QFR No - 8000855363

Defect Details

NC No.	8000855363
NC Date	18/12/2023
NC Submission Date	
Part No.	520JT00302
Part Name	PLATE CLUTCH 3W-4S UPGRADE
Supplier Name & Code	100150-DHANANJAY ENTERPRISES
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	THICKNESS UNDERSIZE-THICKNESS U/S UP TO 1.63 AGAINST 2.0

1. Problem Description

Defect Description	Wrong Thickness observed in 3W4S Plate clutch (1.6 mm observed in 2 mm)
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	17
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qade@dhananjaygroup.com
Plant Head/CEO Email ID	de@dhananjaygroup.com
MD Email ID	kandakuretn@dhananjaygroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	19480	0	0	20160	0	39640
Check Qty	19480	0	0	20160	0	39640
NG Qty	22	0	0	52	0	74

Action taken on NG part

Scrap	74
Rework	0
Under Deviation	0

Containment Action
Segregated whole lot at the M/s ETL end & our DE-I plant end.

3. Process Flow

Process Flow Description
Receiving inspection of RM?Blanking & Piercing?Deburring?Cleaning?Planishing?Straightening?Final Inspection?Oiling & Packing?Logistics/Dispatch

4. Process Details

Process / Operation	Blanking & Piercing
Outsource	No
Machine / Cell	Press Machine-Pnumatic 100T
Machine / Cell No.	Machine no.-10000063

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Set-up approval	Set-up approval not followed after RM coil change	X
Man	Man- Unskilled Operator	Unskilled operator for loading of coil	X
Man	Man- Wrong coil loading	Wrong thickness coil loading on D-coiler	X
Material	Material- RM Storage	No separate storage location for same width different thickness coils	X
Material	Material- Wrong thk.	Wrong material thickness coil loaded on D-coiler	X
Machine	Machine- Excess deburring	No excess deburring done on part	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Wrong thickness in Plate Clutch 3W4S
Why 2	Required thickness 2 observed 1.6mm
Why 3	Two packed form RM coils have same width but different thickness.
Why 4	No separate storage location available.
Why 5	
Root Cause (Occurance)	No separate storage location available.

Root Cause Analysis (Outflow)

Why 1	Wrong thickness in Plate Clutch 3W4S
Why 2	Required thickness 2 observed 1.6mm
Why 3	Set up approval not done after RM Coil change.
Why 4	Set-up approval done during changeover of part/die only.
Why 5	RM coil loading approval report not considered in setting of new RM coil on D-Coiler in PFMEA
Root Cause (Outflow)	RM coil loading approval report not considered in setting of new RM coil on D-Coiler in PFMEA

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Separate location provided for same width-different thickness raw material coil	Mr. Nikhil Attarde	30/12/2023	30/12/2023	Completed
Occurance	Colour coding with blue & yellow paint colour according to thickness of same width different thickness RM coils to be ensured by incoming inspection person.Meantime the same to be informed to supplier for this colour codification.	Mr. Nikhil Attarde	30/12/2023	30/12/2023	Completed
Outflow	100% inspection of material for thickness with Gap gauge started for next 1 month.	Mr. Nikhil Attarde	30/12/2023	18/12/2023	Completed
Outflow	Raw material coil loading approval report provided for every new coil loading on D-coiler.	Mr. Nikhil Attarde	30/12/2023	30/12/2023	Completed
Occurance	Training given to operator	Mr. Nikhil Attarde	30/12/2023	20/12/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Gap-Gauge inspection started 100% for thickness mix-up detection for next one month
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05nos/lot

10. Evidance of Countermeasure

Occurance (Before)	RM coils of same width and different thickness have no separate location available for storage. 618_Occurance_Before.jpg
Occurance (After)	RM coils of same width and different thickness have allocated separate location for storage. 618_Occurance_After.jpg
Outflow (Before)	Set-up approval report take for die-change & start of the shift only. 618_Outflow_Before.pdf
Outflow (After)	RM coil loading approval report for every new coil loading on machine D-coiler. 618_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	N.A

12. Document Review

Documents	ControlPlan, PFMEA, InspCheckSheet

Specify Other Document	N.A

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	OK