QFR No - 8000877853

Defect Details

NC No.	8000877853
NC Date	11/06/2024
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-ID OPERATION MISSING

1. Problem Description

Defect Description	ID OPERATION MISSING
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	2
Is Defect Repeatative?	No
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	680	0	0	1280	0	1960
Check Qty	680	0	0	1280	0	1960
NG Qty	2	0	0	0	0	2

Action taken on NG part

Scrap	2
Rework	0
Under Deviation	0

Containment Action
All Suspected Material Segregation at Customer End

3. Process Flow

Process Flow Description
R/M Inward- Store- Parting And Pilot drill - Bottom side chamfer-CNC Turning and ID Boring - OD Grinding - Plating - Final Inspection - Dispatch.

4. Process Details

Process / Operation	Parting and Pilot Drill on Traub machine.
Outsource	Yes
Machine / Cell	Traub machine-A-25
Machine / Cell No.	Traub section.

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Hard Material	Correct Grade Material use hardness ok	O
Man	Unskiilled Man power	Skilled operator On CNC machine	O
Method	Input Material & Output Material Handling Method Wrong	Input and ok out put material kept On A table And Taper Ring Gauge Not available on CNC Machine .	X
Tool	Wrong Tool use For Pilot Drill	Correct Required Tool On CNC Machine	O
Machine	CNC Machine Condition Not OK	As PM plan Check sheet Condition found ok .	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20nos

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-ID OPERATION MISSING
Why 2	Defected Part By Mistake Mix By CNC operator
Why 3	Input material and out material Kept in one Location on CNC Machine.
Why 4	
Why 5	
Root Cause (Occurance)	Input material and out material Kept one location on CNC Machine.

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-ID OPERATION MISSING
Why 2	Taper Ring Gauge Not Available for 100% Taper Parameter Inspection on CNC Machine .
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Taper Ring Gauge Not Available for 100% Taper Parameter Inspection on CNC Machine .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Input Material and Output material separate location Two Table Arrangement on CNC Machine .	Production Head	13/06/2024	14/06/2024	Completed
Occurance	Taper Ring Gauge Provide on CNC Machine For 100% Inspection.	Quality Head	25/06/2024	25/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Taper & ID Inspection.
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)	Input material and out material Kept on one Table on CNC Machine. 853_Occurance_Before.jpg
Occurance (After)	Now Input Material and Output material separate -separate location Two Table Arrangement on CNC Machine . 853_Occurance_After.jpg
Outflow (Before)	Taper Ring Gauge Not Available for 100% Taper Parameter Inspection on CNC Machine . 853_Outflow_Before.jpg
Outflow (After)	Taper Ring Gauge Provide on CNC Machine For 100% Inspection. 853_Outflow_After.jpg

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK