

Defect Details

NC No.	8000827286
NC Date	24/04/2023
NC Submission Date	
Part No.	520HL00202
Part Name	OIL LOCK COLLAR
Supplier Name & Code	100097-MAHAVIR INDUSTRIES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	LENGTH UNDERSIZE-TOTAL LENGHT LESS

1. Problem Description

Defect Description	Oil lock collar total length less issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	10
Is Defect Repeatative?	No
Defect Sketch / Photo	e01cj5hc5pkgorczc3ywsn10.xlsx

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	3000	0	0	1800	0	4800
Check Qty	3000	0	0	0	0	3000
NG Qty	10	0	0	0	0	10

Action taken on NG part

Scrap	10
Rework	0
Under Deviation	0

Containment Action

All material Customer End and Mahavir Ind. RFD Material verified.

3. Process Flow

Process Flow Description

RM Inward- store- Traub parting- OD Grinding - Plating - Final Inspection- Packing -Transport

4. Process Details

Process / Operation	Traub parting
Outsource	Yes
Machine / Cell	Traub Cutting
Machine / Cell No.	Traub No.2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Bend Pipe	Bend Pipe not Movement as per Required Length due to Balance Weight Improper.	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Length Under Size
Why 2	Bend Pipe Not movement during the parting Process on Traub machine
Why 3	Weight Balancing Not enough.
Why 4	
Why 5	
Root Cause (Occurance)	Weight Balancing Not enough.

Root Cause Analysis (Outflow)

Why 1	Length Under Size
Why 2	Defected material skipped by Inspector During Final inspection
Why 3	Final Inspection sampling frequency low
Why 4	
Why 5	
Root Cause (Outflow)	Final Inspection sampling frequency low

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Required Balancing weight Increase for bend pipe movement.	Mr.Suresh Kapgate/ Mr. Pralhad Bhawar	27/04/2023	Pending
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1) Sampling Size Increase .2) Length Gauge Provide On Traub Machine .
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	Parting Pipe Not proper movement On Traub Due to Weight Balancing Improper 424_Occurance_Before.xlsx
Occurance (After)	As per Required Balancing Weight Increase for bend pipe Parting 424_Occurance_After.xlsx
Outflow (Before)	Length gauge not available on Traub Machine. 424_Outflow_Before.xlsx
Outflow (After)	Length gauge Provide On Parting Process Traub Machine 424_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	For All Oil lock collars Weight Balancer Increase

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	