QFR No - 8000832050

Defect Details

NC No.	8000832050
NC Date	08/06/2023
NC Submission Date	
Part No.	F2BZ05712B
Part Name	CAP OIL LOCK - J1D FF (10mm taper)
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-PARALLISUM FOUND NOT OK.

1. Problem Description

Defect Description	RE-J1A Cap oil lock parallelism found not ok Observed 0.20 mm , required - 0.020 mm
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	95
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	300	0	0	0	0	300
Check Qty	300	0	0	0	0	300
NG Qty	95	0	0	0	0	95

Action taken on NG part

Scrap	0
Rework	95
Under Deviation	0

Containment Action
All Suspected Material Verify at the Customer End.

3. Process Flow

Process Flow Description
RM Inward - Store- Parting-OD Grinding- CNC Turning - Plating - Final Inspection - Dispatch

4. Process Details

Process / Operation	CNC TURNING
Outsource	Yes
Machine / Cell	CNC Section
Machine / Cell No.	CNC-2/ CNC

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Parellity out after CNC machining	Heavy Burr Sticked with CNC Jaw	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10pcs/Hr

7. Root Cause Analysis (Occurance)

Why 1	Pararellity Not OK
Why 2	During CNC machining job Out
Why 3	Heavy Burr Stick With CNC Jaw
Why 4	Not Air Flushing By Operator
Why 5	
Root Cause (Occurance)	1)Heavy Burr Stick With CNC Jaw. 2)Not Air Flushing By Operator

Root Cause Analysis (Outflow)

Why 1	Pararellity Not OK
Why 2	Paralelity Over Than Required
Why 3	Not detected During Simple Step Gauge Inspection
Why 4	Variable Gauge Not Available For Correction
Why 5	
Root Cause (Outflow)	Variable Gauge Not Available For Correction

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Air Flushing During Each and every part Feeding .	Mr. Pralhad Bhawar	24/06/2023	26/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Plunger Dial Provide on Machine
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20nos

10. Evidance of Countermeasure

Occurance (Before)	Air Gun Facility not Available 467_Occurance_Before.jpeg
Occurance (After)	100% Air Gun Facility Provide On Machinie . 467_Occurance_After.jpeg
Outflow (Before)	Step Gauge For Parellelity Inspection 467_Outflow_Before.jpeg
Outflow (After)	Dial Gauge Provide On Machine . 467_Outflow_After.jpeg

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	YES

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	