

Defect Details

NC No.	8000835556
NC Date	06/07/2023
NC Submission Date	
Part No.	S2MX01312B
Part Name	STEEL BUSH (MFeZn8-S)
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	EXCESS MATERIAL-SHARP EDGES ON FASE AND INCOMPETED M/C

1. Problem Description

Defect Description	Sharp Edges on face & parting operation incomplete
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	24
Is Defect Repeatative?	No
Defect Sketch / Photo	I12lv4vlupzt0yklncgm1hwb.png

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	5000	5000	0	0	0	10000
Check Qty	5000	5000	0	0	0	10000
NG Qty	24	0	0	0	0	24

Action taken on NG part

Scrap	24
Rework	0
Under Deviation	0

Containment Action

All Suspected Material Segregation at Customer End

3. Process Flow

Process Flow Description

Raw Material Inward - Store-Parting On Traub- Second Side Chamfer - Plating- Final Inspection - Dispatch

4. Process Details

Process / Operation	Second Side Chamfer
Outsource	Yes
Machine / Cell	Drilling Machine-2
Machine / Cell No.	Chamfer Secton

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Manual 2nd side Chamfer Process On Drill Machine	Defected Parts Skipped During Manual Chamfer process.	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	EXCESS MATERIAL-SHARP EDGES ON FASE AND INCOMPETED M/C
Why 2	On Chamfering Machine 2nd Operation - Randomly part skipped by operator .
Why 3	During Manual Chamfer process operational part catch by plier on Drilling Machine.
Why 4	
Why 5	
Root Cause (Occurance)	During Manual Chamfer process operational part catch by plier on Drilling Machine.

Root Cause Analysis (Outflow)

Why 1	EXCESS MATERIAL-SHARP EDGES ON FASE AND INCOMPETED M/C
Why 2	By Mistake Defected parts Mix By Final Inspector .
Why 3	Sampling Base Final Inspection For Visual Inspection
Why 4	
Why 5	
Root Cause (Outflow)	Sampling Base Final Inspection For Visual Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Chamfer Process Change	Plant Head	08/07/2023	08/07/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Visual Inspection Start Before Dispatch
Inspection Method	Other
Other Inspection Method	100% Visual Insp.
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	During 2nd Chamfer operation part Mounting by plier 505_Occurance_Before.docx
Occurance (After)	During 2nd Chamfer operation Part Mounting in Three Jaw Chuck 505_Occurance_After.docx
Outflow (Before)	Before Sampling Base Visual Inspection 505_Outflow_Before.docx
Outflow (After)	Now 100% Visual at Final inspection Stage. 505_Outflow_After.docx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Steel Bush

12. Document Review

Documents	ControlPlan, PFMEA, ProcessFlowChart
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	ok