QFR No - 8000868408

Defect Details

NC No.	8000868408
NC Date	22/03/2024
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	42
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	3500	0	0	1750	0	5250
Check Qty	3500	0	0	1750	0	5250
NG Qty	42	0	0	5	0	47

Action taken on NG part

Scrap	47
Rework	0
Under Deviation	0

Containment Action
All suspected FG Material Segregation at customer end and Final Inspection Area .

3. Process Flow

Process Flow Description
Raw material Inward - Raw Material store -Parting on Traub machine -Bottom side ID(10.5)chamfer-OD Grinding -Semi Finish Inward - CNC ID Boring, Taper (10°)Turing, Facing -Plating Green)- Final inspection- Packing- Dispatch .

4. Process Details

Process / Operation	Parting on Traub machine -Face uneven
Outsource	Yes
Machine / Cell	Traub(A-25)-02
Machine / Cell No.	Traub Section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Parting on Traub machine -Face uneven	Bottom side Ring Chatter marks	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20pc/Bin

7. Root Cause Analysis (Occurance)

Why 1	Parallelism More
Why 2	Chatter marks On bottom side
Why 3	Bottom Side Face Operation Finish On Traub Machine.
Why 4	
Why 5	
Root Cause (Occurance)	Bottom Side Face Operation Finish On Traub Machine

Root Cause Analysis (Outflow)

Why 1	Parallelism More
Why 2	Parallelism Not 100% Inspection after CNC Machining
Why 3	Dial Test Indicator Instrument Not Available on CNC machine.
Why 4	
Why 5	
Root Cause (Outflow)	Dial Test Indicator Instrument Not Available on CNC machine.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Outflow	Dial Test Indicator Instrument Arrange on CNC machine.	quality Head	24/03/2024	24/03/2024	Completed
Outflow	Work Instruction Display on Defected Material Handling	Quality Head	22/04/2024	22/03/2024	Completed
Occurance	Process add of Bottom facing on CNC Machine	Quality Head	22/03/2024	22/03/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Parallelism Parameter Check On CNC machine
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Parting ,bottom Side Chamfer (0.8x45°) and Facing Process on Traub Machine. 721_Occurance_Before.pptx
Occurance (After)	CNC Process add-Chamfer(0.8X45°) and bottom side facing process. After Traub Parting. 721_Occurance_After.pptx
Outflow (Before)	Sample Basis (10-15Nos/Hr) Parallelism Verification On CNC Machine. 721_Outflow_Before.pptx
Outflow (After)	1)Parallelism parameter 100% Verification By Comparator Stand On CNC Machine. 2) OJT For Comparator Handling to CNC Operator 721_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Only For Cap oil lock J1D Model

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, ProcessFlowChart
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	180
Reason for submission	OK