QFR No - 8000886611

Defect Details

NC No.	8000886611
NC Date	12/08/2024
NC Submission Date	
Part No.	F2FQ00407B
Part Name	HOLDER HANDLE UPPER P/C (XF-521)
Supplier Name & Code	201092-PRANEEL INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	B/H INSIDE BORE- BLOW HOLE

1. Problem Description

Defect Description	Bore ID Blow Hole
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	22
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@praneelgroup.com
Plant Head/CEO Email ID	praneelindustries@rediffmail.com
MD Email ID	anilpatil@praneelgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1633	0	0	250	0	1883
Check Qty	1633	0	0	250	0	1883
NG Qty	22	0	0	10	0	32

Action taken on NG part

Scrap	32
Rework	0
Under Deviation	0

Containment Action
All material at ETL end and at In-house sagrigated and NG quantity rejected at ETL end and at In-house.

3. Process Flow

Process Flow Description
Raw casting inward =>Powder Coating=>Powder Coating inward=>VMC Machining=>De-burring=>Final Inspection=>Packing and Dispatch.

4. Process Details

Process / Operation	VMC Machining
Outsource	No
Machine / Cell	VMC Machine
Machine / Cell No.	VMC Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Machine parameter not as per control plan	Verify the machine parameter and found Ok	O
Tool	Drill not as per required.	Verify the drill size and found ok.	O
Material	Material not as per required specification.	Verify the material report found Ok.	O
Man	Skilled inspector not available	Verify the skill matrix,found Ok.	O
Method	Inspection method not as per required.	Verify the checking method and found inadequate.	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Blow Hole inside the bore size 8.4+0.1mm.
Why 2	Rubbish metal poured in the die.
Why 3	Impurities observed after degassing in the furnace.
Why 4	Metal cleaning process not done properly.
Why 5	
Root Cause (Occurance)	Metal cleaning process not done properly.

Root Cause Analysis (Outflow)

Why 1	Blow Hole inside the bore size 8.4+0.1mm.
Why 2	Skipped from final inspection.
Why 3	No awareness about checking the blow hole inside the bore.
Why 4	
Why 5	
Root Cause (Outflow)	No awareness about checking the blow hole inside the bore.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Wire Mesh filter to be implement	Mr.Ramdas Boinale	05/09/2024	11/09/2024	Completed
Outflow	Awareness and Training given to inspector for checking blow hole inside the bore.	Mr.Yogesh Sonune	19/08/2024	19/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Visual inspection started for Blow Hole inside the bore.
Inspection Method	Other
Other Inspection Method	Visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	samp.plan

10. Evidance of Countermeasure

Occurance (Before)	No any wire mesh filter provided at the insert. 1005_Occurance_Before.pptx
Occurance (After)	Wire mesh filter will be implement at the insert. 1005_Occurance_After.pptx
Outflow (Before)	Before no any marking at bore 8.40+0.1mm. 1005_Outflow_Before.pptx
Outflow (After)	After inspection marking started near to the bore 8.40+0.1mm and Training provided for the same. 1005_Outflow_After.pptx

11. Horizontal Deployment

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

12. Document Review

Documents	WISOP
Specify Other Document	Training record

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK