QFR No - 8000832707

Defect Details

NC No.	8000832707
NC Date	13/06/2023
NC Submission Date	
Part No.	165FY01022
Part Name	HUB CLUTCH BROACHED RE4S COMPACT+LPG
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	M/CING SHIFT.-TAPER MACHINING

1. Problem Description

Defect Description	Dimn 23.5±0.2 observed up to 23 mm (Tapper Machining)
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	7
Is Defect Repeatative?	No
Defect Sketch / Photo	

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	1000	2500
Check Qty	1000	0	0	500	1000	2500
NG Qty	7	0	0	0	0	7

Action taken on NG part

Scrap	7
Rework	0
Under Deviation	0

Containment Action
100% Stock Segregation done at the Customer end, supplier end with blue dot 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	Casting
Outsource	No
Machine / Cell	HPDC
Machine / Cell No.	HPDC 400 TON

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Component was not clamp proper	Component resting position checked	O
Man	Low skill level operator deployed on Machine	Skill matrix chart checked found ok	O
Material	Burr on resting side of component	Component was verify burr found on resting area	X
Tool	Resting and clamping are not proper work	Pressure and resting position checked	O
Machine	Chuck pressure is low	Pressure checked 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	Dim 24.30+/-0.15 observation 23.92
Why 2	Burr on was the component resting area.
Why 3	Component was skipped from fettling operation
Why 4	Machining done on was without fettling component.
Why 5	
Root Cause (Occurance)	Machining done on was without fettling component.

Root Cause Analysis (Outflow)

Why 1	Component was checking on Height gauge
Why 2	Component checking on sampling basis
Why 3	This dimension is checking in only in process stage in 2nd side operation
Why 4	
Why 5	
Root Cause (Outflow)	This dimension is checking in only in process stage in 2nd side operation

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1.Master sample Displayed at Fettling operation. 2.Work instruction of Fettling operation updated for burr is added & training given to fettling operator and inspector about defect.	PDC Supervisior	24/06/2023	28/06/2023	Completed
Outflow	1.OPL Are displayed on Maching stage and final inspection table, 2.QA Alert Displayed. 3.Inspection frequency increased 1:25 to 1:10 and updated in control plan.	QA Engineeer	24/06/2023	28/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection frequency increased 1:25 Nos to 1:10 Nos
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	1:25

10. Evidance of Countermeasure

Occurance (Before)	Master sample not displayed Work instruction not updated 477_Occurance_Before.jpg
Occurance (After)	1.Master sample Displayed at Fettling operation. 2.Work instruction of Fettling operation updated for burr is added & training given to fettling operator and inspector about defect. 477_Occurance_After.pdf
Outflow (Before)	Check point not added in final inspection stage. 477_Outflow_Before.png
Outflow (After)	1.OPL Are displayed on Maching stage and final inspection table, 2.QA Alert Displayed. 3.Inspection frequency increased 1:25 to 1:10 and updated in control plan. 477_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	1.HUB CLUTCH 3W4S MACHINED & BROACHED 2.HUB CLUTCH K70.

12. Document Review

Documents	ControlPlan, WISOP, InspCheckSheet
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	2000
Reason for submission	OK