QFR No - 7000920866

Defect Details

NC No.	7000920866
NC Date	09/06/2023
NC Submission Date	
Part No.	538FL00102
Part Name	PISTON NUT - WP
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	EXCESS MATERIAL-DO BURR

1. Problem Description

Defect Description	Burr found on hex
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	1889
Is Defect Repeatative?	No
Defect Sketch / Photo	2qwja5mj5mgg3izzjrxtdfil.jpg

Supplier Communication Details

Quality Head Email ID	quality@mahavirind.co.in
Plant Head/CEO Email ID	planthead@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	2400	0	0	600	0	3000
Check Qty	2400	0	0	600	0	3000
NG Qty	1889	0	0	0	0	1889

Action taken on NG part

Scrap	0
Rework	1889
Under Deviation	0

Containment Action
All Suspected Material Segregation at Customer End

3. Process Flow

Process Flow Description
Forging Finish Inward -Raw Material Store- CNC-1- CNC-2- Plating- Final Inspection - Packing - Dispatch -

4. Process Details

Process / Operation	CNC-1&2
Outsource	No
Machine / Cell	CNC-13
Machine / Cell No.	CNC section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Insert Corner Wear	Insert Run Than decide tool life	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	1005

7. Root Cause Analysis (Occurance)

Why 1	Burr found on hex
Why 2	Excess Burr Sticking at Across Corner Area
Why 3	During CNC process Across Corner Area Excess Material Not removed.
Why 4	
Why 5	
Root Cause (Occurance)	During CNC process Across Corner Area Excess Material Not removed.

Root Cause Analysis (Outflow)

Why 1	Burr found on hex
Why 2	During Sampling Burr effected Material Not Detected
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	During Sampling Burr effected Material Not Detected

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Deburring Process Add After Both CNC Operation	Plant Head	01/07/2023	03/07/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Visual Inspection Instead Of Sampling inspection.
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)	Before - After CNC Process Deburring not Done to Every Part Only Heavy excess Burr Part Deburring. 470_Occurance_Before.docx
Occurance (After)	100% Deburring Process Start Each Part after CNC Process 470_Occurance_After.docx
Outflow (Before)	Sampling Visual Inspection 470_Outflow_Before.docx
Outflow (After)	100% Visual Inspection Start Before Dispatch . 470_Outflow_After.docx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Spacer Tubes

12. Document Review

Documents	ControlPlan, PFMEA, ProcessFlowChart
Specify Other Document	Nil

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	no any issue observed after action submitted.