QFR No - 8000887715

Defect Details

NC No.	8000887715
NC Date	20/08/2024
NC Submission Date	
Part No.	52GQ01013O
Part Name	M/CYL BODY PDC BORE BURNISHED -K11,K2,
Supplier Name & Code	101100-CAST 4 ALUMINIUM PVT LTD
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	BLOW HOLES-BH AFTER MACHINING

1. Problem Description

Defect Description	BLOW HOLES-BH AFTER MACHINING
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	58
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	info@cast4aluminium.com
Plant Head/CEO Email ID	info@cast4aluminium.com
MD Email ID	kiran@cast4aluminium.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1000	0	0	0	456	1456
Check Qty	1000	0	0	0	456	1456
NG Qty	695	0	0	0	103	798

Action taken on NG part

Scrap	695
Rework	0
Under Deviation	0

Containment Action
Not ok parts rejected and scrapped.

3. Process Flow

Process Flow Description
RM inward & inspection -- melting -- N2 degassing -- PDC -- gate cutting -- inspection -- fettling -- shot blasting -- inspection -- packing & dispatch

4. Process Details

Process / Operation	PDC
Outsource	No
Machine / Cell	PDC machine
Machine / Cell No.	PDC machine no. 8

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Material cleaning freq. not adequate	no	O

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	100%

7. Root Cause Analysis (Occurance)

Why 1	Blow hole observed in bore of master cylinder.
Why 2	Impurities observed in material.
Why 3	material cleaning freq. was decided but not effective.
Why 4	
Why 5	
Root Cause (Occurance)	material cleaning freq. was decided but not effective.

Root Cause Analysis (Outflow)

Why 1	Blow hole observed in bore of master cylinder.
Why 2	New inspector was working on boroscope inspection.
Why 3	Understanding of defects was less in inspector.
Why 4	
Why 5	
Root Cause (Outflow)	Understanding of defects was less in inspector.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Material cleaning freq. revised i.e. thrice in a shift.	Mubarak	27/08/2024	27/08/2024	Completed

Outflow	Training given to inspector regarding understanding of defects.	Mahesh G.	27/08/2024	27/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	Na
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	NA 1034_Occurance_Before.pdf
Occurance (After)	Cleaning freq. decided thrice in a shift and updated in CP. 1034_Occurance_After.pdf
Outflow (Before)	NA 1034_Outflow_Before.png
Outflow (After)	Awareness given to inspector. 1034_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All master cylinders

12. Document Review

Documents	ControlPlan, InspCheckSheet
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	No blow hole found in 200 Nos lot.