QFR No - 8000870485

Defect Details

NC No.	8000870485
NC Date	08/04/2024
NC Submission Date	
Part No.	520BK01573
Part Name	CALIPER BODY INTEGRAL TYPE PULSAR
Supplier Name & Code	101414-G. S. ENGINEERING
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	Receipt
Problem Severity	Aesthetic
NG Quantity	600
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	bhange.shrikant@rediffmail.com
Plant Head/CEO Email ID	subhashmarathe45@gmail.com
MD Email ID	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4780	0	0	0	0	4780
Check Qty	4780	0	0	0	0	4780
NG Qty	600	0	0	0	0	600

Action taken on NG part

Scrap	600
Rework	0
Under Deviation	0

Containment Action
Segregation to ETL end

3. Process Flow

Process Flow Description
Raw material -- Melting -- Degassing -- Core manufacturing -- Casting manufacturing -- De-coring -- Gate cutting -- Fettling & Buffing -- Punching -- Heat Treatment -- Shot Blassting -- Finel Inspection -- Dispatch.

4. Process Details

Process / Operation	GDC
Outsource	No
Machine / Cell	GDC Machine
Machine / Cell No.	M/C No.:- 03

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Turbulence is created while pouring metal into the die	Saucer is arranged for pouring the metal so that the metal reaches all the cavities uniformly	O
Tool	Insufficient air vents in the die, core gas was entrapment	Adequate air vents are provided in the die so that air escapes easily	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Blow hole observed in casting
Why 2	core gas entrapped in casting during process
Why 3	Inadequate venting to escape gas from cavity during casting
Why 4	
Why 5	
Root Cause (Occurance)	Inadequate venting to escape gas from cavity during casting

Root Cause Analysis (Outflow)

Why 1	Blow hole observed in casting
Why 2	Visually not detected in casting
Why 3	Open after machining process at customer end
Why 4	
Why 5	
Root Cause (Outflow)	Open after machining process at customer end

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Training given to operator & Q gate inspector. 100% inspection before & after shot blasting	Mr. S Dhabe	06/05/2024	29/04/2024	Completed
Occurance	Vent to be provided in die from easy escape of gases during casting	Mr. S Marathe	06/05/2024	29/04/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	in-process every hour a visual inspection by production supervisor / QA, DP test is conducted every shift ,100% visual inspection before & after shot blasting & 100% visual inspection before final dispatch.
Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Air vents depth 0.1mm .Inadequate air passing through this 739_Occurance_Before.jpg
Occurance (After)	Air vents depth 0.2mm. This helps the air to escape freely 739_Occurance_After.jpg
Outflow (Before)	Eye sequence chart 739_Outflow_Before.pdf
Outflow (After)	Eye sequence chart is updated 739_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	GDC

12. Document Review

Documents	WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	No defect observed in latest lot