

 <p>SLR metaliks Powered by Passion</p>	SLR Metaliks Limited QAD 8D-REPORT		Document No.: IMSR/QA/76	
			Rev No. / Date : 00/01.01.2020	
			Complaint No.:	SLRM/2024-25/03-12
			Date :	09.03.2025
		Issue Date:	27.03.2025	
Complaint Title :		Crack observed on component		
Manufacturing Plant :		SLR Metaliks Limited		
Customer :		M/s SSB Engineers, Alwar		
D1. Problem solving team:				
Team leader :		C M Walvekar, AGM- Quality Assurance.		
Team members :		Harikant Tiwari,Vikram,Neeraj		
D2. Material / Problem Description:				
Heat No.:		53926, 54217, 54218		
Grade :		16MnCr5, 20MnCr5		
Size :		60mm, 70mm dia		
Supply Condition :		As rolled		
Quantity Supplied :		-		
Complaint Location :		Alwar		
Customer Complaint :		Crack observed on component		
Analysis results:				
SLRM supplied as rolled material to M/s SSB Engineers(Alwar), pertaining to the Heat No.:53926, 54217, 54218, Grade: 16MnCr5, 20MnCr5, and Size: 60mm, 70mm dia.				
As per the non-conformity details given by the customer, cracks were observed in components during processing.				
SLRM representative attended the above quality issue at the customer end and witnessed the upset crack and collected samples for investigation.				
SLRM investigation & observations are as under:				
The defective samples which were received from the customer were analysed at our end. Spectro analysis report showed that chemical composition of the samples are matching to SLRM supplied heat no.53926, 54217, Grade: 16MnCr5, 20MnCr5. Defective sample analysed at our end and observed surface flaw in the sample. During upsetting forging some of cut blanks surface was opened. This is raw material defect. Hence the quality issue is acceptable. Necessary corrective measures will be taken as mentioned in point no. D5.				
Defect confirmed? (Yes / No)		Yes		
Repeated failure? (Yes / No)		No		
D3. Immediate containment action(s) (ICA):			Resp.	Deadline
Requested the customer to use the ok material			-	-
D4. Root Cause:				
1) Presence of discontinuities on input material (As cast material).				
2) Presence of deep patching marks on as cast products.				
D5. Corrective Actions:			Resp.	Deadline
1) Dressing of discontinuities on input material and proper leveling.			SLRM-QA	Immediate
2) Grinding of rough patched on input material.				
3) Apply anti-scaling compound to input material before rolling.				
4) Double MPI inspection route will be followed:				
1st MPI -> Grinding -> 2nd MPI -> if necessary, perform grinding.				
5) Training will be imparted to final inspection, MPI, Grinding operators.				
D6. Verification of Corrective Actions:				
Quality team will ensure the effectiveness of the corrective actions.			-	-
D7. Horizontal Deployment to avoid re-occurrence:			Resp.	Deadline
NA			NA	NA
D8. Any changes Required in IMS Documents:				
1.Process Flow Diagram(PFD)		No change		
2. Failure Mode Effective Analysis (FMEA)		No change		
3. Control plan(CP)		No change		
4. Procedures		No change		
5. Work Instruction(WI)		No change		
6. Any others		No change		
Congratulate your team:				8D Closed
QA team will be congratulated after implementation of CAPA successfully.				Prakash Angadi