

Defect Details

NC No.	7001036040
NC Date	23/07/2024
NC Submission Date	
Part No.	B2EH08602O
Part Name	END CONNECTOR CALIPER SIDE N-TORQ
Supplier Name & Code	101221-SUNREN AUTOMOTIVE PRIVATE LIMI
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	DENTS & DAMAGES-DENTS & DAMAGES

1. Problem Description

Defect Description	DENTS & DAMAGES-DENTS & DAMAGES
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	318
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	6000	9000	2500	1000	8000	26500
Check Qty	6000	9000	2500	1000	8000	26500
NG Qty	318	120	65	0	0	503

Action taken on NG part

Scrap	0
Rework	503
Under Deviation	0

Containment Action

Re-Inspection For All The Suspected Qty.

3. Process Flow

Process Flow Description

Forging-Centerless Grinding-1st Cutting-2nd Cutting-Milling-Cross Drill-Facing 1st- Facing 2nd -Neck Drill-Cross Reamer-Chamfer-Air Cleaning-Pin Tray-Visual Inspection-Bending-Identification Marking-Plating-Final Inspection-Dispatch.

4. Process Details

Process / Operation	Centerless Grinding ,Milling, Cross Drill,
Outsource	No
Machine / Cell	01
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Wrong Method	Appropriate Method Not Followed	O
Man	Lack Of Awareness	Not Aware	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 poor handling
Why 2	Material Handling Method Not Followed
Why 3	Lack of Awareness
Why 4	
Why 5	
Root Cause (Occurance)	Material to Material Contact due to the poor handling.

Root Cause Analysis (Outflow)

Why 1	Due to visual detection only.
Why 2	Inspector was not aware.
Why 3	Due to lack of Training
Why 4	
Why 5	
Root Cause (Outflow)	Lack of Defect Awareness Training

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Material Handling Training Will be provided to the operators.	Amit	01/08/2024	01/08/2024	Completed
Outflow	Defect Awareness Training given to the inspectors.	Amit	01/08/2024	01/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspectors will check the material as per the defect matrix.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	5

10. Evidence of Countermeasure

Occurance (Before)	Poor Handling 957_Occurance_Before.jpg
Occurance (After)	Material Handling Training Provided to the operators. 957_Occurance_After.pdf
Outflow (Before)	Lack of Awareness Training 957_Outflow_Before.jpg
Outflow (After)	Awareness training provided to the inspectors. 957_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Parts

12. Document Review

Documents	
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	found ok