QFR No - 8000834724

Defect Details

NC No.	8000834724
NC Date	27/06/2023
NC Submission Date	
Part No.	S2AB02207B
Part Name	ADJUSTER POWDER COATED KTEM
Supplier Name & Code	100973-TESMO MOTORCAST PRIVATE LIMITE
ETL Plant	1116-ETL K-120 Suspension
Defect Details	EXCESS MATERIAL-EXCESS MATERIAL AT SPRING RESTING FACE

1. Problem Description

Defect Description	Excess material observed at spring resting face.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	19
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rkhare@tesmomotorcast.com
Plant Head/CEO Email ID	harish.bala@tesmomotorcast.com
MD Email ID	svkallani@tesmomotorcast.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	0	0	3000	10000	15000
Check Qty	2000	0	0	3000	5000	10000
NG Qty	20	0	0	2	300	322

Action taken on NG part

Scrap	20
Rework	302
Under Deviation	0

Containment Action
1). Pin flash rework process started. 2). 100% inspection before powder coating.

3. Process Flow

Process Flow Description
C-REAMER-GRINDING-SURFACE TREATMENT-INSPECTION-POWDER COATING-SAMPLE INSPECTION-PACKING DESPATCH

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	HPDC MACHINE
Machine / Cell No.	350-1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	INSERT MATERIAL NOT GOOD	CHEMICAL COMPOSITION VARIFICATION	O
Machine	EJECITON NOT BALANCE	VISUAL CHECK FOR EJECTION PARALLILITY	O
Tool	EJECTOR PIN DIA ON MOVING INSERT INCREASES	VERNIER	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	VISUAL
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1

7. Root Cause Analysis (Occurance)

Why 1	PIN FLASH ON SPRING RESTING FACE
Why 2	EJECTOR PIN INCREASE ON INSERT
Why 3	DIE RUNNING WITH UNBALANCE EJECTION
Why 4	SETTING NOT DONE CORRECTLY
Why 5	POOR SKILL LEVEL
Root Cause (Occurance)	EJECTOR SETTING SKILL LEVEL NOT GOOD

Root Cause Analysis (Outflow)

Why 1	PIN FLASH ON SPRING RESTING FACE
Why 2	PIN FLASH CHECKING IS MISSED BY INSPECTOR
Why 3	IMPROPER TRAINING TO INSPECTOR
Why 4	VISUAL DISPLAY NOT AVAILABLE
Why 5	
Root Cause (Outflow)	VISUAL DISPLAY OF PIN FLASH NOT AVAILABLE

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	PIN & DIAMETER CHECKING	SACHIN	15/07/2023	15/07/2023	Completed
Occurance	VISUAL DISPLAY AT INSPECTION WITH PROPER TRAINING	RAHUL KHARE	15/07/2023	15/07/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	VISUAL DISPLAY IN INSPECTION TABLE WITH SAMPLE
Inspection Method	Other
Other Inspection Method	VISUAL
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1

10. Evidance of Countermeasure

Occurance (Before)	PART WITH PIN FLASH 500_Occurance_Before.jpg
Occurance (After)	EJECTOR PIN DIA INCREASE 500_Occurance_After.jpg
Outflow (Before)	PART WITH PIN FLASH 500_Outflow_Before.jpg
Outflow (After)	SAMPLE PLACED ON FINAL STAGE 500_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	InspCheckSheet
Specify Other Document	PART DISPLAY

13. Effectiveness Of Action

Reviewed Quantity	10
Reason for submission	Against reported defect.