QFR No - 8000789262

Defect Details

NC No.	8000789262
NC Date	28/05/2022
NC Submission Date	
Part No.	S2AB01907B
Part Name	ADJUSTER POWDER COATED
Supplier Name & Code	100973-ABHIVRDHI ENGINEERING PRIVATE
ETL Plant	1116-ETL K-120 Suspension
Defect Details	POWDER COATING NOT OK-POWDER COATING DEFECT & UN COATED MIXUP

1. Problem Description

Defect Description	Major powder coating defects observed at receipt & during assembly stage. Same causing assembly line stoppage & increases rework activity.
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	1139
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rkhare@tesmomotorcast.com
Plant Head/CEO Email ID	harish.bala@tesmomotorcast.com
MD Email ID	svkallani@tesmomotorcast.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1139	0	0	0	0	1139
Check Qty	1139	0	0	0	0	1139
NG Qty	439	0	0	0	0	439

Action taken on NG part

Scrap	39
Rework	300
Under Deviation	100

Containment Action
After powder coated 100% inspection

3. Process Flow

Process Flow Description
pdc, riming, od grinding, debering, inspection, & packing.

4. Process Details

Process / Operation	Powder Coated
Outsource	No
Machine / Cell	pdc 350t
Machine / Cell No.	pdc 350 t

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	not proper spray	gauge	O
Method	Pre-Treatment process not done	System	O

6. Inspection Method Analysis (Current)

Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	300 nos

7. Root Cause Analysis (Occurance)

Why 1	Powder coating not ok
Why 2	Powder not uniform on part
Why 3	Powder electrostatic gun malfunctioning
Why 4	Gun to earth continuity not good
Why 5	Continuity pm not check
Root Cause (Occurance)	point not available in pm check sheet

Root Cause Analysis (Outflow)

Why 1	powder coating not ok
Why 2	Uncover part in final packing
Why 3	100 % inspection not happen after powder coating
Why 4	Sample inspection process follow
Why 5	Inspection system not ok
Root Cause (Outflow)	100% inspection started

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Continuity checking from gun to hanger started	Sachin	01/01/2023	01/01/2023	Completed
Outflow	100 % inspection started	Rahul	01/09/2022	01/01/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection after powder coating
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	1

10. Evidance of Countermeasure

Occurance (Before)	adjuster without powder coated 153_Occurance_Before.jpg
Occurance (After)	After powder coated 153_Occurance_After.jpg
Outflow (Before)	visual not check 153_Outflow_Before.jpg
Outflow (After)	After inspection 153_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	samath coating

12. Document Review

Documents	AuditCheckSheet, PackingStd
Specify Other Document	control plan

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	