QFR No - 8000879507

Defect Details

NC No.	8000879507
NC Date	22/06/2024
NC Submission Date	
Part No.	F2PH00902B
Part Name	VALVE RETAINER (C101B)
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	DAMAGES-MACHINING ISSUES

1. Problem Description

Defect Description	valve retainer machining issue
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	4
Is Defect Repeatative?	Yes
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	1200	0	0	0	9000	10200
Check Qty	1200	0	0	0	9000	10200
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
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	CLG-05
Machine / Cell No.	Grinding Cell

5. Problem Analysis

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

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	DAMAGES-MACHINING ISSUES
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	DAMAGES-MACHINING ISSUES
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
Outflow	Sampling Frequency Increase 50nos Per 500Nos Instead Of 20/500nos& After Visual Inspection Tick Marks On OD at Final Stage.	Quality Head	31/07/2024	01/08/2024	Completed
Occurance	Control wheel RPM Reduce 30-45 Instead Of 45-60	Production Head	30/07/2024	01/08/2024	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.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Control Wheel RPM was Over 879_Occurance_Before.docx
Occurance (After)	Control wheel RPM Reduce 30-45 Instead Of 45-60 879_Occurance_After.docx
Outflow (Before)	After OD Grinding Process & Final Inspection stage visual frequency Very Low 879_Outflow_Before.docx
Outflow (After)	Sampling Frequency Increase 50nos Per 500Nos Instead Of 20/500nos& After Visual Inspection Tick 879_Outflow_After.docx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Valve Retainer

12. Document Review

Documents	ControlPlan, PFMEA
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	5000
Reason for submission	Reviewed