QFR No - 8000835012

Defect Details

NC No.	8000835012
NC Date	30/06/2023
NC Submission Date	
Part No.	C2PP00320B
Part Name	WHEEL CLUTCH_C20009_D1
Supplier Name & Code	100432-BHAKTI AUTO COMP PRIVATE LIMIT
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	TAPPING O/SIZE.-THREADING OVERSIZE ISSUE(PPG NOGO QUALIF

1. Problem Description

Defect Description	Threading Oversize -Fitment bolt loose (Minor Diameter found oversize)
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	32
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	bhaktiauto2008@gmail.com
Plant Head/CEO Email ID	bhaktiauto2008@gmail.com
MD Email ID	vinodanin@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	400	0	0	400	800	1600
Check Qty	400	0	0	400	800	1600
NG Qty	32	0	0	0	0	32

Action taken on NG part

Scrap	32
Rework	0
Under Deviation	0

Containment Action
100% lot verified at customer end Inhouse WIP & FG stock verified

3. Process Flow

Process Flow Description
Raw Material - Melting - Casting - Fettling - Face machining -6 hole Drill & Tapping - Inspection - PDI - Dispatch

4. Process Details

Process / Operation	Drilling & Tapping
Outsource	Yes
Machine / Cell	machining
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	part loading on fixture	part loose after claming	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	05

7. Root Cause Analysis (Occurance)

Why 1	part located of fixture improperly
Why 2	locating person not able to judge the perfect clamping after his clamping operation
Why 3	semi skilled operator
Why 4	Entry level L1 operator
Why 5	
Root Cause (Occurance)	Part in proper clamping on fixture due to shift drilling minor ID get Oversized as already casting hole is there.

Root Cause Analysis (Outflow)

Why 1	Skipped from final inspection
Why 2	No Inspection check point to the same
Why 3	Dimensional inspection is on sampling basis
Why 4	
Why 5	
Root Cause (Outflow)	Check point is not available hence not able to block defect in inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Skilled Manpower L3 allotted to D/T Operation.	GS engineering	08/07/2023	07/07/2023	Completed

Outflow	Inspection check point added	Bhakti Auto	07/07/2023	07/07/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	M6x1 Minor ID inspection check point is added in check point
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)	Semi Skilled operator 502_Occurance_Before.bmp
Occurance (After)	skilled operator Provided 502_Occurance_After.bmp
Outflow (Before)	No Check Point 502_Outflow_Before.jpg
Outflow (After)	Check Point added in Inspection 502_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan
Specify Other Document	Control plan

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	Occurrence Side Action not mention ,Also Required sustenance side action