

Defect Details

NC No.	7000966627
NC Date	12/12/2023
NC Submission Date	
Part No.	B207027000
Part Name	END CONNECTOR ASM M/CYL & CAL.ST.BR.
Supplier Name & Code	101221-SUNREN AUTOMOTIVE PRIVATE LIMI
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	DAMAGES-damages

1. Problem Description

Defect Description	DAMAGES-damages
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	167
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	shivank@sunren.in
Plant Head/CEO Email ID	shivank@sunren.in
MD Email ID	subhashsaini@sunren.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	2000	3500	1500	2500	9500
Check Qty	0	2000	3500	1500	2500	9500
NG Qty	0	15	0	10	0	25

Action taken on NG part

Scrap	0
Rework	25
Under Deviation	0

Containment Action

100% Material Segregation

3. Process Flow

Process Flow Description

Forging- Centerless Grinding - Cylinder Drill - CNC1st - CNC2ND- Facing2nd-Neck Drill-Step Drill-Nipple Assy.-Brazing-100%Visual Inspection-Bending-Final Inspection

4. Process Details

Process / Operation	Facing
Outsource	No
Machine / Cell	Facing Machine
Machine / Cell No.	8

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Packaging Standard	Yes	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Dent & Damages
Why 2	Due to small face width.
Why 3	Due to drawing
Why 4	
Why 5	
Root Cause (Occurance)	Due to small face width.

Root Cause Analysis (Outflow)

Why 1	Dent & Damages
Why 2	Due to metal to metal contact
Why 3	Due to poor handling
Why 4	Due to Packaging Standard
Why 5	
Root Cause (Outflow)	Due to packaging standard

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Face Width should be increased and same has to be cover in the drawing.	SunRen	23/12/2023	22/12/2023	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Additional Checkpoint added.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	05

10. Evidence of Countermeasure

Occurance (Before)	Face Width Diameter is 13.75 615_Occurance_Before.pdf
Occurance (After)	Face Width Diameter is 14.97 615_Occurance_After.pdf
Outflow (Before)	250 Nos / Polybag 615_Outflow_Before.png
Outflow (After)	100 Nos / Polybag 615_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	B207025000

12. Document Review

Documents	Drawing, ControlPlan, WISOP, ProcessFlowChart
Specify Other Document	ECN

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	No defect found in latest lot