

## Defect Details

<b>NC No.</b>	8000832689
<b>NC Date</b>	12/06/2023
<b>NC Submission Date</b>	
<b>Part No.</b>	16JPP00117
<b>Part Name</b>	WHEEL CLUTCH REML 6 PLATE / 7 PLATE
<b>Supplier Name &amp; Code</b>	101100-CAST 4 ALUMINIUM PVT LTD
<b>ETL Plant</b>	1132-ETL K-226/1 TRANSMISSION
<b>Defect Details</b>	RUN OUT MORE-TEETH ID R/O OBS 1.0 MM

## 1. Problem Description

<b>Defect Description</b>	Tapper Machining -Teeth Runout found more than 1 mm against 0.2
<b>Detection Stage</b>	Inprocess
<b>Problem Severity</b>	Fitment
<b>NG Quantity</b>	159
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	info@cast4aluminium.com
<b>Plant Head/CEO Email ID</b>	infor@cast4aluminium.com
<b>MD Email ID</b>	kiran@cast4aluminium.com

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

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	500	0	0	200	1300	2000
<b>Check Qty</b>	500	0	0	200	1300	2000
<b>NG Qty</b>	159	0	0	200	1300	1659

## Action taken on NG part

<b>Scrap</b>	1659
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

Pipeline Material checked 100 % for defects & Material quarantined and Scrapped.

## 3. Process Flow

**Process Flow Description**

RM- Melting- PDC - Gate cutting / Fettling- Machining - Final inspection - FG- PDI - Dispatch

**4. Process Details**

<b>Process / Operation</b>	Machining
<b>Outsource</b>	No
<b>Machine / Cell</b>	CNC machining
<b>Machine / Cell No.</b>	CNC Machining

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Machine	Jaw observed cracked.	Jaw observed cracked.	O
Man	Part skipped from inspection As inspector is not aware of defect.	Part skipped from inspection As inspector is not aware of defect.	O

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Visual
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	REML 6 plate wheel observed with taper machining
<b>Why 2</b>	During Machining operation job get shifted from location.
<b>Why 3</b>	Job is not get clamped properly in jaw.
<b>Why 4</b>	Jaw observed cracked
<b>Why 5</b>	
<b>Root Cause (Occurance)</b>	Jaw observed cracked

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	Jaw observed cracked
<b>Why 2</b>	Inspector is not aware of defect
<b>Why 3</b>	
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	Inspector is not aware of defect

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Jaw observed cracked	Datta	10/06/2023	Completed
Outflow	Detection poka-yoke provided at drilling & Tapping stage ( Part located in ID & Three spline hole ). OPL is displayed 3) Knowledge & training is provided to inspectors.	Manoj C	10/06/2023	Completed

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	No
<b>Change Details</b>	No change , OPL is displayed & training provided to inspectors
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Visual
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

## 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	Jaw observed Crack <a href="#">472_Occurance_Before.xlsx</a>
<b>Occurance (After)</b>	Replaced with New <a href="#">472_Occurance_After.xlsx</a>
<b>Outflow (Before)</b>	Visual <a href="#">472_Outflow_Before.xlsx</a>
<b>Outflow (After)</b>	Visual with Training provided to Inspector & OPL is displayed <a href="#">472_Outflow_After.xlsx</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	Applied to other Machines & Components ( wheels)

## 12. Document Review

<b>Documents</b>	WISOP
<b>Specify Other Document</b>	OPL

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	1000
<b>Reason for submission</b>	Ok