QFR No - 7001057011

Defect Details

NC No.	7001057011
NC Date	25/09/2024
NC Submission Date	
Part No.	S2BA00202B
Part Name	REBOUND DISC h8.5
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	RUSTY-Rusty

1. Problem Description

Defect Description	parts found rusty
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	635
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

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	635	0	0	0	0	635
Check Qty	635	0	0	0	0	635
NG Qty	635	0	0	0	0	635

Action taken on NG part

Scrap	0
Rework	635
Under Deviation	0

Containment Action
All Material segregation at Customer End

3. Process Flow

Process Flow Description
RM inward - store - CNC Machining -1 -CNC Machining -2- Final Inspection - Packing - Dispatch - Transport

4. Process Details

Process / Operation	CNC Machining - Final Stage
Outsource	Yes
Machine / Cell	CNC-9
Machine / Cell No.	CNC Section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Wrong Grade And other grade Material Use	Correct Grade Material use .	O
Tool	Wrong Rusty Removal Oil Apply .	Correctly apply rust removal oil, but the curing time is not specified, and pack the material.	X
Method	Wrong Cutting Oil Feed By Operator	No , Coolant Concentration Low as per Required (3~5%	X
Man	Unskilled operator	As per Skilled Matrix Operator is skilled	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Rusty
Why 2	Coolant Concentration Low
Why 3	Coolant Concentration Observed 2.5% on final Operation
Why 4	Concentration Not Check In early Morning
Why 5	
Root Cause (Occurance)	Coolant Concentration Observed 2.5% on final Operation

Root Cause Analysis (Outflow)

Why 1	Rusty
Why 2	Lightly Rusty Observed at inspection stage
Why 3	Rust Removal oil Apply And Without Curing Time Material pack.
Why 4	
Why 5	
Root Cause (Outflow)	Rust Removal oil Apply And Without Curing Time Material pack.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Work instructions and training for applying rust removal oil and curing time during finished material packing.	Quality Head	04/10/2024	03/10/2024	Completed
Occurance	Make schedule Coolant Concentration Monitoring sheet for CNC Machine.	Production Incharge.	04/10/2024	03/10/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Coolant Concentration Check in shift starting.
Inspection Method	Other
Other Inspection Method	100%
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Coolant Concentration Observed 2.5% on final Operation 1110_Occurance_Before.jpg
Occurance (After)	Make schedule Coolant Concentration Monitoring sheet for CNC Machine. 1110_Occurance_After.jpg
Outflow (Before)	Rust Removal oil Apply And Without Curing Time Material pack. 1110_Outflow_Before.docx
Outflow (After)	Work instructions and training for applying rust removal oil and curing time during finished material packing. 1110_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Machining Part

12. Document Review

Documents	PFMEA, WISOP
Specify Other Document	yes -Coolant Cont,

13. Effectiveness Of Action

Reviewed Quantity	400
Reason for submission	evidence of countermeasure before coolant concentration & also training record.