

Defect Details

NC No.	8000862065
NC Date	07/02/2024
NC Submission Date	
Part No.	F2BZ05712B
Part Name	CAP OIL LOCK - J1D FF (10mm taper)
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-PARELLELISM MORE

1. Problem Description

Defect Description	Parallelism more
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	27
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	

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2500	0	0	1580	0	4080
Check Qty	2500	0	0	1580	0	4080
NG Qty	27	0	0	2	0	29

Action taken on NG part

Scrap	29
Rework	0
Under Deviation	0

Containment Action

All Stages +customer End All suspected Finish Good material Verified

3. Process Flow

Process Flow Description

R/M Inward - R/M Store- Traub parting (10.5 ID Hole - CNC Taper Turning/ ID Boring - Bottom Side Chamfer- OD Grinding- Rust preventive washing - Final Inspection - Packing- Dispatch.

4. Process Details

Process / Operation	CNC Taper Turning/ ID Boring
Outsource	No
Machine / Cell	CNC-2
Machine / Cell No.	CNC SECTION

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Heavy Burr Sticked With CNC Chuck Jaw	Air Flushing Arrangement not available on CNC Machine.	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Parallelism Not OK
Why 2	Job Not proper clam Feed at CNC Jaw
Why 3	Heavy Burr Sticked With jaw
Why 4	Air Flushing Arrangement not available on machine.
Why 5	
Root Cause (Occurance)	Heavy Burr Sticked With jaw and Air Flushing Arrangement not available on machine..

Root Cause Analysis (Outflow)

Why 1	Parallelism Not OK
Why 2	Parallelism Parameter Not check 100 % on machine
Why 3	Parallelism parameter checking instrument not available
Why 4	
Why 5	
Root Cause (Outflow)	Parallelism parameter checking instrument not available

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Air Flushing Arrangement not available on machine.	Maintenance Head / Production Head/Quality Head	12/02/2024	12/02/2024	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	New Dial stand arrange on CNC machine
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	Before Air Flushing Arrangement Not Available on CNC Machine for CNC Jaw Loose Burr Remove after Process Part Unload 659_Occurance_Before.pptx
Occurance (After)	Air Flushing Arrangement on CNC Machine for 100% CNC Jaw Loose Burr Remove after Process Part Unload and then New Part Load for Machining Process. 659_Occurance_After.pptx
Outflow (Before)	Before Dial Stand not Available on CNC machine for 100% parallelism specification Inspection 659_Outflow_Before.pptx
Outflow (After)	Dial Stand Provide on CNC machine for 100% parallelism speciation Inspection . 659_Outflow_After.pptx

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	286
Reason for submission	Found ok