

## Defect Details

<b>NC No.</b>	8000817842
<b>NC Date</b>	20/01/2023
<b>NC Submission Date</b>	
<b>Part No.</b>	B2BK068230
<b>Part Name</b>	CALIPER BODY-PAINTED - ATHER FR
<b>Supplier Name &amp; Code</b>	206460-TULJA ENTERPRISES
<b>ETL Plant</b>	1120-ETL K-226/2 Disc Brakes
<b>Defect Details</b>	PANIT UNCOVER-AFTER 100% INSP. DUST, UNCOVER, ORANGE P

## 1. Problem Description

<b>Defect Description</b>	Paint uncover,dust,paint peel off
<b>Detection Stage</b>	Receipt
<b>Problem Severity</b>	Aesthetic
<b>NG Quantity</b>	30
<b>Is Defect Repeatative?</b>	Yes
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	tuljaenterprises.e124@gmail.com
<b>Plant Head/CEO Email ID</b>	info@tulja.in
<b>MD Email ID</b>	tuljaenterprises.e124@gmail.com

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	30	0	0	0	0	30
<b>Check Qty</b>	30	0	0	0	0	30
<b>NG Qty</b>	30	0	0	0	0	30

## Action taken on NG part

<b>Scrap</b>	0
<b>Rework</b>	30
<b>Under Deviation</b>	0

## Containment Action

The touch up spray is under development. Once it will be developed, The issue be cured. Currently we are touching it up with existing paint.

## 3. Process Flow

**Process Flow Description**

Receipt of NG parts - Paint application and NG area - Baking - Visual inspection - Packing - Dispatch

## 4. Process Details

<b>Process / Operation</b>	Repainting
<b>Outsource</b>	No
<b>Machine / Cell</b>	Paint Booth
<b>Machine / Cell No.</b>	NA

## 5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Sensitive Shade	The shade is sensitive at curved areas	X

## 6. Inspection Method Analysis (Current)

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	L4 Operator Deployed
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

## 7. Root Cause Analysis (Occurance)

<b>Why 1</b>	The component geometry is difficult to cover with electrostatic gun.
<b>Why 2</b>	The shade is sensitive
<b>Why 3</b>	Paint not applied properly
<b>Why 4</b>	Painter coverage was poor at curved area
<b>Why 5</b>	L3 Operator deployed at inspection stage
<b>Root Cause (Occurance)</b>	Improper application of paint at curved and deep surface.

## Root Cause Analysis (Outflow)

<b>Why 1</b>	L3 operator was deployed
<b>Why 2</b>	Inspector did not inspected properly
<b>Why 3</b>	Operator did not inspected the curved and deep surface of the component.
<b>Why 4</b>	Operator did not informed senior inspector
<b>Why 5</b>	Senior operator was not inspecting the parts
<b>Root Cause (Outflow)</b>	L3 operator was deployed for inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Occurance	Conventional gun will used for coverage at deep surface.	Operation Head	03/02/2023	03/02/2023	Completed
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## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	Additional inspector placed for a month at the inspection stage
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Visual
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

## 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	Uncover <a href="#">339_Occurance_Before.jpg</a>
<b>Occurance (After)</b>	Covered with iwata gun <a href="#">339_Occurance_After.jpg</a>
<b>Outflow (Before)</b>	Uncover <a href="#">339_Outflow_Before.jpg</a>
<b>Outflow (After)</b>	Ok. <a href="#">339_Outflow_After.jpg</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	No
<b>Applicable Machine / Model / Plant</b>	Paint Booth

## 12. Document Review

<b>Documents</b>	
<b>Specify Other Document</b>	NA

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	250
<b>Reason for submission</b>	Paint uncover 100% checked found ok