QFR No - 8000877870

Defect Details

NC No.	8000877870
NC Date	11/06/2024
NC Submission Date	
Part No.	F2PH00902B
Part Name	VALVE RETAINER (C101B)
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-CUT MAK

1. Problem Description

Defect Description	CUT MAK
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	6
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	3285	0	0	0	6000	9285
Check Qty	3285	0	0	0	6000	9285
NG Qty	6	0	0	0	0	6

Action taken on NG part

Scrap	6
Rework	0
Under Deviation	0

Containment Action
All Suspected Material Segregation at Customer End

3. Process Flow

Process Flow Description
RM Inward - Store- Parting on Traub Machine - CNC counter boring and facing - OD Grinding- plating-- Final Inspection - Dispatch

4. Process Details

Process / Operation	OD Grinding
Outsource	No
Machine / Cell	Grinding machine
Machine / Cell No.	GRD-5

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator	As per Skilled Matrix Operator is Skilled	O
Method	Process &Inspection Method Wrong	Process Method Ok But Inspection Method After OD Grinding visual frequency Very Low .	X
Material	Hard And other grade Material Use	Hardness 75-80 HRB and as per required grade CEW-1 Material Use.	O
Tool	Wrong Grinding Wheel Use	As Per Store Record Ok CUMI Make Grinding Wheel Use.	O
Machine	Machine Condition Not oK or RPM over	Machine Condition ok But Control Wheel RPM was 45-60	X

6. Inspection Method Analysis (Current)

Inspection Method	Sp. Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20/500nos

7. Root Cause Analysis (Occurance)

Why 1	NOT AS PER SPECIFICATION-CUT MAK
Why 2	Part Not Proper OD Grinding On Grinding Machine
Why 3	While OD grinding process, the part gets inverted.
Why 4	Control Wheel RPM was Over
Why 5	
Root Cause (Occurance)	Control Wheel RPM was Over

Root Cause Analysis (Outflow)

Why 1	NOT AS PER SPECIFICATION-CUT MAK
Why 2	Final Inspection stage Not Detect During Visual sampling Inspection ..
Why 3	After OD Grinding Process & Final Inspection stage visual frequency Very Low .
Why 4	
Why 5	
Root Cause (Outflow)	After OD Grinding Process & Final Inspection stage visual frequency Very Low .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Control wheel RPM Reduce 30-45 Instead Of 45-60	Production Head	15/06/2024	15/06/2024	Completed
Outflow	Sampling Frequency Increase 50nos Per 500Nos Instead Of 20/500nos& After Visual Inspection Tick Marks On OD at Final Stage.	Quality Head	17/06/2024	15/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Sampling Frequency Increase & After Visual Inspection Tick Marks On OD at Final Stage.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50Nos/500N

10. Evidance of Countermeasure

Occurance (Before)	Control Wheel RPM was Over 856_Occurance_Before.docx
Occurance (After)	Control wheel RPM Reduce 30-45 Instead Of 45-60 856_Occurance_After.docx
Outflow (Before)	After OD Grinding Process & Final Inspection stage visual frequency Very Low . 856_Outflow_Before.docx
Outflow (After)	Sampling Frequency Increase 50nos Per 500Nos Instead Of 20/500nos& After Visual Inspection Tick Marks On OD at Final Stage. 856_Outflow_After.docx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All CAP OIL Models

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	150

Reason for submission	OK