

Defect Details

NC No.	7000829982
NC Date	06/04/2022
NC Submission Date	
Part No.	S2BY04007B
Part Name	CANISTER M/C, IMPREGNATED & COATED
Supplier Name & Code	101032-ASM CASTINGS PRIVATE LIMITED (
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	POWDER COATING NOT OK-POWDER COATING PEEL OFF

1. Problem Description

Defect Description	Canister Failed in Adhesion Test at Receipt
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	2000
Is Defect Repeatative?	Yes
Defect Sketch / Photo	bxvtf0xyugvyhemmx3w43yva.png

Supplier Communication Details

Quality Head Email ID	quality@asmcastings.in
Plant Head/CEO Email ID	skaul@asmcastings.in
MD Email ID	rajiv@asmcastings.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1200	0	0	1650	1000	3850
Check Qty	10	0	0	1650	1000	2660
NG Qty	0	0	0	1650	0	1650

Action taken on NG part

Scrap	10
Rework	0
Under Deviation	0

Containment Action

Part Checked (10 Nos. each lot for Tape Test) and a chemical added in impregnation process as per M/S Ultraseal's Recommendation (Sealant & Impregnation Unit Supplier)

3. Process Flow

Process Flow Description

R.M. Receiving - Casting - Fattling- CNC Machining - SPM Machining- Impregnation - Pin Pressing - Leakage Testing- Dry in Oven - Inspection & PDI - Packing - Dispatch

4. Process Details

Process / Operation	Impregnation
Outsource	No
Machine / Cell	Impregnation Unit
Machine / Cell No.	N/A

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Ra not maintained from Shot Blasting Machine	Ra Inspection & Cycle Time Verification in Shot Blasting Machine	X
Tool	Impregnation Unit not working adequately	Ring Test	X
Material	Impregnation Sealant not effective	Impregnation done at Customer End with Other Brand	O
Man	Operator not aware about process	Skill Matrix	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Tape Test
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	not detect

7. Root Cause Analysis (Occurance)

Why 1	Powder Coating Peel off at customer end
Why 2	bonding of Powder & Part could not be adequate
Why 3	a layer of chemical sealant deposited at surface of part
Why 4	Damaged /Old Mesh Used in Basket (mesh Not Changed Timely)
Why 5	Mesh Changing Freq. Not decided.
Root Cause (Occurance)	Mesh Changing Freq. Not decided.

Root Cause Analysis (Outflow)

Why 1	Can Not detected at ASM
Why 2	Powder Coating at Outsource. (Customer /Supplier End)
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Powder Coating Out Source (Customer /Supplier)

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Qty. per Basket reduced from 600 nos. to 400 nos. per basket & added in Work Instruction.	Lalit Sharma	30/07/2022	30/07/2022	Completed
Occurance	Awareness Training Provided to Concerned person for Work Instruction ammedment.	Lalit Sharma	02/08/2022	02/08/2022	Completed
Occurance	Mesh Changing Freq. Added in Control Plan	Lalit Sharma	01/02/2023		Completed
Occurance	Sealant Grade Changed from PC504 to IM3000 to improve Impregnation Quality.	Ultraseal.	28/10/2022		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Supervisor Verification for part Qty. in Basket as per W.I.
Inspection Method	Other
Other Inspection Method	as per w.i.
Check Point at Final Inspection	No
Checking Freq.	100%
Sampling	No
Sample Size	10

10. Evidence of Countermeasure

Occurance (Before)	01. Check Point not added in Work Instruction for qty per basket. 02. Sealent Grade Change from PC504 to IM3000 (Suggested by Impregnation Supplier) 47_Occurance_Before.png
Occurance (After)	Work Instruction Updated for Qty. per Basket 47_Occurance_After.pdf
Outflow (Before)	Awareness not evident to concern person for Qty. per basket. 47_Outflow_Before.jpg
Outflow (After)	Awareness Training provided to concerned person 47_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	n/a

12. Document Review

Documents	WISOP
Specify Other Document	W.I

13. Effectiveness Of Action

Reviewed Quantity

4000

Reason for submission

No any Peel Off Reported after Action Taken