QFR No - 8000862173

Defect Details

NC No.	8000862173
NC Date	07/02/2024
NC Submission Date	
Part No.	F2PD02007B
Part Name	UPPER BRACKET P/C-XF-1C1
Supplier Name & Code	100001-ANANT ENTERPRISES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	RUNOUT-BLOW HOLE, PIN HOLE AND CUT MARKS

1. Problem Description

Defect Description	Casting defects
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	50
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	anandkulkarni@anantgroup.co.in
Plant Head/CEO Email ID	pramodgosavi@anantgroup.co.in
MD Email ID	ashwinjoshi@anantgroup.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	200	0	0	150	100	450
Check Qty	200	0	0	150	100	450
NG Qty	50	0	0	19	0	69

Action taken on NG part

Scrap	69
Rework	0
Under Deviation	0

Containment Action
100 % parts checked and identification mark provide on part.

3. Process Flow

Process Flow Description
Raw material received - Storage - Melting - Molten metal transfer to holding - Metal treatment - Die preparation - Casting - Cutting - grinding - Heat Treatment - Visual inspection - Powder coating - machining - final inspection - dispatch.

4. Process Details

Process / Operation	Casting, powder coating, & Machining.
Outsource	No
Machine / Cell	pF no 3
Machine / Cell No.	GDC M/c

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	The operator was not skilled	Skill matrix	O
Material	Other material used	Ok material used	O
Machine	Solidification time reduced.	Timer check found ok	O
Method	Die coating process.	Air vent not cleaned die coat accumulated	X
Tool	other tool used	OK tool used.	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	100%

7. Root Cause Analysis (Occurance)

Why 1	Pin hole due to turbulence
Why 2	Turbulence due to air entrapment
Why 3	Insufficient air vents
Why 4	Die coat accumulated in air vent
Why 5	Die coat not cleaned after coating apply.
Root Cause (Occurance)	Die coat not cleaned after coating apply.

Root Cause Analysis (Outflow)

Why 1	Visual inspection not done.
Why 2	Defect severity not aware.
Why 3	Training in effective.
Why 4	
Why 5	
Root Cause (Outflow)	Training in effective.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Training provided to final inspectors.	Mr Nisar	28/02/2024	28/02/2024	Completed
Occurance	1) Air vent cleaning frequency increased. 2) Periodically verification started.	Mr Sunil Monde	28/02/2024	28/02/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% parts checked
Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	PM check sheet before 669_Occurance_Before.pdf
Occurance (After)	PM check sheet after 669_Occurance_After.pdf
Outflow (Before)	No Training 669_Outflow_Before.pdf
Outflow (After)	Training given to inspectors 669_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	no

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	210
Reason for submission	Found ok