QFR No - 8000879506

Defect Details

NC No.	8000879506
NC Date	22/06/2024
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	DIMN.O/SIZE.-CONCENTRICITY MORE ISSUE

1. Problem Description

Defect Description	CAP OIL LOCK - DF01 CONCENTRICITY MORE ISSUE
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	1480
Is Defect Repeatative?	No
Defect Sketch / Photo	i2z4kjrrzalkbmbwopa4sgmv.gif

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	2780	12000	0	0	6000	20780
Check Qty	2780	12000	0	0	6000	20780
NG Qty	1480	0	0	0	0	1480

Action taken on NG part

Scrap	1480
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 on Traub -Bottom side chamfer on Drill M/C-CNC-ID boring and Turning -OD Grinding -Plating- Final Inspection-Dispatch

4. Process Details

Process / Operation	Parting & Pilot Drill on Traub
Outsource	Yes
Machine / Cell	Traub A-25 No.2
Machine / Cell No.	Traub Section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Parting & Pilot Drill Pprocess wrong and Gauge Not Available	Parting Process on Traub Machine But Concentricity Gauge Not Available	X
Tool	Wrong tool use for Pilot drill	Yes , Over length Drill Use For pilot drill operation on Traub 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
Man	Unskilled operator	Skilled Operator On Traub Machine	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	DIMN.O/SIZE.-CONCENTRICITY MORE ISSUE
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	DIMN.O/SIZE.-CONCENTRICITY MORE ISSUE
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	01/07/2024	02/07/2024	Completed
Outflow	Concentricity Gauge Provide On CNC Machine	QA Incharge.	10/07/2024	11/07/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Concentricity Parameter 100% Verifying on CNC Machine.
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)	Piolet Drill had Over length Than Required 878_Occurance_Before.jpg
Occurance (After)	Piolet Drill Replace as per Required Length 878_Occurance_After.docx
Outflow (Before)	Concentricity Gauge not Available On CNC machine 878_Outflow_Before.jpg
Outflow (After)	Concentricity Gauge Provide On CNC Machine. 878_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	10000
Reason for submission	verified after improvement lot found ok