QFR No - 8000896118

Defect Details

NC No.	8000896118
NC Date	17/10/2024
NC Submission Date	
Part No.	F2FQ00507B
Part Name	HOLDER HANDLE P/C-XF-1C1
Supplier Name & Code	100001-ANANT ENTERPRISES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	B/H INSIDE BORE-BLOW HOLE,CUT MARK

1. Problem Description

Defect Description	CUT MARK
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	70
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	anandkulkarni@anantgroup.co.in
Plant Head/CEO Email ID	pramodgosavi@anantgroup.co.in
MD Email ID	ashwinjoshi@anantgroup.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	0	0	205	160	365
Check Qty	0	0	0	203	152	355
NG Qty	0	0	0	2	8	10

Action taken on NG part

Scrap	10
Rework	0
Under Deviation	0

Containment Action
Under cut part segregated at our end and scraped separately for the same. ICA mark started back side on part surface for the confirm free from cut mark on part.

3. Process Flow

Process Flow Description
Raw material Inspection=Melting=Spectro=Metal transfer to holding furnace=Degassing=Die preparation=Casting=Riser cutting=Inspection=Buffing=Heat treatment=Inspection=Powder coating=Inspection=Machining=deburring=Pre-Washing=Final Inspection=Packing Dispatched

4. Process Details

Process / Operation	Casting=HT=PC=M/C
Outsource	No
Machine / Cell	Plat Form number 03
Machine / Cell No.	Machine Number 04

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled manpower	Skill matrix verified and found ok	O
Method	Buffing process	Buffing process done by manual, some part profile not matched during buffing	X
Material	Material not ok	Material grade check and found as per specification.	O
Machine	Machine condition not ok	Machine condition verified and PM done as per defined frequency	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	cut mark observed on part
Why 2	Cut mark observed on part due to buffing not done properly
Why 3	Buffing not done properly due to buffing process is manual
Why 4	Buffing process is manual due to some part profile not match process
Why 5	
Root Cause (Occurance)	Buffing process is manual due to some part profile not match in process

Root Cause Analysis (Outflow)

Why 1	Cut mark observed on part
Why 2	Cut mark part skipped by inspector
Why 3	Part skipped by inspector due to part not catch by inspector at final stage
Why 4	cut mark part not catch by inspector due to eyes sequence not followed
Why 5	Eyes sequence not followed due to operator negligence
Root Cause (Outflow)	Eyes sequence not followed due to operator negligence

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Q- alert displayed	Nisar	19/10/2024	19/10/2024	Completed
Outflow	Awareness training given to all Inspector regarding customer complaint.	Nisar A	20/10/2024	20/10/2024	Completed
Occurance	Q alert and defect matrix displayed	Nisar A.	19/10/2024	19/10/2024	Completed
Occurance	Start to five numbers part check in every hrs in buffing process.	Ambar	22/10/2024	22/10/2024	Completed
Occurance	Training has given to all buffing operator regarding customer complaint	Nisar A.	20/10/2024	20/10/2024	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	Q- alert display 1173_Occurance_Before.pdf
Occurance (After)	Training given to al regarding customer complaint 1173_Occurance_After.pdf
Outflow (Before)	Q alert displayed 1173_Outflow_Before.pdf
Outflow (After)	Awareness training given to al inspector regarding customer complaint 1173_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All holder and bracket

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	No Any

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok