QFR No - 8000854205

Defect Details

NC No.	8000854205
NC Date	08/12/2023
NC Submission Date	
Part No.	520PP01902
Part Name	WHEEL CLUTCH FINISHED UPGRADE
Supplier Name & Code	100656-MADHURA DIE CAST PVT.LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	HIGHT O/SIZE.-LUG HIGHT OBS 27.6+ AGAINST 26.60 +/-0.1

1. Problem Description

Defect Description	Lug Height found oversize up to 27.38~27.6 mm against 26.60±0.1 mm
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	1
Is Defect Repeatative?	Yes
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@gaikegroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	500	0	500	500	2500
Check Qty	1000	500	0	500	500	2500
NG Qty	1	0	0	0	500	501

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
100% Stock segregate at customer end and Supplier end stock.

3. Process Flow

Process Flow Description
1.Casting 2.fetling 3. CNC 1st Set-up 4.CNC 2nd Set-up 5.Drilling & Tapping 6.Final Inspection

4. Process Details

Process / Operation	CNC 2ND SETUP
Outsource	No
Machine / Cell	CNC
Machine / Cell No.	07

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	chuck jaw loose	Checked found ok	O
Man	Unskill Operator On machine.	Skill Matrix Varified & Found OK.	O
Tool	Insert got wear	Checked found ok	O
Method	component shift	verified found not ok component shift due to extra material above OD. So face side got more cut.	X

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	1:1

7. Root Cause Analysis (Occurance)

Why 1	HIGHT O/SIZE.-LUG HIGHT OBS 27.6+ AGAINST 26.60 +/-0.1
Why 2	Extra cut on resting face of part during cnc 2nd setup machining
Why 3	Part move & come in front side.
Why 4	Because extra material found in Outer dia .
Why 5	Then there is component shift due to extra material above OD. So face side got more cut.
Root Cause (Occurance)	Then there is component shift due to extra material above OD. So face side got more cut.

Root Cause Analysis (Outflow)

Why 1	HIGHT O/SIZE.-LUG HIGHT OBS 27.6+ AGAINST 26.60 +/-0.1
Why 2	100% Inspection not done
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Inspection done on sampling basis

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	1. Training & Awarness given to operator. 2. OPL is displayed. 3.Quality Alert is displayed.	QUALITY SUPERVISOR	21/12/2023	20/12/2023	Completed
Occurance	1. Started 100 % inspection after fettling operation. 2. Correction done in CNC Program ,OD Cut increases.	PRODUCTION SUPERVISOR	21/12/2023	20/12/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Started 100 % inspection after fettling operation.
Inspection Method	Other
Other Inspection Method	VISUAL
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1:1

10. Evidance of Countermeasure

Occurance (Before)	component shift due to extra material above OD. So face side got more cut. 611_Occurance_Before.jpg
Occurance (After)	1. Started 100 % inspection after fettling operation. 2. Correction done in CNC Program ,OD Cut increases. 611_Occurance_After.pdf
Outflow (Before)	100% Inspection not done 611_Outflow_Before.jpg
Outflow (After)	1. Training & Awarness given to operator. 2. OPL is displayed. 3.Quality Alert is displayed. 611_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	QUALITY ALERT,OPL

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	OK-Sustenance to be monitored