QFR No - 8000886612

Defect Details

NC No.	8000886612
NC Date	12/08/2024
NC Submission Date	
Part No.	F2BZ05712B
Part Name	CAP OIL LOCK - J1D FF (10mm taper)
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	PARALITY NOT OK.-PARALLISUM FOUND NOT OK.

1. Problem Description

Defect Description	Parallelism Found Not OK
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	4
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	340	0	0	0	0	340
Check Qty	340	0	0	0	0	340
NG Qty	4	0	0	0	0	4

Action taken on NG part

Scrap	4
Rework	0
Under Deviation	0

Containment Action
All Stages +customer End All suspected Finish Good material Verified

3. Process Flow

Process Flow Description
R/M Inward - R/M Store- Traub parting ?10.5 ID Hole - CNC Taper Turning/ ID Boring - Bottom Side Chamfer- OD Grinding- Rust preventive washing - Final Inspection - Packing- Dispatch.

4. Process Details

Process / Operation	CNC Taper Turning/ ID Boring
Outsource	Yes
Machine / Cell	CNC Section
Machine / Cell No.	CNC-2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Not proper arrangement of Defective parts Handling on CNC Machine	Not Available Lock and Key Red box on CNC machine	X
Man	Unskiilled Man power	Skilled operator On CNC machine	O
Material	Hard Material	Correct Grade Material use & hardness ok	O
Machine	CNC Machine Condition Not OK	As PM plan Check sheet Condition found ok but Chuck Jaw Boring Frequency not decide.	X
Tool	Wrong Tool use For Pilot Drill	Correct Required Tool On CNC Machine	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	PARALITY NOT OK.-PARALLISUM FOUND NOT OK.
Why 2	CNC chuck jaw boring was not completed on time
Why 3	The operator is not aware of CNC jaw boring
Why 4	The frequency for jaw boring has not been decided
Why 5	
Root Cause (Occurance)	The frequency for jaw boring has not been decided

Root Cause Analysis (Outflow)

Why 1	PARALITY NOT OK.-PARALLISUM FOUND NOT OK.
Why 2	Defected Part By Mistake Mix By CNC operator
Why 3	Improper arrangement of defective parts stored on the CNC machine.
Why 4	
Why 5	

Root Cause (Outflow)	Improper arrangement of defective parts stored on the CNC machine.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Define the frequency of CNC jaw boring and provide training to the operator.	Production Head	14/08/2024	14/08/2024	Completed
Outflow	Arrange the lock and key in the red box on the CNC machine.	Quality head	17/08/2024	17/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100%
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	The frequency for jaw boring has not been decided 1006_Occurance_Before.pptx
Occurance (After)	Define the frequency of CNC jaw boring and provide training to the operator. 1006_Occurance_After.jpg
Outflow (Before)	Improper arrangement of defective parts stored on the CNC machine. 1006_Outflow_Before.jpg
Outflow (After)	Arrange the lock and key in the red box on the CNC machine 1006_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Machine and all models

12. Document Review

Documents	PFMEA, WISOP
Specify Other Document	no

13. Effectiveness Of Action

Reviewed Quantity	50

Reason for submission	Work instruction updated for jaw boring frequency but no revision number updated