QFR No - 8000893359

Defect Details

NC No.	8000893359
NC Date	27/09/2024
NC Submission Date	
Part No.	S2MX00812B
Part Name	STEEL BUSH J1A & J1D
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	LENGTH UNDERSIZE-T.LENGTH U/S SPE=25.20-0.20 OBS=24.84

1. Problem Description

Defect Description	LENGTH UNDERSIZE-T.LENGTH U/S SPE=25.20-0.20 OBS=24.84
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	79
Is Defect Repeatative?	No
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	7000	0	0	0	0	7000
Check Qty	7000	0	0	0	0	7000
NG Qty	17	0	0	0	0	17

Action taken on NG part

Scrap	17
Rework	0
Under Deviation	0

Containment Action
All Suspected Material segregation at Customer End

3. Process Flow

Process Flow Description
RM inward - store - Traub Parting -Chamfering - Plating-Final inspection - Packing - Dispatch - Transport

4. Process Details

Process / Operation	Traub Parting
Outsource	Yes
Machine / Cell	Traub No. 5
Machine / Cell No.	Traub Section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator	As per Skilled Matrix Operator is skilled	O
Tool	Wrong Tool Insert Use	Correct carbide parting Tool Use But Tool Holding Issue	X
Material	Wrong Grade And other grade Material Use	Correct Grade CEW-1 Material use .	O
Method	Machining Process & Inspection Method Wrong	Machining Process is ok But Inspection Method Wrong	X
Machine	Machine Condition Not OK	As per Daily Check sheet Machine Condition was OK	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	Length oversize / under size
Why 2	During the parting process, the parting tool Insert is lightly loose on the Traub machine.
Why 3	The tool Insert is not properly tightened because the bolt head is worn due to improper tightening with an Allon Key
Why 4	
Why 5	
Root Cause (Occurance)	During the parting process, the parting tool Insert is lightly loose on the Traub machine.

Root Cause Analysis (Outflow)

Why 1	Length oversize / under size
Why 2	Sample Basis Inspection On final Inspection stage .
Why 3	No stage Wise Length gauges Only One Gauge For Both Stage
Why 4	
Why 5	
Root Cause (Outflow)	No stage Wise Length gauges Only One Gauge For Both Stage.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	New Parting Tool Holder Replace on Traub Machine and Insert change Work Instruction Display	Production Head	30/09/2024	30/09/2024	Completed
Outflow	Additional New Length gauge Arrange On Final Inspection Stage for 100% Inspection.	Quality Head	10/09/2024	06/09/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Length Inspection on final Stage Instead of 50% Inspection
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)	During the parting process, the parting tool Insert is lightly loose on the Traub machine. 1117_Occurance_Before.jpg
Occurance (After)	New Parting Tool Holder Replace on Traub Machine and Insert change Work Instruction Display 1117_Occurance_After.jpg
Outflow (Before)	No stage Wise Length gauges Only One Gauge For Both Stage . 1117_Outflow_Before.jpg
Outflow (After)	Additional New Length gauge Arrange On Final Inspection Stage for 100% Inspection. 1117_Outflow_After.docx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Steel Bush

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	200
Reason for submission	after taking action no any issue reported for the same.