QFR No - 8000834816

Defect Details

NC No.	8000834816
NC Date	29/06/2023
NC Submission Date	
Part No.	S2BG02502B
Part Name	BRACKET UN P/C KTEP
Supplier Name & Code	100973-TESMO MOTORCAST PRIVATE LIMITE
ETL Plant	1116-ETL K-120 Suspension
Defect Details	BROKEN-BROKEN AT BUSH FITTING STAGE

1. Problem Description

Defect Description	Part Broken during assembly condition. This is very serious as well as safety critical concern, & may leads to field complaint.
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	2
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	3000	0	0	3000	4000	10000
Check Qty	3000	0	0	3000	4000	10000
NG Qty	0	0	0	0	1	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
Checking started in final stage with dot mark at bottom side

3. Process Flow

Process Flow Description
PDC - REAMER - DEBURRING - INSPECTION - SURFACE TREATMENT - CHAMFER - TAPPING - PACKING

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	DIE CASTING MACHINE
Machine / Cell No.	250-02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	CORE OUT INCOMPLETE	PHYSICAL	O
Method	EJECTION UNEVEN	VISUAL	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	Part cracked from its I-section
Why 2	I-section area get weak due to hair crack generation
Why 3	Part get tilted in hot condition while ejection process in PDC
Why 4	Core not completely out and ejection done
Why 5	Core slider Jam due to flash inside core sliding area
Root Cause (Occurance)	Machine run with flash in core area.

Root Cause Analysis (Outflow)

Why 1	Cracked part found at customer end
Why 2	Crack not checked
Why 3	KTEP parts particular location crack checking not happening in final stage
Why 4	Checking points not provided
Why 5	
Root Cause (Outflow)	Point not available in check point of inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	Crack check point added in inspection	Ankush	29/06/2023	30/06/2023	Completed
Occurance	Tool to run with flash free	Ravi	28/06/2023	30/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Crack checking for this specific location incorporated in final inspection
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)	Flash at core side 498_Occurance_Before.jpeg
Occurance (After)	Zero flash 498_Occurance_After.jpeg
Outflow (Before)	Cracked Part 498_Outflow_Before.jpeg
Outflow (After)	Quality Alert Displayed 498_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	KWPK

12. Document Review

Documents	InspCheckSheet
Specify Other Document	Alert displayed

13. Effectiveness Of Action

Reviewed Quantity	10
Reason for submission	Corrective action parts submission.