QFR No - 8000820733

Defect Details

NC No.	8000820733
NC Date	16/02/2023
NC Submission Date	
Part No.	520HL00202
Part Name	OIL LOCK COLLAR
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-TOTAL LENGTH UNDERSIZE BY 0.20 MM

1. Problem Description

Defect Description	Oil lock collar total length found undersize by 0.20 mm
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	62
Is Defect Repeatative?	No
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	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1200	0	0	1840	0	3040
Check Qty	1200	0	0	1840	0	3040
NG Qty	62	0	0	1	0	63

Action taken on NG part

Scrap	63
Rework	0
Under Deviation	0

Containment Action
All Material Segregation at Customer End

3. Process Flow

Process Flow Description
RM Inward- store- Parting - Bottom Chamfer-Semi finish Inward- OD Grinding Process- Plating - Final Inspection- Dispatch - Transport.

4. Process Details

Process / Operation	Parting -ID Chamfer 2X15°
Outsource	Yes
Machine / Cell	Traub Section
Machine / Cell No.	Traub No.03

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Machine Part Stopper Not Proper working	Part stopper Brazing crack	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	100%

7. Root Cause Analysis (Occurance)

Why 1	Length under size / over size
Why 2	Resting Stopper Not Proper Working On Traub machine during parting process
Why 3	Stopper Occurs Flexible During Raw material Pipe Resting on Stopper.
Why 4	Resting Stoper Found Crack As per Attached Photograph.
Why 5	
Root Cause (Occurance)	Stoper crack on traub machine during parting process.2

Root Cause Analysis (Outflow)

Why 1	Length under size / over size
Why 2	Defective material not detect in sampling on final inspection stage During material dispatch
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Defective material not detect in sampling on final inspection stage During material dispatch

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Occurance- New stopper arrange on traub machine in place of old Crack stopper. Detection-New Gauge (OD AND LENGTH)Provide On Final Inspection Stage.	Mr. Pralhad Bhawar / Mr.Suresh Kapgate.	26/03/2023	26/03/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	New Combine Gauge (OD And Length)Provide On Final Inspection Stage. and Separate Snap Gauge.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Stopper Crack Point was Not Add in Daily PM Check sheet. 370_Occurance_Before.xlsx
Occurance (After)	Daily PM Check sheet Stopper Crack Point Add. 370_Occurance_After.xlsx
Outflow (Before)	Sampling Purpose Snap Gauge Use 370_Outflow_Before.xlsx
Outflow (After)	100% OD and Length Purpose Combine gauge Use. 370_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Oil Lock Collar Models

12. Document Review

Documents	ControlPlan, PMCheckSheet, PFMEA
Specify Other Document	OJT

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	Verified next 3 lot and found ok