

Defect Details

NC No.	8000897821
NC Date	29/10/2024
NC Submission Date	
Part No.	520PA01602
Part Name	TUBE RING BOTTOM
Supplier Name & Code	101255-MAHAVIR INDUSTRIES
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	ID UNDERSIZE-ID U/S SPE=29.0+/-0.10 OBS=28.40

1. Problem Description

Defect Description	ID UNDERSIZE-ID U/S SPE=29.0+/-0.10 OBS=28.40
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	49
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	1800	0	0	0	0	1800
Check Qty	1800	0	0	0	0	1800
NG Qty	49	0	0	0	0	49

Action taken on NG part

Scrap	49
Rework	0
Under Deviation	0

Containment Action

All Material segregation at Customer End

3. Process Flow

Process Flow Description

RM inward - store - Traub Machining -1 -chamfer Machining -2- Final Inspection - Packing - Dispatch - Transport

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Parting Machining Method Change , Inspection Method Change	Traub Machining Method is Correct But pipe ID not Inspection Before parting on Parting Process..	X
Material	Wrong Size And other grade Material Use	Grade was ok but ID under size Pipe Mix With ok Raw Material .	X
Tool	Wrong Chamfer Tool Use	No, Insert Type Chamfer Tool Use on chamfer machine .	O
Machine	Machine Condition Not Ok	As Per PM schedule Traub Machine Found Ok	O
Man	Unskilled operator	As per Skilled Matrix Operator is skilled	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20nos

7. Root Cause Analysis (Occurance)

Why 1	D UNDERSIZE-ID U/S
Why 2	ID Under size One Pipe mix With Ok Regular Raw Material.
Why 3	Operator Not aware for ID under size. In Regular Operation.
Why 4	
Why 5	
Root Cause (Occurance)	ID Under size One Pipe mix With Ok Regular Raw Material.

Root Cause Analysis (Outflow)

Why 1	D UNDERSIZE-ID U/S
Why 2	ID Under size One Pipe mix With Ok Regular Raw Material.
Why 3	The operator on the Traub machine did not check the first parting piece after loading a new pipe.
Why 4	Operator Not aware for ID under size. In Regular Operation.
Why 5	
Root Cause (Outflow)	The operator on the Traub machine did not check the first parting piece after loading a new pipe.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Work Instructions Display on Traub Machine for Operator Awareness	Production Incharge	08/11/2024	07/11/2024	Completed
Outflow	Plug Gauge Provide On Traub Machine for check the first parting piece after loading a new pipe.	Quality Head	17/11/2024	16/11/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Plug Gauge Provide On Traub Machine for check the first parting piece after loading each and Every a New Pipe
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	20Pcs

10. Evidence of Countermeasure

Occurance (Before)	ID Under size One Pipe mix With Ok Regular Raw Material. 1196_Occurance_Before.docx
Occurance (After)	Work Instructions Display on Traub Machine for Operator Awareness. 1196_Occurance_After.docx
Outflow (Before)	The operator on the Traub machine did not check the first parting piece after loading a new pipe. 1196_Outflow_Before.docx
Outflow (After)	lug Gauge Provide On Traub Machine for check the first parting piece after loading a new pipe. 1196_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Tube Rings

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	

