QFR No - 8000877854

Defect Details

NC No.	8000877854
NC Date	11/06/2024
NC Submission Date	
Part No.	550BZ01402
Part Name	CAP OIL LOCK - DF01
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-ID OUT

1. Problem Description

Defect Description	ID wall thickness variation
Detection Stage	Inprocess
Problem Severity	Function
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	0	1280	1960
Check Qty	680	0	0	0	1280	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 & Pilot Drill -Bottom side chamfer-CNC-ID boring and Turning -OD Grinding -Plating- Final Inspection-Dispatch.

4. Process Details

Process / Operation	Parting & Pilot Drill
Outsource	Yes
Machine / Cell	Traub M/C
Machine / Cell No.	Traub No.2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Wrong tool use for Pilot drill	Yes , Long length Drill Use For pilot drill operation on Traub machine	X
Man	Unskilled operator	Skilled Operator On Traub Machine	O
Method	Parting & Pilot Drill Process wrong and Gauge Not Available.	Parting Process on Traub Machine But Concentricity Gauge Not Available On CNC Machine.	X
Material	Wrong grade &Hard Material use	Material Grade-EN1A and Hardness -87HRB	O
Machine	Machine Condition Not Ok	As per PM Check sheet Traub Machine Condition had 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	20 NOS

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-ID OUT
Why 2	Concentricity Problem observed During Piolet Drilling Process on Traub Machine.
Why 3	Piolet Drill Vibrate On Traub Machine during Piolet Drill Operation
Why 4	Piolet Drill had Over length Than Required .
Why 5	
Root Cause (Occurance)	Piolet Drill had Over length Than Required

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-ID OUT
Why 2	Sample Basis and Visual Inspection On CNC Machine.
Why 3	Concentricity Gauge not Available On CNC machine.
Why 4	
Why 5	
Root Cause (Outflow)	Concentricity Gauge not Available On CNC machine.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Piolet Drill Replace as per Required Length	Traub Operator / Line Inspector	13/06/2024	13/06/2024	Completed
Outflow	Concentricity Gauge Provide On CNC Machine.	QA Incharge.	22/06/2024	22/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Concentricity Parameter 100% Verifying on CNC Machine.
Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20nos / Hr

10. Evidance of Countermeasure

Occurance (Before)	Piolet Drill had Over length Than Required 854_Occurance_Before.jpg
Occurance (After)	Piolet Drill Replace as per Required Length 854_Occurance_After.docx
Outflow (Before)	Concentricity Gauge not Available On CNC machine. 854_Outflow_Before.jpg
Outflow (After)	Concentricity Gauge Provide On CNC Machine. 854_Outflow_After.docx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Cap OIL locks Family

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK