submission Date	
Part No.	B2FP01013O
Part Name	HOLDER BRACKET FINISHED - REML
Supplier Name & Code	100398-MANOJ INDUSTRIES
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	DAMAGES-AFTER 100% INSP. BH,PINHOLES,DENT,DAMAGE

1. Problem Description

Defect Description	Dent, & Blow holes observed on parts
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	25
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qad@manojindustrieskop.com
Plant Head/CEO Email ID	foundry@manojindustrieskop.com
MD Email ID	mgnt@manojindustrieskop.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1750	450	0	500	0	2700
Check Qty	1750	450	0	500	0	2700
NG Qty	18	13	0	7	0	38

Action taken on NG part

Scrap	38
Rework	0
Under Deviation	0

Containment Action
100% visual Inspection of All pipeline stock

3. Process Flow

Process Flow Description
casting ,VMC machining ,Slotting ,Final Inspection

4. Process Details

Process / Operation	casting ,VMC machining
Outsource	No
Machine / Cell	ENDURANCE CELL
Machine / Cell No.	VMC-14

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Dent damage observed on casting
Why 2	Casting dent observed at parting process
Why 3	After parting parts not kept properly
Why 4	operator keeps the parts in open bin from 2ft height
Why 5	
Root Cause (Occurance)	operator keeps the parts in open bin from 2ft height

Root Cause Analysis (Outflow)

Why 1	Dent damage observed on casting
Why 2	skipped from final inspector
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	skipped from final inspector

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	After parting operation parts kept in open bin 456_Occurance_Before.png
Occurance (After)	After parting parts kept in partitioned bin 456_Occurance_After.jpg
Outflow (Before)	no Dot mark provided 456_Outflow_Before.jpg
Outflow (After)	Dot mark provided 456_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Master cylinder,Calipers

12. Document Review

Documents	WISOP
Specify Other Document	Quality plan

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	NO damage observed in corrected lot