QFR No - 8000834704

Defect Details

NC No.	8000834704
NC Date	27/06/2023
NC Submission Date	
Part No.	550FA17433
Part Name	FORK PIPE MACHINED
Supplier Name & Code	100503-DIVYA INDUSTRIES
ETL Plant	1116-ETL K-120 Suspension
Defect Details	NOT AS PER SPECIFICATION-CLUCKING,THREADING,LENGTH NOT OK

1. Problem Description

Defect Description	Dimensional NG concern observed.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	148
Is Defect Repeatative?	Yes
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	rajesh@mahavirind.co.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1600	0	0	0	0	1600
Check Qty	1600	0	0	0	0	1600
NG Qty	148	0	0	0	0	148

Action taken on NG part

Scrap	0
Rework	148
Under Deviation	0

Containment Action
All Suspected material Checking At Customer End

3. Process Flow

Process Flow Description
Raw material Inward- Store- CNC Machining Coulking Side- CNC Machining Threading Side - 1.5 mm Cross Drill - Final Inspection - Packing - Rusty Oil Apply - Dispatch - Transport .

4. Process Details

Process / Operation	CNC Machining - Coulking Side.
Outsource	No
Machine / Cell	CNC No.2
Machine / Cell No.	Fork Pipe CNC Sect.

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Coulking Under Size Coolant Flow Not proper	Coolant Pipe Accessory Not Available On Machine	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	Coulking Side ID under size
Why 2	Insert Wear
Why 3	Not Proper Coolant Flow
Why 4	Not proper Coolant Pipe Arrangement .
Why 5	
Root Cause (Occurance)	Not proper Coolant Pipe Arrangement.

Root Cause Analysis (Outflow)

Why 1	Coulking Side ID under size
Why 2	during final inspection defected part not detect
Why 3	Randombly Defect
Why 4	
Why 5	
Root Cause (Outflow)	During final inspection defected part not detect.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	All Machine Coolant Pipe Replace And Flexible Pipe provide	Mantenanace Head and production Head	05/07/2023	08/07/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% ID Inspection
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)	Not proper Coolant Pipe Arrangemen 499_Occurance_Before.docx
Occurance (After)	All Machine Coolant Pipe Replace And Flexible Pipe provide 499_Occurance_After.docx
Outflow (Before)	1) Go Gauge Not Proper suit in ID .2)Coulking ID Inspection Frequency was 5Nos / Hr. 499_Outflow_Before.docx
Outflow (After)	1) Go gauge Proper Suit Coulking ID .2)Inspection Frequency Change Now 20nos/hr 499_Outflow_After.docx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Fork Pipe Coolant Pipe Replace

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	10
Reason for submission	Corrective action parts submission.