QFR No - 8000791480

Defect Details

NC No.	8000791480
NC Date	15/06/2022
NC Submission Date	
Part No.	S1AB00307B
Part Name	ADJUSTER POWDER COATED K0LA
Supplier Name & Code	100973-ABHIVRDHI ENGINEERING PRIVATE
ETL Plant	1136-ETL Suspension Sanand
Defect Details	POWDER COATING NOT OK-POWDERCOATING PROBLEM

1. Problem Description

Defect Description	Powder Coating defects like paint bubble, paint dry, paint dust etc. and wrong supplier code (found V code instead of A code)
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	275
Is Defect Repeatative?	No
Defect Sketch / Photo	0s4yuyooyw4vtdtqjaz2mq3a.jpg

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	275	0	0	0	2100	2375
Check Qty	275	0	0	0	2100	2375
NG Qty	275	0	0	0	0	275

Action taken on NG part

Scrap	75
Rework	150
Under Deviation	50

Containment Action
After powder coated 100% inspection

3. Process Flow

Process Flow Description
pdc - ,reming - od grinding, - debering - surface treatment - inspection - powder coated - packing.

4. Process Details

Process / Operation	Powder Coated
Outsource	Yes
Machine / Cell	booth 1
Machine / Cell No.	1

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	1

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	Rahul	06/03/2023		Completed
Outflow	100 % inspection started	Rahul	06/03/2023		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)	Before powder coated 180_Occurance_Before.jpg
Occurance (After)	after powder coated 180_Occurance_After.jpg
Outflow (Before)	powder coated check 180_Outflow_Before.jpg
Outflow (After)	100% inspection check 180_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	adjuster kola

12. Document Review

Documents	ControlPlan, PackingStd
Specify Other Document	process flow chart

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	