QFR No - 8000863226

Defect Details

NC No.	8000863226
NC Date	16/02/2024
NC Submission Date	
Part No.	S2JL05733B
Part Name	PISTON ROD BOTH SIDE M/C _MY 18
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	DIMETER UNDERSIZE-5.5-0.1 ID IUNDER SIZE

1. Problem Description

Defect Description	Piston rod ID 5.5-01 found Under size
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	26
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	4200	0	0	1200	600	6000
Check Qty	4200	0	0	1200	600	6000
NG Qty	27	0	0	3	0	30

Action taken on NG part

Scrap	27
Rework	3
Under Deviation	0

Containment Action
All Suspected material verification at customer end

3. Process Flow

Process Flow Description
R/M Received- R/M Inward- band saw parting - straightening - 1st side chamfer-2nd side chamfer- 5mm Drilling-rough grinding- CNC-1st (Mounting)-CNC -2nd (Pist.side)- Cross hole Drilling- Cross Hole Chafer- IDF5.4 (1.4Cross hole) Burr Deburring - Final Inspection - Packing- Dispatch.

4. Process Details

Process / Operation	IDF5.4 (1.4Cross hole) Burr Deburring
Outsource	Yes
Machine / Cell	Drilling machine-1
Machine / Cell No.	Drilling Section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Hard burr At Main ID5.4 Hole of Cross Hole 1.4	Cross Hole Hard burr Remove by machine stop condition on Drilling 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	Main ID 5.4mm under size
Why 2	Heavy burr occurred at main id During cross hole 1.4mm Drilling Process.
Why 3	Occurred Burr Remove By 5.4 Reamer as Machine standing condition.
Why 4	
Why 5	
Root Cause (Occurance)	Occurred Burr Remove By 5.4 Reamer as Machine standing condition.

Root Cause Analysis (Outflow)

Why 1	Main ID 5.4mm under size
Why 2	Sampling basis ID parameters verification By PPG After burr remove process on Drilling Machine.
Why 3	Gauge Not Available on ID 5.4 Main hole (Cross Hole) Deburring Process Stage.
Why 4	
Why 5	
Root Cause (Outflow)	Gauge Not Available on ID 5.4 Main hole (Cross Hole) Deburring Process Stage.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Occurred Burr Deburring By 5.4 Reamer as Machine Running condition.	Line quality Incharge	17/02/2024	22/02/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Main ID Inspection By New PPG on Deburring Stage.
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)	Deburring Process Machine Stand Condition 680_Occurance_Before.pptx
Occurance (After)	Deburring Process Machine Running Condition 680_Occurance_After.pptx
Outflow (Before)	1)Sampling Basis ID inspection .2) PPG not available on deburring machine . 680_Outflow_Before.pptx
Outflow (After)	1)100% ID Inspection On Deburring Process. 2) PPG Arrange On Deburring Machine. 680_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Hallow Piston Rod

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	1200
Reason for submission	no any issue observed after action taken.