QFR No - 8000833473

Defect Details

NC No.	8000833473
NC Date	20/06/2023
NC Submission Date	
Part No.	520JT00602
Part Name	PLATE CLUTCH JA
Supplier Name & Code	100154-IFB INDUSTRIES LTD.
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	OVALITY-MINOR DIA 85.2+0.30 OVEL FOUND 83.50~86.

1. Problem Description

Defect Description	Plate clutch not qualify to Spline gauge due to ovality observed 2.5 mm to Minor Diameter
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	2
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	niladri_nandi@ifbkolkata.com
Plant Head/CEO Email ID	alokeksarkar@ifbkolkata.com
MD Email ID	arupdas@ifbkolkata.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	12000	3000	2800	31000	51800
Check Qty	3000	12000	3000	2800	31000	51800
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action
Checking by mating part & Spline gauge

3. Process Flow

Process Flow Description
Fine Blanking, Linishing, Barreling, Straightening, Sandering, Checking & Packing

4. Process Details

Process / Operation	Material handling
Outsource	No
Machine / Cell	Material movement from TTL plant to GRP plant
Machine / Cell No.	250 TN FB press

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Material Handling	simulation done	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10 pcs/lot

7. Root Cause Analysis (Occurance)

Why 1	Component not qualify at corresponding fitment part
Why 2	Why? Component found oval
Why 3	Component storage by OD resting
Why 4	No standard defined for storage of material in bin
Why 5	
Root Cause (Occurance)	No standard defined for storage of material in bin

Root Cause Analysis (Outflow)

Why 1	Bend component found at customer end
Why 2	No inspection system defined in Control plan
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	No inspection system defined in Control plan at Final Inspection stage

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Material handling method standerdized	Vijay & Arindam	05/09/2023	05/09/2023	Pending

Outflow	100% Spline gauge checking at Final Inspection stage	Vijay	05/09/2023	05/09/2023	Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% spline gauge checking at Final Inspection stage
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

10. Evidance of Countermeasure

Occurance (Before)	
Occurance (After)	
Outflow (Before)	
Outflow (After)	

11. Horizontal Deployment

Horizontal Deployment Required	
Applicable Machine / Model / Plant	

12. Document Review

Documents	
Specify Other Document	

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	