

## Defect Details

<b>NC No.</b>	8000827791
<b>NC Date</b>	28/04/2023
<b>NC Submission Date</b>	
<b>Part No.</b>	F2PH00902B
<b>Part Name</b>	VALVE RETAINER (C101B)
<b>Supplier Name &amp; Code</b>	101255-MAHAVIR INDUSTRIES
<b>ETL Plant</b>	1146-ETL Suspension Narasapura
<b>Defect Details</b>	RUSTY-RUST ISSUE

## 1. Problem Description

<b>Defect Description</b>	valve retainer rust issue
<b>Detection Stage</b>	Receipt
<b>Problem Severity</b>	Aesthetic
<b>NG Quantity</b>	1000
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	<a href="#">hu2g3xnwwdoxzi2mq5cqmlnm.jpg</a>

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality@mahavirind.co.in
<b>Plant Head/CEO Email ID</b>	production@mahavirind.co.in
<b>MD Email ID</b>	

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	6000	6000	0	0	0	12000
<b>Check Qty</b>	6000	6000	0	0	0	12000
<b>NG Qty</b>	1000	0	0	0	0	1000

## Action taken on NG part

<b>Scrap</b>	1000
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

All Material Check at the Customer End and Warehouse End.

## 3. Process Flow

### Process Flow Description

RM inward - store - Parting - Semi finish Inward - CNC ( Counter ID Machining ) - OD Grinding- Plating - Final Inspection - Packing - Dispatch - Transport-warehouse- Customer Received

### 4. Process Details

<b>Process / Operation</b>	Warehouse Loading - Unloading Handling Problem
<b>Outsource</b>	No
<b>Machine / Cell</b>	Narsapura Warehouse
<b>Machine / Cell No.</b>	Narsapura Warehouse

### 5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
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### 6. Inspection Method Analysis (Current)

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

### 7. Root Cause Analysis (Occurance)

<b>Why 1</b>	Rusty
<b>Why 2</b>	Finish Good Material Wet at warehouse
<b>Why 3</b>	Finish Good Lying On Shop floor
<b>Why 4</b>	Packing Bag Torn of finish good
<b>Why 5</b>	Improper Material Handling
<b>Root Cause (Occurance)</b>	Packing Bag Torn of finish good

### Root Cause Analysis (Outflow)

<b>Why 1</b>	Rusty
<b>Why 2</b>	Finish Good Material More No. of days lying at transport Godown
<b>Why 3</b>	Inform To godown person
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	Finish Good Material More No. of days lying at transport Godown

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	1)Improper Material Handling .2)Finish Good Material More No. of days lying at transport Godown	Mahavir QA	10/05/2023	10/05/2023	Completed
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## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	1)Packing as per Customer Standards. 2) HDPE white, Heavy thickness and clean Gunny bags use for outer coating packing.
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Packing Visual Obs
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100

## 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	1)Finish Good Packing Bag Torn at warehouse during Material Handling . 2)Low Thickness Poly Bag. <a href="#">443_Occurance_Before.xlsx</a>
<b>Occurance (After)</b>	1)Inner poly bag thickness increases up to 400 gauge Instead of 300 Gauge for Tearing problems avoid Suitable to Material Handling. 2)HDPE white , Heavy thickness and clean Gunny bags use for outer coating packing. <a href="#">443_Occurance_After.xlsx</a>
<b>Outflow (Before)</b>	Finish Good Material More No. of days lying at transport godown <a href="#">443_Outflow_Before.jpg</a>
<b>Outflow (After)</b>	As per the attached packing standard <a href="#">443_Outflow_After.xlsx</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	Applicable all Narsapur-supplied Parts

## 12. Document Review

<b>Documents</b>	PackingStd
<b>Specify Other Document</b>	No

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	1000
<b>Reason for submission</b>	Reviewed 1000 no`s found ok