QFR No - 8000865191

Defect Details

NC No.	8000865191
NC Date	29/02/2024
NC Submission Date	
Part No.	B2GQ04103O
Part Name	M/CYL RAW-K1,K1R,K2,K11TDABS PDC Ø12.7
Supplier Name & Code	100471-CASTALL TECHNOLOGIES (P) LTD
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	BLOW HOLES-PIN HOLE, BLOW HOLE DENT &DAMAGED

1. Problem Description

Defect Description	BLOW HOLES-PIN HOLE, BLOW HOLE DENT &DAMAGED
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	445
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qa@castalltech.com
Plant Head/CEO Email ID	sg@castalltech.com
MD Email ID	nmv@castalltech.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	0	0	2100	0	2100
Check Qty	0	0	0	2100	0	2100
NG Qty	0	0	0	2	0	2

Action taken on NG part

Scrap	0
Rework	2
Under Deviation	0

Containment Action
100% checked at vendors site

3. Process Flow

Process Flow Description
Operation # 100 & 110

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	PDC 400
Machine / Cell No.	PDC 4

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Air entrapped in cavity	verified	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	2nos/1hr

7. Root Cause Analysis (Occurance)

Why 1	Air not escaped from cavity
Why 2	In sufficient air vent
Why 3	Air entraped in cavity
Why 4	
Why 5	
Root Cause (Occurance)	Air entraped in cavity

Root Cause Analysis (Outflow)

Why 1	Machining process at customer end
Why 2	sampling inspection at castall
Why 3	Blow holes will find after machining at customer end
Why 4	
Why 5	
Root Cause (Outflow)	Blow holes will find after machining at customer end

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Cut section was added along with Sampling inspection	QA	31/03/2024	04/04/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Cut section was added along with Sampling inspection
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	2nos/hour

10. Evidance of Countermeasure

Occurance (Before)	Single chillvent passage available. 701_Occurance_Before.jpg
Occurance (After)	Extra chillvent passage was added to reduce blow holes. 701_Occurance_After.jpg
Outflow (Before)	Boroscope inspection done for bore porosity/blow holes . 701_Outflow_Before.jpeg
Outflow (After)	Cut section was added Along with Boroscope inspection for porosity/blow holes . 701_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All master cylinder variants

12. Document Review

Documents	WISOP
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	250
Reason for submission	Improvement found in next lots