QFR No - 8000845684

Defect Details

NC No.	8000845684
NC Date	20/09/2023
NC Submission Date	
Part No.	S2MX00112B
Part Name	STEEL BUSH
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	LENGTH OVERSIZE-LENGTH OVERSIZE

1. Problem Description

Defect Description	STEEL BUSH (S2MX00112O) TOTAL LENGTH OVERSIZE FOUND UPTO 24.06 MM AGINST 24 -0.2 MM
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	8
Is Defect Repeatative?	No
Defect Sketch / Photo	4nndp3kisfc1ecbi3e5kchrz.jpg

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	5600	0	0	0	6000	11600
Check Qty	5600	0	0	0	6000	11600
NG Qty	1906	0	0	0	0	1906

Action taken on NG part

Scrap	0
Rework	0
Under Deviation	1906

Containment Action
All Suspected Material segregation At Customer End .

3. Process Flow

Process Flow Description
RM Inward - Store - Traub Parting- Inward -Plating- Plating Mate.Inward- Final Inspection - packing - Dispatch

4. Process Details

Process / Operation	Traub Parting
Outsource	Yes
Machine / Cell	Traub Machine
Machine / Cell No.	Traub Section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Stopper Lightly move During parting Pipe Rest.	Physically Check-Stopper Lightly Losse	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	TOTAL LENGTH OVERSIZE FOUND UPTO 24.06 MM AGINST 24 -0.2 MM
Why 2	Pipe Rest Stopper Not Proper Working
Why 3	Pipe Rest Stopper Lightly loose.
Why 4	
Why 5	
Root Cause (Occurance)	Pipe Rest Stopper Lightly loose.

Root Cause Analysis (Outflow)

Why 1	TOTAL LENGTH OVERSIZE FOUND UPTO 24.06 MM AGINST 24 -0.2 MM
Why 2	During Final Inspection part Not proper Checking
Why 3	During Final Inspection Part tight Part Inserting In Checking Height Gauge.
Why 4	
Why 5	
Root Cause (Outflow)	During Final Inspection Part tight Part Inserting In Checking Height Gauge.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Stopper Adjust as specification	Mahadev Bhawar	22/09/2023	22/09/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Height Reduce By 0.02 mm of Height Gauge.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	On Traub Machine Pipe Resting stopper Lightly Loose 553_Occurance_Before.pptx
Occurance (After)	On Traub Machine Pipe Resting stopper Adjust As per Required Specification 553_Occurance_After.pptx
Outflow (Before)	Part forcely insert in height gauge at Final Stage 553_Outflow_Before.pptx
Outflow (After)	Height gauge Size Reduce By 0.02mm Than Required Size 24.0(Now 23.98mm) 553_Outflow_After.pptx

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok