

## Defect Details

<b>NC No.</b>	8000832550
<b>NC Date</b>	12/06/2023
<b>NC Submission Date</b>	
<b>Part No.</b>	F2MB31102B
<b>Part Name</b>	SPACER TUBE - NS200
<b>Supplier Name &amp; Code</b>	101255-MAHAVIR INDUSTRIES
<b>ETL Plant</b>	1118-ETL E-92,93 Suspension
<b>Defect Details</b>	LENGTH UNDERSIZE-LINGTH UINDR SIZE OVER SIZE

## 1. Problem Description

<b>Defect Description</b>	Total length found oversize and undersize
<b>Detection Stage</b>	Inprocess
<b>Problem Severity</b>	Fitment
<b>NG Quantity</b>	140
<b>Is Defect Repeatative?</b>	Yes
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality@mahavirind.co.in
<b>Plant Head/CEO Email ID</b>	planthead@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	1500	13500
<b>Check Qty</b>	6000	6000	0	0	1500	13500
<b>NG Qty</b>	2	0	0	0	0	2

## Action taken on NG part

<b>Scrap</b>	2
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

All Material Segregation at Customer End .

## 3. Process Flow

**Process Flow Description**

RM Inward - Store - Traub Parting - 2nd Side ID Chamfer- Final Inspection - Antirust Oil Apply- Dispatch

**4. Process Details**

<b>Process / Operation</b>	Traub Parting
<b>Outsource</b>	Yes
<b>Machine / Cell</b>	Traub No.6
<b>Machine / Cell No.</b>	TRB No.6./Traub

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Method	Defected Parts Mix with OK Parts	During Final Inspection Defected Parts mix with OK Material .	O

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Gauge
<b>Other Inspection Method</b>	
<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>	Length Under Size
<b>Why 2</b>	During Traub Parting End Piece Mix with the OK Parts
<b>Why 3</b>	During Parting Process Pipe Lost End Piece Not Separate Kept By Operator
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Occurance)</b>	During Parting Process Pipe Lost End Piece Not Separate Kept By Operator.

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	Length Under Size
<b>Why 2</b>	During Final Inspection Defected Part Detect But Final Inspector Not Kept separate
<b>Why 3</b>	Not Provision for Defected parts Keeping on Final Inspection stage
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	Not Provision for Defected parts Keeping on Final Inspection stage

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Outflow	Separate lock and Key Red Box For Defected Parts keeping On Final Inspection Stage	Mr. Suresh Kabbage	10/06/2023	12/06/2023	Completed
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## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	100% Length Inspection Start Instead of Sampling
<b>Inspection Method</b>	Gauge
<b>Other Inspection Method</b>	
<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>	End Pieces Verification by Digital Vernier caliper. <a href="#">475_Occurance_Before.jpeg</a>
<b>Occurance (After)</b>	1)Sampling Basis Hourly 20Nos Length Verification On Parting Machine.2)End Piece <a href="#">475_Occurance_After.jpeg</a>
<b>Outflow (Before)</b>	A sampling at Final Inspection <a href="#">475_Outflow_Before.jpeg</a>
<b>Outflow (After)</b>	100 % Checking On Final Inspection Stage. <a href="#">475_Outflow_After.jpeg</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	1)All Spacer Tube 100% length Verification On Machine . 2) Length Gauge Provide on Machine .

## 12. Document Review

<b>Documents</b>	ControlPlan, WISOP
<b>Specify Other Document</b>	No

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	1000
<b>Reason for submission</b>	No any issue raised after action submitted.