QFR No - 7000842723

Defect Details

NC No.	7000842723
NC Date	17/06/2022
NC Submission Date	
Part No.	53BHT00807
Part Name	OUTER SPRING POWDER COATED-VAVE
Supplier Name & Code	101048-STUMPP SCHUELE AND SOMAPPA SPR
ETL Plant	1136-ETL Suspension Sanand
Defect Details	POWDER COATING NOT OK-Powder coating Defects .

1. Problem Description

Defect Description	Powder coating Defects like White Spot, Heavy Hanger Marke, Pin Hole, Paint Uncover & Dry etc.
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	271
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	vipin.shukla@ssssprings.com
Plant Head/CEO Email ID	udham.singh@ssssprings.com
MD Email ID	rln@ssssprings.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1120	0	0	1120	0	2240
Check Qty	1120	0	0	1120	0	2240
NG Qty	8	0	0	0	0	8

Action taken on NG part

Scrap	8
Rework	0
Under Deviation	0

Containment Action
100% Visual Inspection

3. Process Flow

Process Flow Description
Recipt & inspection - Storage of material - Winding - Stress Relieving-1 - Grinding - Shot peening - Stress Releiving-2 - Scragging - Length,e1,e2 sorting - powder coating - Final inspection - Packing

4. Process Details

Process / Operation	Powder Coating
Outsource	No
Machine / Cell	PC Line
Machine / Cell No.	Powder Coating

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	improper handling of the parts	Verified and found that parts fall down during hanging process and got dust accumulated	X
Method	OK and NG parts mix up during inspeciton	Inspected OK parts and Parts pending for inspection got mix up	X
Material	parts not cleaned during PT process	Process verified and found satisfactory PT process	O
Man	Unskilled person deputed for powder coated springs	Verified the skill level of the inspector and found OK	O
Machine	Powder coating gun parameters not as per specification	Verified all the machine parameters & found within specification	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Problem occured during powder coating process.
Why 2	Dust accumulation during process
Why 3	Few parts dropped down while loading/hanging to hangers & loaded again without cleaning.
Why 4	
Why 5	
Root Cause (Occurance)	Few parts dropped down while loading/hanging to hangers & loaded again without cleaning.

Root Cause Analysis (Outflow)

Why 1	Defective part escaped through inspection
Why 2	NG parts mixed up with OK parts.
Why 3	Inspected OK parts and parts pending for inspection got mix up
Why 4	
Why 5	

Root Cause (Outflow)	Inspected OK parts and parts pending for inspection got mix up

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Design of the hangers modified to avoid the fall of spring during hanging process	Mr Shashank	23/06/2022		Pending
Outflow	Separator provided at inspection table to avoid the mix up of "Inspection finished parts" and "parts pending for inspection"	Mr. Shashank	22/06/2022		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Separator provided at inspection table to avoid the mix up of "Inspection finished parts" and "parts pending for inspection
Inspection Method	Pokayoke
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	No work instruction found for the treatment of fallen parts during hanging of springs during powder coating process 181_Occurance_Before.pdf
Occurance (After)	Work instruction revised for the instructions on treatment of fallen parts 181_Occurance_After.pdf
Outflow (Before)	Inspection finished parts and Inspection pending parts were kept together without separator. 181_Outflow_Before.png
Outflow (After)	Separator provided to avoid accumulation at inspection table for the isnpected parts and inspection pending parts 181_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Horizontal deployment for Occurrence and Outflow actions for all OC springs

12. Document Review

Documents	WISOP
Specify Other Document	No

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	