QFR No - 8000877855

Defect Details

NC No.	8000877855
NC Date	11/06/2024
NC Submission Date	
Part No.	520BZ00102
Part Name	CAP OIL LOCK-LML
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-ID STEP

1. Problem Description

Defect Description	ID step
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	56
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	730	0	0	0	1460	2190
Check Qty	730	0	0	0	1460	2190
NG Qty	56	0	0	0	0	56

Action taken on NG part

Scrap	56
Rework	0
Under Deviation	0

Containment Action
All Suspected Material Segregation at customer End .

3. Process Flow

Process Flow Description
RM Inward - store- Traub Parting and boring - Bottom side chamfer- CNC Turning and Boring - OD Grinding- Plating- Final Inspection - Dispatch

4. Process Details

Process / Operation	CNC Turning and Boring
Outsource	No
Machine / Cell	CNC Section
Machine / Cell No.	CNC nO-2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Wrong Tool Use	Boring Shank dia 8mmTool Use On CNC Machine .	X
Method	Inspection Wrong	10nos Per Bin ID Visual On Final Inspection Stage .	X
Man	Man Unskilled	As Per Skilled Matrix Operator is Skill	O
Material	Hard Material	Hardness 75-78 HRB	O
Machine	Machine Condition Not OK	As per PM schedule Machine Condition is OK	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10nos/Bin

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-ID STEP
Why 2	ID STEP Defect Observed On CNC machine
Why 3	Tool Vibration During Boring Operation On CNC
Why 4	Boring tool Shank was Weak on CNC machine .
Why 5	
Root Cause (Occurance)	Boring tool Shank was Weak on CNC machine .

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-ID STEP
Why 2	Final Inspection Stage ID Visual Sampling Frequency Very Low
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Final Inspection Stage ID Visual Sampling Frequency Very Low

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	ID Visual Sampling Increase 50Nos/Bin Instead of 5Nos	Quality Head	13/06/2024	14/06/2024	Completed
Occurance	Boring Tool Replace Shank dia Kept 11mm Instead of 8mm.	Production Head	13/06/2024	15/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	ID Visual Inspection Frequency Change 50Nos /bin Instead of 5nos.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50Nos/Bin

10. Evidance of Countermeasure

Occurance (Before)	Boring tool Shank was Weak on CNC machine . 855_Occurance_Before.docx
Occurance (After)	Boring Tool Replace Shank dia Kept 11mm Instead of 8mm. 855_Occurance_After.docx
Outflow (Before)	Final Inspection Stage ID Visual Sampling Frequency Very Low 855_Outflow_Before.jpg
Outflow (After)	ID Visual Sampling Increase 50Nos/Bin Instead of 5Nos 855_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Cap Models

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	Nil

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	OK