

Defect Details

NC No.	8000851792
NC Date	10/11/2023
NC Submission Date	
Part No.	520HL00102
Part Name	OIL LOCK COLLAR K60
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-TOTAL LENGTH UNDERSIZE

1. Problem Description

Defect Description	Total Length undersize
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	8
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@mahavir.in.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	1000	0	0	1200	0	2200
Check Qty	1000	0	0	1200	0	2200
NG Qty	8	0	0	0	0	8

Action taken on NG part

Scrap	8
Rework	0
Under Deviation	0

Containment Action

All suspected finish good material segregation at customer end

3. Process Flow

Process Flow Description

Raw material Inward - store - Traub (Final Length+ ID Chamfer+ OD Groove)- Back Side Chamfer - Cross Drilling - Inward Inspection- OD Grinding - Zinc Plating- Final Inspection - Packing - Dispatch

4. Process Details

Process / Operation	Traub -Final Length
Outsource	Yes
Machine / Cell	Traub Machine-03
Machine / Cell No.	Traub Section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Bend Pipe /Job Pusher Not Proper Working	Weight balance Not Sufficient for Bend Pipe Push	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 UNDERSIZE
Why 2	Parting Pipe not Rest to as per Required Length job stopper.
Why 3	Parting Pipe Not Push By Pusher Due to Weight balancer Weight Low .
Why 4	Weight Balancer Not Sufficient For Bend Pipe Push.
Why 5	
Root Cause (Occurance)	Weight Balancer Not Sufficient For Bend Pipe Push.

Root Cause Analysis (Outflow)

Why 1	TOTAL LENGTH UNDERSIZE
Why 2	During Final Inspection Length Under Size Part Not Deduct
Why 3	Sampling Frequency Low
Why 4	
Why 5	
Root Cause (Outflow)	Sampling Frequency Low

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Weight Balancer Not Sufficient For Bend Pipe Push.	Mr. Pralhad Bhawar	13/11/2023	14/11/2023	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% at Final stage and Ghoda gauge Provide On Traub Machine .
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)	Weight Balancer Not Sufficient before Weight Was 4 Kg 597_Occurance_Before.pptx
Occurance (After)	Weight Balancer Weight Increase -Now 6Kg For Regular Pipe Or Bend Pipe Pushing Purpose. 597_Occurance_After.pptx
Outflow (Before)	Ghoda Gauge Not Available On Traub Machine . 597_Outflow_Before.pptx
Outflow (After)	Ghoda Gauge Provide On Traub Machine. 597_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Oil Lock Coller

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	