QFR No - 8000789810

Defect Details

NC No.	8000789810
NC Date	02/06/2022
NC Submission Date	
Part No.	B2GQ03323O
Part Name	M/CYL BODY RAW POW.COATED-RE J1C FRONT
Supplier Name & Code	100204-KRISHNA COATING
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	POWDER COATING NOT OK-AFTER100%INSP.DUST,UNCOVER,BUBBLE

1. Problem Description

Defect Description	Dust and uncover
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	60
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	qualitykrishnaassociates01@gmail.com
Plant Head/CEO Email ID	ravikrishnacoating@gmail.com
MD Email ID	krishnacoating@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	4448	0	0	0	0	4448
Check Qty	4448	0	0	0	0	4448
NG Qty	125	0	0	0	0	125

Action taken on NG part

Scrap	0
Rework	125
Under Deviation	0

Containment Action
before sampling basis Inspection done at inward stage. but currently we start 100 % raw material Inspection at inward inspection stage

3. Process Flow

Process Flow Description
Inward -100 % visual inspection - Pretreatment - Drying - Powder coating - Baking - final inspection - packing & dispatch

4. Process Details

Process / Operation	Powder Coating
Outsource	No
Machine / Cell	Powder coating line
Machine / Cell No.	Powder coating line

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Rusty material , oily ,	Rusty material observed at inward stage	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	Bubble defect observed
Why 2	White rust observe in master cylinder RE- J1C at inward stage
Why 3	no 100 % visual inspection plan at inward stage
Why 4	
Why 5	
Root Cause (Occurance)	White rusty part observe at inward inspection stage

Root Cause Analysis (Outflow)

Why 1	rusty material observed
Why 2	Only inward inspection on sampling basis
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Rusty Material

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Now we started 100% visual inspection at inward stage	Ahok dabhade	04/07/2022	05/07/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% visual Inspection at inward stage
Inspection Method	Other
Other Inspection Method	VIsual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100 %

10. Evidance of Countermeasure

Occurance (Before)	only sampling basis inward inspection at inward stage 161_Occurance_Before.pdf
Occurance (After)	Now Started 100 % visual inspection at inward stage (as per sampling plan) 161_Occurance_After.pdf
Outflow (Before)	only sampling basis inward inspection at inward stage 161_Outflow_Before.pdf
Outflow (After)	Now Started 100 % visual inspection at inward stage (as per sampling plan 161_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	inward stage

12. Document Review

Documents	WISOP
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	1360
Reason for submission	No rusty found in next 3 lot