QFR No - 8000839822

Defect Details

NC No.	8000839822
NC Date	08/08/2023
NC Submission Date	
Part No.	B2EH06002O
Part Name	END CONNECTOR CAL SIDE N360 NON ABS
Supplier Name & Code	101221-SUNREN AUTOMOTIVE PRIVATE LIMI
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	PLATING NOT OK-PLATING NOT OK

1. Problem Description

Defect Description	PLATING NOT OK
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	33
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	shivank@sunren.in
Plant Head/CEO Email ID	dharmbir@sunren.in
MD Email ID	subhashsaini@sunren.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	2500	4000	1000	2000	9500
Check Qty	0	2500	4000	1000	2000	9500
NG Qty	0	0	0	22	0	22

Action taken on NG part

Scrap	0
Rework	22
Under Deviation	0

Containment Action
Re-Plating

3. Process Flow

Process Flow Description
Raw Inspection of Raw Material - Cutting Multi Operation - Centerless Grinding - Milling - Cross Drill- Facing1st - Facing-2nd - Neck Drill-Cross Reamer - Chamfer- 100% Visual Inspection -Bending - Plating - Final Inspection - Packaging - Storage / Dispatch .

4. Process Details

Process / Operation	Plating
Outsource	Yes
Machine / Cell	01
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Jig was partially loaded	Jig was verified	X
Man	Operator Negligency	Skill Level verified as per skill matrix	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	2

7. Root Cause Analysis (Occurance)

Why 1	current distribution on part during plating process NG
Why 2	Jigs was partially loaded by operator
Why 3	SOP available but process not running as per defined SOP
Why 4	Operator skill level not found as per the SOP
Why 5	Training provided to the operator as per the SOP
Root Cause (Occurance)	Jig was partially loaded with the EC.

Root Cause Analysis (Outflow)

Why 1	Material cannot be checked 100%
Why 2	Due to destructive testing
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Material cannot be checked 100% due to destructive testing .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	will check 2 parts by the use of plier .	Krishna Plating	10/08/2023	10/08/2023	Completed
Occurance	OPL displayed for partial loading of Jigs	Krishna Plating	10/08/2023	10/08/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Will check 02 Nos with the use of plier
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	2

10. Evidance of Countermeasure

Occurance (Before)	N/A 523_Occurance_Before.jpg
Occurance (After)	OPL Displayed 523_Occurance_After.jpg
Outflow (Before)	No mechanism to check peel off. 523_Outflow_Before.png
Outflow (After)	2 Nos/lot will be checked with the use of plier . 523_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	B20706100,B20706200O,B20706300,B20703700O,B20703800O,B20703900,B2EH08502O,B2EH08602O,B2EH05902O,B20702500O,B2070270(

12. Document Review

Documents	
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	No plating defect found in latest lot