QFR No - 8000790195

Defect Details

NC No.	8000790195
NC Date	06/06/2022
NC Submission Date	
Part No.	260KN00107
Part Name	RESERVOIR CAP POWDER COATED
Supplier Name & Code	100204-KRISHNA COATING
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	POWDER COATING NOT OK-COATING UNCOVER,DUST,PIN HOLES

1. Problem Description

Defect Description	Powder Coating Uncover, dust
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	740
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	23450	0	0	0	0	23450
Check Qty	23450	0	0	0	0	23450
NG Qty	1782	0	0	0	0	1782

Action taken on NG part

Scrap	0
Rework	1782
Under Deviation	0

Containment Action
Previously reservoir cap Coating on batch type line to resolve the uncover issue we shift coating from batch type to conveyor line And also dust mark issue also resolve because of close section of conveyor line.

3. Process Flow

Process Flow Description
Inward - Pretreatment - Drying - powder Coating- Baking- Final Inspection - 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
Machine	1) Over Coated Rod	Visual	X

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	Material Uncover issue?
Why 2	Proper Earthing not get to the Part.
Why 3	Over Coated rod
Why 4	Rod used for coating 2 times
Why 5	
Root Cause (Occurance)	Over Coated rod.

Root Cause Analysis (Outflow)

Why 1	Found Over Coated Rod
Why 2	We Shift Reservoir cap from batch type to conveyor line
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Over Coated Rod.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	We shift reservoir cap batch type coating to conveyor line	Mr. Ajim Patel	06/07/2022	06/06/2022	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	Batch type Before Loading Pattern for powder Coating 162_Occurance_Before.xlsx
Occurance (After)	Conveyor line Loading Pattern for powder coating 162_Occurance_After.jpg
Outflow (Before)	Batch type Before Loading Pattern for powder Coating 162_Outflow_Before.xlsx
Outflow (After)	Conveyor line Loading Pattern for powder coating 162_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Conveyor line

12. Document Review

Documents	ControlPlan, ProcessFlowChart
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	12600
Reason for submission	No defect found in Next 3 Lot