

Defect Details

NC No.	8000833697
NC Date	21/06/2023
NC Submission Date	
Part No.	520FZ01902
Part Name	HUB CLUTCH K70
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	EXCESS M/CING-DIMN 21.20-0.25 OBS 20.73~2095 MM

1. Problem Description

Defect Description	Tapper Machining Dimn 21.20-0.25 mm found up to 20.73~20.95 mm
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	2
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@gaikgroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1500	0	0	1000	1500	4000
Check Qty	1500	0	0	1000	1500	4000
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	2
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	CNC 1st Set-up
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	CNC N0.01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Component was not clamp proper	Resting area of component was checked	X
Man	Training not given to operator	Training plan and on job training record checked	O
Man	Attitude of Operator is not good against work	Interview with operator found ok	O
Material	Damage on Component Resting area	Trial taken for damage component found NG	X
Machine	Jaw Clamping pressure was low	Jaw clamping pressure found ok	O
Man	Low skill level operator on Machine	Skill matrix chart verify found ok	O
Tool	Jaw runout is not ok	Set-up approval report checked found as per control plan	O
Tool	Burr on Component resting area in jaw	Air gun available on CNC machining stage	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	05

7. Root Cause Analysis (Occurance)

Why 1	Tapper Machining Dim 21.20-0.25 mm found up to 20.73~20.95 mm
Why 2	Component was not clamp proper
Why 3	Damage on Component Resting area
Why 4	
Why 5	
Root Cause (Occurance)	Damage on Component Resting area

Root Cause Analysis (Outflow)

Why 1	Inspection Eye sequence chart not updated at fettling stage
Why 2	This defect not added
Why 3	
Why 4	

Why 5	
Root Cause (Outflow)	Inspection Eye sequence chart not updated at fettling stage

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1. Rubber mat provided in casting stage. 2.Work instruction is updated for fettling operation damage defect checking and kept on red bin.	Production Supervisor	19/06/2023	21/06/2023	Completed
Outflow	1.QA Alert displayed on Final stage 2.OPL displayed Casting,Fettling & Machining stage 3.Training given to Operator & Final Inspector.	QA Engineer	20/06/2023	21/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NO
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	1:25

10. Evidance of Countermeasure

Occurance (Before)	Work Instruction not updated for fettling operation 488_Occurance_Before.jpg
Occurance (After)	1. Rubber mat provided in casting stage. 2.Work instruction is updated for fettling operation damage defect checking and kept on red bin. 488_Occurance_After.pdf
Outflow (Before)	Training and awareness not given to inspector and operator about defect 488_Outflow_Before.jpeg
Outflow (After)	1.QA Alert displayed on Final stage 2.OPL displayed Casting,Fettling & Machining stage 3.Training given to Operator & Final Inspector. 488_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	no

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	OK