QFR No - 8000881358

Defect Details

NC No.	8000881358
NC Date	05/07/2024
NC Submission Date	
Part No.	B2RC03824O
Part Name	CALIPER PISTON ANODISED DIA 28
Supplier Name & Code	101261-BHOGALE AUTOMOTIVE PRIVATE LIM
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	SURFACE FINISH NOT OK-UNCLEAN AT BOTTOM

1. Problem Description

Defect Description	Unclean AT Bottom Side
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	23
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	nikhil.kulkarni@bhogaleauto.com
Plant Head/CEO Email ID	rajendra.randive@bhogaleauto.com
MD Email ID	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	1300	900	3200
Check Qty	1000	0	0	1300	900	3200
NG Qty	23	0	0	0	0	23

Action taken on NG part

Scrap	23
Rework	0
Under Deviation	0

Containment Action
1) 2300 parts verified in pipeline. 2) 2nd firewall implemented till issue resolved.

3. Process Flow

Process Flow Description
Reciept insp. > Forging > Heat treatment > Trimming > Grinding > Final Inspection > Packing and dispatch

4. Process Details

Process / Operation	Forging
Outsource	No
Machine / Cell	Forging press
Machine / Cell No.	P1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Die not cleaned	Forging lubrication paste diposited on die in running	O
Machine	Pressure variation	Checked consistancy over 100 parts, found ok	X
Material	Short input billet size	Billet cutting is program controlled and checked repeatability found ok	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Manual/ Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	10

7. Root Cause Analysis (Occurance)

Why 1	After CNC machining 2nd, part having unclean face.
Why 2	Machining not done on partial outer portion of face.
Why 3	Forging face is not having flatness, as required.
Why 4	Forging ejection pin having lubrication paste stuck on corners.
Why 5	Die and pin does not cleaned, during production.
Root Cause (Occurance)	Tooling not cleaned frequently during production.

Root Cause Analysis (Outflow)

Why 1	Defect skipped from visual inspection.
Why 2	Due to surface dying, surface appearance matches with machining
Why 3	Difference difficult to understand
Why 4	
Why 5	
Root Cause (Outflow)	Inspector not understand the defect

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Tool cleaning after every 500 nos forging is implemented in WIS	NSK	28/06/2024		Pending
Occurance	Control plan revised	NSK	28/06/2024		Pending
Outflow	Refreshment training given to inspectors.	NSK	27/06/2024		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No change in inspection method
Inspection Method	Other
Other Inspection Method	Visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	all

10. Evidance of Countermeasure

Occurance (Before)	No tool cleaning frequency defined in forging WIS 907_Occurance_Before.png
Occurance (After)	Cleaning frequency defined in forging WIS 907_Occurance_After.png
Outflow (Before)	Defect forging unclean not in visual inspection WIS 907_Outflow_Before.pdf
Outflow (After)	Defect forging unclean added in visual inspection WIS 907_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Not applicable

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	Not applicable

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	