QFR No - 8000797659

Defect Details

NC No.	8000797659
NC Date	29/07/2022
NC Submission Date	
Part No.	520BZ00102
Part Name	CAP OIL LOCK-LML
Supplier Name & Code	100503-DIVYA INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-STEP MARK & ID UNDERSIZE

1. Problem Description

Defect Description	STEP IN BACK FACE & ID 14MM UNDERSIZED BY 0.5MM
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	351
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

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

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2106	0	0	702	0	2808
Check Qty	2106	0	0	702	0	2808
NG Qty	351	0	0	13	0	364

Action taken on NG part

Scrap	62
Rework	302
Under Deviation	0

Containment Action
All Material Segregation at Customer End

3. Process Flow

Process Flow Description
1)RM Inward- 2)store - 3)Traub facing/Main Bore Drilling 14.02/14.14/8.5Drill F8.5/ID Chamfer/OD Chamfer - 4)Bottom Chamfer.5)OD Grinding.6) Plating .7) Final Inspection .8) Dispatch

4. Process Details

Process / Operation	3)Traub facing/Main Bore Drilling 14.02/14.14/8.5D
Outsource	Yes
Machine / Cell	Traub Section
Machine / Cell No.	Traub No.2(A-25)

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	ID boring on traub Machine	During ID boring 14.02 Drill edges Line Marks Observed	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Line Marks at the ID of 14.02 Main Bore
Why 2	Main ID boring operation on Traub machine
Why 3	14.02 drill edges heavy Burr Sticked
Why 4	Drill Edges Fraction In at Part ID
Why 5	
Root Cause (Occurance)	Main Boring ID operation Process by wrong Method Machining

Root Cause Analysis (Outflow)

Why 1	Line Marks at the ID of 14.02 Main Bore
Why 2	Not Defect In Final Inspection
Why 3	Final Inspector Not aware about ID Line Marks
Why 4	
Why 5	
Root Cause (Outflow)	Final Inspector Not aware about ID Line Marks

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	ID Boring Process change Traub Machining To CNC Machining	Mr. Suresh Kapgate	12/08/2022	12/08/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Visual Inspection Instead Of 20Nos Samples
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	....

10. Evidance of Countermeasure

Occurance (Before)	Main boring Operation On Traub Machine 214_Occurance_Before.xlsx
Occurance (After)	Main Boring Operation Start on CNC machine 214_Occurance_After.xlsx
Outflow (Before)	Sampling Basis Visual Inspection 20nos Per Bin 214_Outflow_Before.docx
Outflow (After)	Main Bore ID 100% Visual inspection at Final Inspection stage. 214_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Cap Oil Locks

12. Document Review

Documents	ControlPlan, PFMEA, ProcessFlowChart
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	