

Defect Details

NC No.	8000846809
NC Date	29/09/2023
NC Submission Date	
Part No.	B2FP052130
Part Name	HOLDER BRACKET FINISHED-RE J1 FRONT
Supplier Name & Code	201092-PRANEEL INDUSTRIES
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	NOT AS PER SPECIFICATION-PART REJECTED AFTER 100% INSPECTION AT E

1. Problem Description

Defect Description	Powder coating not ok
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	8
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@praneelgroup.com
Plant Head/CEO Email ID	praneelindustries@rediffmail.com
MD Email ID	anilpatil@praneelgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	260	0	0	80	0	340
Check Qty	260	0	0	80	0	340
NG Qty	8	0	0	5	0	13

Action taken on NG part

Scrap	13
Rework	0
Under Deviation	0

Containment Action

All WIP checked at all end . Defective parts rejected.

3. Process Flow

Process Flow Description

Powder Coating Process (Outsourcing at Krishna Coating)

4. Process Details

Process / Operation	Powder coating
Outsource	Yes
Machine / Cell	VMC Cell
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	No awareness to operator	New operator	X
Method	Wrong method of powder coating	verified, found ok	O
Tool	Ventury Damaged	Verified , ventury found damaged	X
Machine	Low air pressure	Verified , air pressure found ok	O
Material	Wrong material used	Verified , Material as per specifications	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	Uncover issue observed in Holder bracket
Why 2	Defective ventury observed in Powder coating Gun
Why 3	Powder coating Gun not proper checked before powder coating process
Why 4	Powder coating Operator has not gained sufficient knowledge for powder coating process
Why 5	
Root Cause (Occurance)	New Manpower

Root Cause Analysis (Outflow)

Why 1	Skipped from final inspection
Why 2	New Manpower
Why 3	Old manpower unplanned absenteeism
Why 4	
Why 5	
Root Cause (Outflow)	Old manpower unplanned absenteeism

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Immediate new ventury install in Powder coating Gun	Mr.Tosif	16/10/2023	16/10/2023	Completed
Occurance	PM check Sheet provided at Powder coating booth for coating gun checking and Cleaning	Mr.Tosif	25/10/2023	25/10/2023	Completed
Outflow	Training provided to Powder coating operator for powder coating gun checking and Cleaning	Mr. Tosif	16/10/2023	16/10/2023	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	No checkpoint in PM Checksheet 559_Occurance_Before.pptx
Occurance (After)	Checkpoint added in PM checksheet 559_Occurance_After.jpg
Outflow (Before)	Skipped from final inspection 559_Outflow_Before.jpg
Outflow (After)	Training & awareness given to final inspector 559_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Holder Brackets for Praneel Industries

12. Document Review

Documents	PMCheckSheet, InspCheckSheet
Specify Other Document	Q-Alert

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	No defect found in latest lot

