

Defect Details

NC No.	8000870484
NC Date	08/04/2024
NC Submission Date	
Part No.	B2FP045030
Part Name	HOLDER BRACKET BODY RAW- K2 REAR ABS
Supplier Name & Code	101180-MAULI CAST TECH PVT. 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	Aesthetic
NG Quantity	87
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@maulicasttech.com
Plant Head/CEO Email ID	planthead@maulicasttech.com
MD Email ID	shrikant.shelke@maulimetal.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	9301	0	0	835	3080	13216
Check Qty	9301	0	0	835	3080	13216
NG Qty	87	0	0	9	33	129

Action taken on NG part

Scrap	6
Rework	36
Under Deviation	0

Containment Action

All castings are segregated at ETL end & in-house also. And defective parts are being reworked at M/s-Mauli Casttech.

3. Process Flow

Process Flow Description

1.Raw material receive-->2.Incoming Inspection-->3.Raw Ingot Melting-->4.N2 Degassing Process-->5.Liquid Metal Transfer-->6.GDC Production-->7.Gate/Raiser Cutting-->8.Buffing Process-->9.Fetlling Process--> 10.Heat Treatment--> 11.Shot Blasting-->12.Engraving/Marking-->13.Final Inspection-->14.Move to FG-->15.PDIR Inspection-->16.Packing & Dispatch.

4. Process Details

Process / Operation	At Riser & gate cutting stage.
Outsource	No
Machine / Cell	N/A
Machine / Cell No.	N/A

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Coating mixing process not ok.	Operator manually mixing the water & die coat.	X
Method	Metal to metal contact,New manpower,Impurities in molten metal	Poor material handling,Change of regular manpower,Dross in metal	X
Man	Unskilled manpower	New operator deputed for operation.	X
Tool	Improper tool using for operation	Tool shape not good.	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Metal to metal contact in shop floor.
Why 2	Poor material handling.
Why 3	Bins are got damaged.
Why 4	Separate bins are not available.
Why 5	Plastic bin shortage for shop floor movement.
Root Cause (Occurance)	During shop floor movement of casting dedicated bins are not available.

Root Cause Analysis (Outflow)

Why 1	No metal metal contact during operation.
Why 2	Proper handling of material.
Why 3	Do not use the damaged bins.
Why 4	Dedicated bins to be provided to operator.
Why 5	
Root Cause (Outflow)	For shop floor casting movement dedicated bins to be provided.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Proper dedicated bins to be provide at all operation stages.	Mr.Somesh Rout	14/08/2024	08/05/2024	Completed
Outflow	Part wise dedicated bins to be provide for all operations.	Mr.Somesh Rout	14/08/2024	08/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Q gate inspection has started at buffing & fettling area.
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	Every lot

10. Evidence of Countermeasure

Occurance (Before)	Casting movement in non-standard bins at post operation stage. 738_Occurance_Before.jpeg
Occurance (After)	Now standard bins are procure for post operation stage. for proper part handling. 738_Occurance_After.jpeg
Outflow (Before)	Semi skilled operator are deputed at post operation stage. 738_Outflow_Before.jpeg
Outflow (After)	Now operator OJT has given & deputed at post operation stage. And skill matrix has updated. 738_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Applicable to all Holder bracket model.

12. Document Review

Documents	PFMEA, WISOP, AuditCheckSheet, PackingStd, InspCheckSheet
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	found ok

