QFR No - 8000808154

## Defect Details

| | |
|---|---|
| **NC No.** | 8000808154 |
| **NC Date** | 17/10/2022 |
| **NC Submission Date** | |
| **Part No.** | 550FA17433 |
| **Part Name** | FORK PIPE MACHINED |
| **Supplier Name & Code** | 100503-DIVYA INDUSTRIES |
| **ETL Plant** | 1116-ETL K-120 Suspension |
| **Defect Details** | NOT AS PER SPECIFICATION-THREADING,CLUCKING,LENGTH NOTOK |

## 1. Problem Description

| | |
|---|---|
| **Defect Description** | Dimensional NG concern:- During assembly operation fitment parameters, like threading, caulking ID, total length observed not ok. |
| **Detection Stage** | Inprocess |
| **Problem Severity** | Fitment |
| **NG Quantity** | 114 |
| **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** | 2600 | 0 | 0 | 0 | 0 | 2600 |
| **Check Qty** | 2600 | 0 | 0 | 0 | 0 | 2600 |
| **NG Qty** | 114 | 0 | 0 | 0 | 0 | 114 |

Action taken on NG part

| | |
|---|---|
| **Scrap** | 10 |
| **Rework** | 104 |
| **Under Deviation** | 0 |

| Containment Action |
|---|
| All material Segregation at Customer End |

## 3. Process Flow

| Process Flow Description |
|---|
| 1)RM pipe Cutting Inward- 2)Store- 3)CNC 1st Caulking Side Machining -4)CNC 2nd side Machining -5) F1.5mm Drilling --6) Final Inspection -7) Packing - Dispatch |

## 4. Process Details

| | |
|---|---|
| **Process / Operation** | 3)CNC 1st Caulking Side Machining |
| **Outsource** | No |
| **Machine / Cell** | Fork Pipe CNC machine Shop. |
| **Machine / Cell No.** | CNC-5 |

## 5. Problem Analysis

| Type | Possible Cause | Fact Verification | Jud |
|---|---|---|---|
| Material | Fork Pipe face Unclean / Depth Under Size By0.2 -0.5 | Length Under Size by 0.2-0.5 of Fork Pipe Raw Material | X |

## 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** | Caulking Depth Under size |
| **Why 2** | Caulking Side Face Unclean |
| **Why 3** | CNC-1st Side - Caulking Side Facing Not Proper as Require Length |
| **Why 4** | Raw Material Length Short |
| **Why 5** | |
| **Root Cause (Occurance)** | Raw Material Length Short |

## Root Cause Analysis (Outflow)

| | |
|---|---|
| **Why 1** | Caulking Depth Under size |
| **Why 2** | Face Unclean Defect Not Detect During Final Inspection |
| **Why 3** | Inspector Not Aware Of Face Unclean |
| **Why 4** | New Inspector |
| **Why 5** | |
| **Root Cause (Outflow)** | Inspector Not Aware Of Face Unclean |

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

| Type | Countermeasure Details | Responsibility | Target Date | Actual Date | Status |
|---|---|---|---|---|---|

| | | | | | |
|---|---|---|---|---|---|
| Outflow | 1)Raw material Length Short. 2)New Final Inspector. | Mr Gadekar And Mr. Suresh Kapgate | 20/10/2022 | 20/10/2022 | Completed |

## 9. Inspection Method After Customer Complaint

| | |
|---|---|
| **Change In Inspection System** | Yes |
| **Change Details** | 1) Defected Samples display at Final Inspection And Machine .2) OJT to Machine Operator & New Inspector. |
| **Inspection Method** | Sp. Gauge |
| **Other Inspection Method** | |
| **Check Point at Final Inspection** | Yes |
| **Checking Freq.** | 100% |
| **Sampling** | No |
| **Sample Size** | ... |

## 10. Evidance of Countermeasure

| | |
|---|---|
| **Occurance (Before)** | Caulking Side face Unclean / Caulking side Depth Under Size<br>289_Occurance_Before.jpeg |
| **Occurance (After)** | One Point Lesson Display / OJT to operators<br>289_Occurance_After.xlsx |
| **Outflow (Before)** | Raw Material Length Short form Source Area<br>289_Outflow_Before.jpeg |
| **Outflow (After)** | Ram material Inspection start<br>289_Outflow_After.xlsx |

## 11. Horizontal Deployment

| | |
|---|---|
| **Horizontal Deployment Required** | Yes |
| **Applicable Machine / Model / Plant** | All Types Fork Pipe |

## 12. Document Review

| | |
|---|---|
| **Documents** | ControlPlan, PFMEA, InspCheckSheet |
| **Specify Other Document** | Raw material Inward |

## 13. Effectiveness Of Action

| | |
|---|---|
| **Reviewed Quantity** | |
| **Reason for submission** | |