QFR No - 8000887711

Defect Details

NC No.	8000887711
NC Date	20/08/2024
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-BH,PH, DENT & DAMAGED, AFTER 100% INSPEC

1. Problem Description

Defect Description	BLOW HOLES-BH,PH, DENT & DAMAGED, AFTER 100% INSPEC
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	377
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

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

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3160	0	0	0	0	3160
Check Qty	3160	0	0	0	0	3160
NG Qty	337	0	0	0	0	337

Action taken on NG part

Scrap	337
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 - Final Inspection - Dispatch.

4. Process Details

Process / Operation	GDC
Outsource	No
Machine / Cell	GDC Machine
Machine / Cell No.	GDC Machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Turbulence is created while pouring metal into the die	Saucer is arranged for pouring the metal & tilting angle time fixed so that metal reaches uniformly.	O
Method	Handling of casting,bins not properly	Arranged inhouse handling bins & improved packing standerd	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	Blow hole observed in casting.
Why 2	Turbulence is created while pouring metal into the die.
Why 3	Direct metal pouring.
Why 4	
Why 5	
Root Cause (Occurance)	Turbulence is created while pouring metal into the die.

Root Cause Analysis (Outflow)

Why 1	Blow hole observed in casting.
Why 2	visually not detected in casting.
Why 3	Open after Shot blasting in-house and same open after powder coating process at customer end.
Why 4	
Why 5	
Root Cause (Outflow)	Open after Shot blasting in-house and same open after powder coating process at customer end.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Training given to Q gate inspector.OPL Display ,100% inspection before shot blasting and 100% inspection after shot blasting total :- 200% visually inspection, packing standard improve	S.Dhabe	23/08/2024	23/08/2024	Completed
Occurance	Saucer is arranged for pouring the metal,tilting angle fixed, pouring method change ,training given to operator.	S. Marathe	23/08/2024	24/08/2024	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 conducted every shift,Density index maintain under 2, 200% time visually inspection.
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)	Inappropriate pouring method and less machine tilting time 1036_Occurance_Before.pptx
Occurance (After)	Appropriate pouring method and much machine tilting time 1036_Occurance_After.pptx
Outflow (Before)	Old packing standard no using polythene bag. 1036_Outflow_Before.pptx
Outflow (After)	Improving packing standard using polythene bag. 1036_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	All GDC machine

12. Document Review

Documents	PackingStd
Specify Other Document	OPL Display

13. Effectiveness Of Action

Reviewed Quantity	20
Reason for submission	found ok