QFR No - 8000833962

Defect Details

NC No.	8000833962
NC Date	23/06/2023
NC Submission Date	
Part No.	530PA00502
Part Name	TUBE RING
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	CHAMFER NOT DONE-ONE SIDE WITHOUT CHAMFER

1. Problem Description

Defect Description	CHAMFER NOT DONE
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	7
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@mahavirind.co.in
Plant Head/CEO Email ID	Planthead@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	1244	0	0	0	0	1244
Check Qty	1244	0	0	0	0	1244
NG Qty	7	0	0	0	0	7

Action taken on NG part

Scrap	7
Rework	0
Under Deviation	0

Containment Action
All Suspected material Segregation At Customer End

3. Process Flow

Process Flow Description
1)RM Inward at k-11 - 2)store at Supplier - 3)Parting - 4) Semifinish Inward- 5)CNC 1st - 6)CNC 2nd- 7)OD Grinding - 8)Final Inspection - 9)Antirust Oil Apply - 10)Store - 11)Dispatch

4. Process Details

Process / Operation	Final Operation
Outsource	Yes
Machine / Cell	CNC Section
Machine / Cell No.	CNC-8

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Individual Both Side Chamfer Not Check By Operatior	Machine Operator Skilled But sample Basis Inspection	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	OD /ID Chamfer One side operation Missing
Why 2	By Mistake Defected Part Mix with ok Parts.
Why 3	Sample Basis Part Inspection By Machine Operator
Why 4	
Why 5	
Root Cause (Occurance)	Sample Basis Visual Inspection By Machine Operator

Root Cause Analysis (Outflow)

Why 1	OD /ID Chamfer One side operation Missing
Why 2	OD/ID Visual Inspection 100% but Wrong & Very Poor as attached Photograph.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Part Collect in Hand Flood and OD/ID Visual Inspection 100% but Detective Part not Detect.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	Visual Inspection Method Change	Quality Head	25/06/2023	26/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Individual Part Inspection For OD and ID At Final Stage and CNC Machine Process
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)	Sampling Basis Visual Inspection For OD /ID Chamfer 494_Occurance_Before.jpeg
Occurance (After)	During Machining Process 100% ID Inspection Start that Time Defected Material Detect To Operator 494_Occurance_After.jpeg
Outflow (Before)	One Time 4 or 5 Parts Collect at flood For Visual Inspectio and Kept In Dispatch Poly Bag as per Attached Photograph. 494_Outflow_Before.jpeg
Outflow (After)	1)OK sample Display on Final Inspection Table .2)Separate Part Inspection Method Start On final Inspection Stage 494_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Tube Rings

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	Nil

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	