QFR No - 7001032025

Defect Details

NC No.	7001032025
NC Date	10/07/2024
NC Submission Date	
Part No.	B20708200O
Part Name	END CON ASM ABS SIDE- ABS 2 FR MC K42CH
Supplier Name & Code	101221-SUNREN AUTOMOTIVE PRIVATE LIMI
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	RUSTY-rusty

1. Problem Description

Defect Description	RUSTY-rusty
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	300
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	shivank@sunren.in
Plant Head/CEO Email ID	sanjayrana@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	2800	3800	800	500	1500	9400
Check Qty	2800	3800	800	500	1500	9400
NG Qty	300	0	0	0	0	300

Action taken on NG part

Scrap	0
Rework	300
Under Deviation	0

Containment Action
Re-Plating

3. Process Flow

Process Flow Description
Plating

4. Process Details

Process / Operation	Plating
Outsource	Yes
Machine / Cell	01
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Wrong Method	Wrong Method Followed	O
Man	Lack of Knowledge	Skilled	X
Man	Lack Of Awareness	Training Required	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	5

7. Root Cause Analysis (Occurance)

Why 1	Due to presence of water.
Why 2	Due to no. of bends , in the part water gets accumulated at the bends.
Why 3	Pressurized air not passed through the bends of the part.
Why 4	Not Define in SOP.
Why 5	Lack of Awareness
Root Cause (Occurance)	Pressurized Air not passes through the bends of the parts after plating operation.

Root Cause Analysis (Outflow)

Why 1	Rust cannot be detected at the same time and takes time to occur.
Why 2	Depends on storage conditions also.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Rust takes time to occur and cannot be detected at the same time.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Rust Oil will be passed through the bend of the part after plating operation.	Krishna Plating	30/07/2024	30/07/2024	Completed
Occurance	Pressurized Air will be passed through the bends of the parts after plating operation.	Krishna Plating	30/07/2024	30/07/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Rust oil will be passed through the end bend of the part after plating operation and it`s inspection.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

10. Evidance of Countermeasure

Occurance (Before)	No Air Passes Through Bend After Plating Operation 932_Occurance_Before.jpg
Occurance (After)	Air will be pass through bend after plating operation. 932_Occurance_After.jpeg
Outflow (Before)	Rust Oil was applied over the surface of the part. 932_Outflow_Before.jpeg
Outflow (After)	Rust oil will be pass through the bend of the part,. 932_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	B20707800O

12. Document Review

Documents	
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	ok