QFR No - 8000863411

Defect Details

NC No.	8000863411
NC Date	17/02/2024
NC Submission Date	
Part No.	520FG07802
Part Name	GEAR PRIMARY DRIVEN (JZ)
Supplier Name & Code	200172-AURANGABAD AUTO ENGG PVT LTD
ETL Plant	1132-ETL K-226/1 TRANSMISSION
Defect Details	PATCH MARK ON FACE.-DFC OBS 0.12 AGAINST 0.07

1. Problem Description

Defect Description	Flicker observed excess up to 0.030 mm against 0.010 mm -DFCE observed 0.12 mm against 0.040 mm
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	1
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	verma.aaepl@gmail.com
Plant Head/CEO Email ID	aaepl.pantnagar@sangkaj.com
MD Email ID	steel@sangkaj.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1565	0	0	1008	1890	4463
Check Qty	1565	0	0	1008	1890	4463
NG Qty	25	0	0	12	7	44

Action taken on NG part

Scrap	0
Rework	44
Under Deviation	0

Containment Action
All WIP 100% Rechecked

3. Process Flow

Process Flow Description
CNC Blank Inward---Hobbing ---HT--- ID Honing---Teeth Honing -----Final Inspection ----Oiling Packing ---Dispatch

4. Process Details

Process / Operation	Teeth Honing
Outsource	Yes
Machine / Cell	Teeth Honing Machine
Machine / Cell No.	HMX 260

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Less Allowance for teeth Honing	Less allowance for teeth honing	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Patch mark on teeth
Why 2	less material removal on teeth honing operation
Why 3	As per process requirement no sufficient stock for teeth honing
Why 4	Teeth honing input material face runout excess due to part excess bend in HT process
Why 5	HT charge making fixture bend & Crack
Root Cause (Occurance)	HT charge making fixture bend & Crack

Root Cause Analysis (Outflow)

Why 1	Patch mark on teeth
Why 2	Part detected in final inspection
Why 3	less awareness of final inspector
Why 4	N/A
Why 5	N/A
Root Cause (Outflow)	Less awareness of final inspector

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	New HT charge making plate ordered	Mr.Raut	20/03/2024		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1) Training provided to all final inspector 2) Ok Not Ok part OPL displayed at final inspection 3) Before teeth honing 100% face runout inspection started .
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Evidence attached 684_Occurance_Before.xlsx
Occurance (After)	Evidence attached 684_Occurance_After.xlsx
Outflow (Before)	Evidence attached 684_Outflow_Before.xlsx
Outflow (After)	Evidence attached 684_Outflow_After.xlsx

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan, WISOP, AuditCheckSheet, InspCheckSheet
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	