

Defect Details

NC No.	8000881302
NC Date	05/07/2024
NC Submission Date	
Part No.	B2BK056030
Part Name	CALIPER BODY RAW-N-TORQ CBS
Supplier Name & Code	100398-MANOJ INDUSTRIES
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	BLOW HOLES-BLOW HOLE, DENT DAMAGE

1. Problem Description

Defect Description	EXTRA CASTING IN PAD SPRING AREA, BH & DAMAGED
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	316
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	dlad@manojind.com
Plant Head/CEO Email ID	siju@manojind.com
MD Email ID	mgnt@manojindustriestkop.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	7646	300	0	0	1200	9146
Check Qty	7646	300	0	0	1200	9146
NG Qty	316	0	0	0	0	316

Action taken on NG part

Scrap	316
Rework	0
Under Deviation	0

Containment Action

Sort out all pipe line material

3. Process Flow

Process Flow Description

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4. Process Details

Process / Operation	Casting production
Outsource	No
Machine / Cell	MI Tilt -9
Machine / Cell No.	-

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Sand core finish rough at pad spring area	Visually verified sand core	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	EXTRA CASTING IN PAD SPRING AREA
Why 2	Its sand core area, Due to sand fall casting get extra material
Why 3	Sand core observed rough at profile area
Why 4	
Why 5	
Root Cause (Occurance)	Sand core observed rough at profile area

Root Cause Analysis (Outflow)

Why 1	EXTRA CASTING IN PAD SPRING AREA
Why 2	Skipped by final inspection.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Skipped by final inspection.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	For smooth & avoid extra material at pad spring area silver paint applied at sand core profile area	Siju D	09/07/2024	09/07/2024	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	After final inspection dot marking done on casting at pad spring area.
Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	Sand core observed rough at pad spring area 904_Occurance_Before.pptx
Occurance (After)	Silver paint applied at sand core profile area. 904_Occurance_After.pptx
Outflow (Before)	Skipped by final inspection 904_Outflow_Before.pptx
Outflow (After)	Q alert displayed at final inspection area 904_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	--

12. Document Review

Documents	
Specify Other Document	--

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	Improvement found in next lots