



QUALITY ALERT

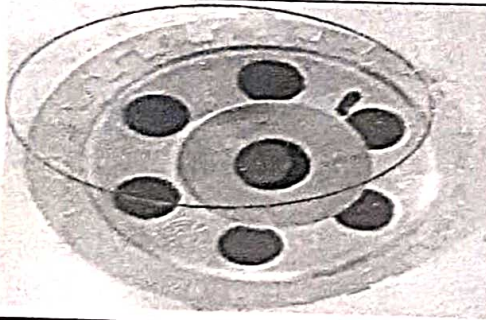
Customer	Customer Complaint No	Complaint Type	Date of Complaint
ETL-K226/1	MDCPL/FY22/03	Line Rejection	
Customer Location	Part Name	Qty Reported	13.06.2023
Aurangabad	HUB CLUTCH RE4S	1	
Complaint Reported By	Customer Part Number		Defective Part Batch Code
Anil Borkute	165FY01022/D		
Complaint Received By	ETL Part Number		April 2nd week material
L A Agnihotri			

Complaint Description :

Dimn24.5 ± 0.2 observed up to 23 mm (tapper machining)

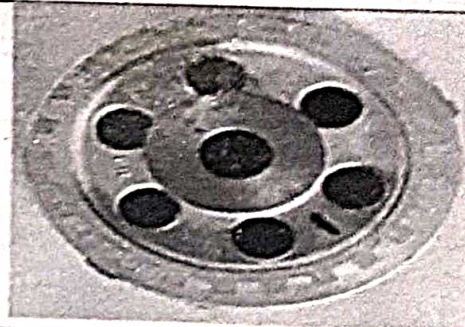
NOT OK PHOTO

Actual:- Heavy Damage in window of component due to resting is not proper at cnc stage (fetting not proper)



OK PHOTO

Specification:- Free from burr and damage in window of component resting proper at cnc stage (Fetting proper)



ICA :

1. Stock at customer end and inhouse is been 100% segregated

Prepared By: Miss.Palleen Jadhav
Approved By: Mr.Krishindas pandey



2A Identification Mark

Distribution List

WORK STATION	<input checked="" type="checkbox"/>	HOD MATL	<input type="checkbox"/>
CC	<input type="checkbox"/>	HOD PROCESS	<input type="checkbox"/>
HOD Prod	<input type="checkbox"/>	HOD AE	<input type="checkbox"/>
HOD QA	<input type="checkbox"/>	PLANT HEAD	<input type="checkbox"/>

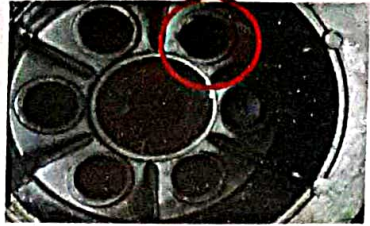



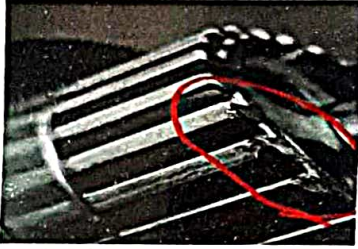





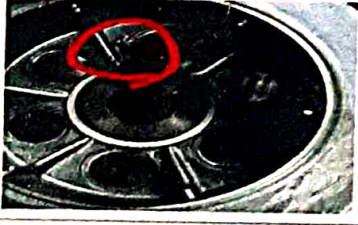



Photo after dot mark

Teeth damage in top face,

Note :- This document needs to be filled, controlled & finalized by Quality Engineer.
This document can be removed after 24Hr period of inclusion of Firewall at concerned workstation


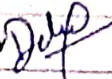

EYE SEQUENCE CHART FOR RE4S HUB Visual Checking

Model Name
Re4s Hub
Doc No. FM/QA/33
Rev No. 00
Date: 1 04 2023

Sr.No.	Critical "I" Check Point	Defect Sample Photo	Frequency	Inspection Method
1	6 Core hole chamfer should be done. (6 कोर होल चांफर केले आहे का ते Check करा.)		100% (१०० टक्के)	
2	No Casting Crack. (Casting क्रॅक आहे का ते Check करा.)		100% (१०० टक्के)	
3	No Damage Marks on Castings at any area/ Teeth. (कास्टिंगवर कोणत्याही भागात/दातांवर कोणतेही नुकसान चिन्ह नाहीत याची खात्री करा.)		100% (१०० टक्के)	
4	No reb broken. (रेब तुटलेली आहे का ते Check करा.)		100% (१०० टक्के)	
5	No Nonfilling on Claw / any other portion of casting. (कास्टिंगच्या इतर कोणत्याही भागावर कोणतेही नॉनफिलिंग नाही याची खात्री करा.)		100% (१०० टक्के)	
6	No Cold Shot in Spring pocket. (स्प्रिंग पॉकेटमध्ये कलॉल्ड शॉट नाही याची खात्री करा.)		100% (१०० टक्के)	
7	No heat check/Crack on casting. (कास्टिंगवर उष्णता तपासणी/क्रॅक नाही याची खात्री करा.)		100% (१०० टक्के)	

Note:- (टीप:-)
 1) Inspector Identification mark required on each part after inspection.
 (तपासणीनंतर प्रत्येक भागावर निरीक्षक ओळख चिन्ह आवश्यक आहे.)
 2) Calendar mark should update every month.
 (कॅलेंडर मार्क दर महिन्याला अपडेट करावे.)
 3) Cavitywise inspection to be done during Inprocess inspection.
 (प्रक्रिया तपासणी दरम्यान Cavitywise तपासणी करावी.)











Prepared By  Checked By  Approved By 

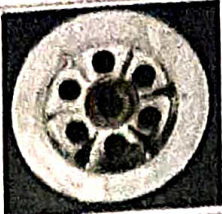


MADHURA DIE CAST PVT. LTD., D-168, FIVE STAR M.I.D.C. SHENDRA, AURANGABAD-431201.

Doc. No. WSPRCO11
 Rev.No. 0
 Rev.Date 26.10.2022
 Page No. 1 of 1

FETTLING PROCESS STANDARED FOR REAS - HUB CLUTCH(I)

Component Name	Process/Stage	Tool Used	Critical Fetting Point	View	Frequency	Inspection Method	Reaction Plan
REAS - HUB	Stage 1 (Gate removing & OD Smoothing)	Buffing	1. No extra material at gate area. (गेट Area वरती कोणतीही अतिरिक्त Material नाही पाहीजे.)		100% (१०० टक्के)	Visual 	To remove extra material & inspection. (अतिरिक्त Material काढून टाका आणि ते चेक करा.)
	Stage 2 (Provide chamfering at spring pocket)	Chamfering	Chamfering must present at 6 Hole area. (Spring pocket मध्ये chamfering असावे पाहीजे.)		100% (१०० टक्के)	Visual 	To provide chamfering. (6 Hole area chamfering करा आणि ते चेक करा.)
	Stage 3 (Removing Burr from spoket area)	Flat file / Round file / Punch	1. No burrflashes at oil slot area (Burrflash oil slot मध्ये नाही पाहीजे.)		100% (१०० टक्के)	Visual 	To remove OD flash. (घरंग काढून टाका आणि ते चेक करा.)
	Stage 4 (Removing Burr from oil hole)	Flat file	1. No burrflashes At Casting. (सरकस वरती नुत्र Burrflash नाही पाहीजे.)		100% (१०० टक्के)	Visual 	To remove burrflash & ID OD area. (Burrflash ID/OD Area मधून काढून टाका आणि ते चेक करा.)



Signature 

Prepared By

Approved By

Issued By

Control Status

Designation

PDC HOD

MR

Master Copy

Controlled Copy



MASTER SAMPLE

