

Defect Details

NC No.	8000825247
NC Date	02/04/2023
NC Submission Date	
Part No.	F2HB06910M
Part Name	OUTER TUBE ANODISED - Ø48 690 SMC
Supplier Name & Code	100975-KRISHNA ASSOCIATES
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	SHADE VARIATION-SHADE VERIATION

1. Problem Description

Defect Description	Shade variation found on 690 SMC Outer tube
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	201
Is Defect Repeatative?	No
Defect Sketch / Photo	0jb0exe3dv3vs0e5m2na4cnq.jpg

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	201	0	0	0	0	201
Check Qty	201	0	0	0	0	201
NG Qty	201	0	0	0	0	201

Action taken on NG part

Scrap	201
Rework	0
Under Deviation	0

Containment Action

checkpoint added in final inspection sheet OPL Displayed at final inspection stage

3. Process Flow

Process Flow Description

Pre-treatment - anodizing -Coloring - Sealing- Inspection - packing -Dispatch

4. Process Details

Process / Operation	Anodizing
Outsource	No
Machine / Cell	Anodizing Line
Machine / Cell No.	2

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Faulty timer	cross checked	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	Not proper cleaning in water rinse
Why 2	Inadequate time in water rinse
Why 3	Water rinse timer faulty
Why 4	.
Why 5	.
Root Cause (Occurance)	Part not cleaned properly in water rinse tank due to timer of water rinse tank malfunction

Root Cause Analysis (Outflow)

Why 1	Defective Sample not displayed at final inspection
Why 2	Inspector Not aware about issue
Why 3	Checking skipped from inspector
Why 4	.
Why 5	.
Root Cause (Outflow)	Defective sample not displayed at final inspection stage, Inspector Not aware about issue

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Timer Controller replaced	Maintenance	02/04/2023	02/04/2023	Completed

Outflow	NG part Not displayed at inspection stage	QA	03/04/2023	03/04/2023	Completed
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9. Inspection Method After Customer Complaint

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

10. Evidence of Countermeasure

Occurance (Before)	Faulty Timer 397_Occurance_Before.jpg
Occurance (After)	Timer changed 397_Occurance_After.jpg
Outflow (Before)	Before inspection SOP 397_Outflow_Before.pdf
Outflow (After)	Updated Inspection SOP Displayed & One Point lesson(OPL) Displayed at final inspection stage 397_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Timer

12. Document Review

Documents	PMCheckSheet, InspCheckSheet
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	1600
Reason for submission	All part found ok as per requirement