

Defect Details

NC No.	7000835500
NC Date	09/05/2022
NC Submission Date	
Part No.	520AE01502
Part Name	CORE PLATE LML
Supplier Name & Code	100959-AAR CEE ENGINEERING WORKS UNIT
ETL Plant	1135-ETL 7/10 P Nagar
Defect Details	SHADE VARIATION-surface finish not ok

1. Problem Description

Defect Description	surface finish not ok
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	565
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qc@aarceeengg.com
Plant Head/CEO Email ID	planthead.diecasting@aarceeengg.com
MD Email ID	vaibhav.arora@aarceeengg.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5000	0	0	7500	8000	20500
Check Qty	5000	0	0	7500	8000	20500
NG Qty	500	0	0	50	0	550

Action taken on NG part

Scrap	0
Rework	550
Under Deviation	0

Containment Action

Material segregated at the customer end (ETL end) & our end (AAR CEE end) NG parts to be reshot blasting.

3. Process Flow

Process Flow Description

10. Receipt of Raw Material 20. Storage of Raw Material 30. Holding Cum Melting 40. PDC 50. Trimming 60. Shot Blasting 70. Barrelling 80. Sound Testing 90. Stress Relieving 100. Final Inspection & Packing 110. Storage & Dispatch

4. Process Details

Process / Operation	60. Shot Blasting & 100. Final Inspection
Outsource	No
Machine / Cell	SHOT BLASTING MACHINE
Machine / Cell No.	SBM-02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Shot Blasting not done as per defined method in Control Plan	Operator not follow the method as defined in control plan	X
Man	At final inspection NG pieces skip	NG pieces skipped by Final Inspectors	X
Man	Operator not doing shot blasting as per defined method	Semi-skilled operator deputed by contractor	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	10pcs

7. Root Cause Analysis (Occurance)

Why 1	Shade variation surface finish is not ok due to shot blasting not being done correctly
Why 2	Shot blasting is not done correctly due to the operator not following the defined method
Why 3	Operator not following the defined method due to semi-skilled workforce deputed by the contractor
Why 4	
Why 5	
Root Cause (Occurance)	Semi-skilled operator deputed by the contractor

Root Cause Analysis (Outflow)

Why 1	The shade variation surface finish is not ok due to NG pieces skipped by final inspectors
Why 2	NG pieces were skipped by final inspectors due to a semi-skilled workforce deputed by the contractor
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Semi-skilled operator deputed by the contractor

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	On job training to be given to the operators & also before deputing any worker induction training to be given	Ankit Gupta	14/05/2022	14/05/2022	Completed
Occurance	On job training to be given to the operators & also before deputing any worker induction training to be given	Ankit Gupta	14/05/2022	14/05/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	no change
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	05

10. Evidance of Countermeasure

Occurance (Before)	No induction training was given to the newly joined manpower only format available but not adhered to. 97_Occurance_Before.pdf
Occurance (After)	No induction training was given to the newly joined manpower only format available but not adhered to. 97_Occurance_After.pdf
Outflow (Before)	On the job training is being given to the concerned persons & Induction training is being given to the shot blasting machine operator 97_Outflow_Before.pdf
Outflow (After)	Induction Training is given to the quality inspector 97_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	All model

12. Document Review

Documents	WISOP
Specify Other Document	No other documents

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok

