

Defect Details

NC No.	7000903135
NC Date	17/03/2023
NC Submission Date	
Part No.	S2MX00112B
Part Name	STEEL BUSH
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	LENGTH UNDERSIZE-Length Undersize up to 0.5mm

1. Problem Description

Defect Description	Length observed up to 23.30mm against 24-0.20mm
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	10000
Is Defect Repeatative?	Yes
Defect Sketch / Photo	vhasrjzr11exzfzeuow2hrz.jpg

Supplier Communication Details

Quality Head Email ID	quality@mahavirind.co.in
Plant Head/CEO Email ID	production@mahavirind.co.in
MD Email ID	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	10000	0	0	3000	2000	15000
Check Qty	10000	0	0	3000	2000	15000
NG Qty	40	0	0	0	0	40

Action taken on NG part

Scrap	30
Rework	10
Under Deviation	0

Containment Action

All Finish Good Customer End and Godown Material Return call

3. Process Flow

Process Flow Description

1)RM Inward-2)store- 3)Parting-4)2nd side ID Chamfer-5) Plating -6) Final Inspection -7) Dispatch .

4. Process Details

Process / Operation	Parting
Outsource	Yes
Machine / Cell	Traub /Traub Cell
Machine / Cell No.	Traub No.2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Randomly Bend Pipe Mix with OK RM	2 pipe found Bend Out of 60 Pipes	X

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 no.s/hr

7. Root Cause Analysis (Occurance)

Why 1	Length Under Size
Why 2	During Traub parting process RM pipe was not Move
Why 3	Finger ok But Not Open on Time After part cutting
Why 4	RM Pipe Bend
Why 5	
Root Cause (Occurance)	RM PIPE BEND

Root Cause Analysis (Outflow)

Why 1	Length Under Size
Why 2	Defected piece mix with ok material During final inspection
Why 3	Inspector mistake
Why 4	During final inspection Defected part bag and ok FG bag kept one Location
Why 5	
Root Cause (Outflow)	Defected piece mix with ok material During final inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
	OCCURANCE- All Bend Pipe Segregation Before				

Occurance	machining, OUTFLOWS- Separate area Decide on Final Inspection Table.	Dispatch Engineer	31/03/2023	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection Table modification for NG Parts Red Box Provide and finish Good Regular Polybag
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	RM Pipe Bend 389_Occurance_Before.jpeg
Occurance (After)	All Suspected bend RM Pipe Material Segregation / 389_Occurance_After.jpeg
Outflow (Before)	During final inspection Defected part bag and ok FG bag kept one Location 389_Outflow_Before.jpeg
Outflow (After)	Inspection Table modification for NG Parts Red Box Provide and finish Good Regular Polybag 389_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Steel Bush

12. Document Review

Documents	PMCheckSheet, PFMEA, WISOP
Specify Other Document	Final Inspection QP

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	OK