

Defect Details

NC No.	8000792475
NC Date	23/06/2022
NC Submission Date	
Part No.	S2BG00702B
Part Name	BRACKET UN P/C
Supplier Name & Code	101032-ASM CASTINGS PRIVATE LIMITED (
ETL Plant	1143-ETL Suspension Halol, Vadodara
Defect Details	BUFFING DEFECT-BUFFING MARK,SCRATCH MARK

1. Problem Description

Defect Description	Buffing Mark
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	684
Is Defect Repeatative?	Yes
Defect Sketch / Photo	zkxzdvg4s1fgjq10txeucfj.jpg

Supplier Communication Details

Quality Head Email ID	quality@asmcastings.in
Plant Head/CEO Email ID	skaul@asmcastings.in
MD Email ID	rajiv@asmcastings.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	0	0	2200	1050	3250
Check Qty	0	0	0	2200	1050	3250
NG Qty	0	0	0	69	18	87

Action taken on NG part

Scrap	0
Rework	87
Under Deviation	0

Containment Action

Re-Buffering done on Parts.

3. Process Flow

Process Flow Description

Incoming of R.M. - R.M. Melting - Die Casting - Lancering - Reamer - Drilling & Tapping - Buffing - Polishing - Inspection - Packing & PDI- Dispatch.

4. Process Details

Process / Operation	Buffing
Outsource	No
Machine / Cell	Machine Shop
Machine / Cell No.	Buffing Machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Operator not aware about Work	Skill Matrix to be verified for min. Level 2	X
Method	Buffing Wheel Grade not Ok	Physical Verification for Appearance by Different Grade Wheel.	O
Machine	Scratch during Machining	Physical Verification	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Buffing Marks on Bracket
Why 2	Buffing Wheel Grade Not Adequate (120 No. while required 160 no. for Painted parts)
Why 3	Process Validation not done as per Painted part
Why 4	Paint At Customer End.
Why 5	
Root Cause (Occurance)	Process Validation not done for Buffing Appearance.

Root Cause Analysis (Outflow)

Why 1	Buffing Marks on Bracket
Why 2	Skipped from Final Inspection
Why 3	Limit Sample not provided for Buffing Marks.
Why 4	
Why 5	
Root Cause (Outflow)	Limit Sample not provided for Buffing Marks.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	01) Process Validation done for Buffing Appearance on painted parts. 02) Buffing Wheel Grade Changed from 120 to 160 no. 03) Control Plan updated for the buffing Wheel Grade.	Lalit Sharma	15/07/2022	15/07/2022	Completed

9. Inspection Method After Customer Complaint

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

10. Evidence of Countermeasure

Occurance (Before)	Buffing Wheel Grade 120 No. 185_Occurance_Before.png
Occurance (After)	Buffing Wheel Grade 160 No. 185_Occurance_After.png
Outflow (Before)	Limit Sample was not provided 185_Outflow_Before.jpg
Outflow (After)	Limit Sample Provided. 185_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Buffing Machine

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	Limit Sample

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	Found ok and reduce visual defects