QFR No - 8000878523

Defect Details

NC No.	8000878523
NC Date	15/06/2024
NC Submission Date	
Part No.	550BZ01402
Part Name	CAP OIL LOCK - DF01
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	RUSTY-

1. Problem Description

Defect Description	CAP OIL LOCK RUST ISSUE
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	616
Is Defect Repeatative?	Yes
Defect Sketch / Photo	bhpnhqxb2aqiqeo31315nure.gif

Supplier Communication Details

Quality Head Email ID	quality@mahavirind.co.in
Plant Head/CEO Email ID	production@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	6000	0	0	0	12000	18000
Check Qty	6000	0	0	0	12000	18000
NG Qty	616	0	0	0	0	616

Action taken on NG part

Scrap	0
Rework	616
Under Deviation	0

Containment Action
All Material Check at the Customer End and Warehouse End

3. Process Flow

Process Flow Description
RM inward - store - Parting Piot Drill on Traub Machine - Bottom Side Chamfer -Semi finish Inward - CNC (Counter ID Machining) - OD Grinding - Plating - Final Inspection - Packing - Dispatch

4. Process Details

Process / Operation	Warehouse Loading - Unloading Handling Problem
Outsource	Yes
Machine / Cell	Narsapura Warehouse
Machine / Cell No.	Narsapura Warehouse

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Finish material Not Proper Packing	Yes , at Transport and Godown material not proper handling	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Rusty
Why 2	Finish Good Material Wet at warehouse
Why 3	Finish Good Lying On Shop floor
Why 4	Packing Bag Torn of finish good
Why 5	Finish Material Improper Material Handling
Root Cause (Occurance)	Packing Bag Torn of finish good Material During Store Area as it is material collect by godown man and Dispatch.

Root Cause Analysis (Outflow)

Why 1	Rusty
Why 2	Finish Good Material More No. of days lying at transport Godown
Why 3	Inform To godown person
Why 4	
Why 5	
Root Cause (Outflow)	Finish Good Material More No. of days lying at transport Godown

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	1)Improper Material Handling .2)Finish Good Material More No. of days lying at transport Godown	Mahavir QA	25/06/2024	26/06/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	1)Packing as per Customer Standards. 2) HDPE white, Heavy thickness and clean Gunny bags use for outer coating packing.
Inspection Method	Other
Other Inspection Method	Packing Visual Obs
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Finish Good Packing Bag Torn at warehouse during Material Handling .2)Low Thickness Poly Bag 873_Occurance_Before.gif
Occurance (After)	1)Inner poly bag thickness increases up to 100mic gauge Instead of 75Microm for Tearing problems avoid Suitable to Material Handling. 2)HDPE white , Heavy thickness and clean Gunny bags use for outer coating packing. 873_Occurance_After.jpg
Outflow (Before)	Finish Good Material More No. of days lying at transport godown 873_Outflow_Before.xlsx
Outflow (After)	As per the attached packing standard 443_Outflow_After.xlsx 873_Outflow_After.xlsx

11. Horizontal Deployment

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

12. Document Review

Documents	ControlPlan, PFMEA, PackingStd
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	15000
Reason for submission	reviewed 2 lots found ok