QFR No - 8000854709

Defect Details

NC No.	8000854709
NC Date	12/12/2023
NC Submission Date	
Part No.	B2SU01002O
Part Name	BRAKE HOSE TUBE CLAMP 2 (N282)
Supplier Name & Code	100151-EXCELL PRESSINGS
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-PLATING NOT OK
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	308
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	excellpressings.qc@gmai.com
Plant Head/CEO Email ID	yogesh_vaidya42@yahoo.co.in
MD Email ID	excellpressings@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	3000	2000	8000
Check Qty	3000	0	0	3000	2000	8000
NG Qty	393	0	0	0	0	393

Action taken on NG part

Scrap	0
Rework	393
Under Deviation	0

Containment Action
All the material was checked at ETL end and our end also

3. Process Flow

Process Flow Description
After press opeation, plating is done to the parts at M/S Krishna Industries.Then final inspection is done at our end

4. Process Details

Process / Operation	Plating
Outsource	Yes
Machine / Cell	WATT TANK NO 02
Machine / Cell No.	WATT TANK NO 02

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Current supply issue on jigs	V blocks copper cathode are hot	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	10

7. Root Cause Analysis (Occurance)

Why 1	Less thickness observed below 8 micron
Why 2	Current fluctuation observed
Why 3	Jigs copper getting hot
Why 4	V block getting loosed
Why 5	Monthly maintenance was not done
Root Cause (Occurance)	Current fluctuations due to overheat cathode contact

Root Cause Analysis (Outflow)

Why 1	Thickness was not checked
Why 2	Visually found Ok
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	At our end thickness was not checked

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Current fluctuations caused to lower the thickness	M/S Krishna Industries	19/12/2023	20/12/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Every lot plating thickness will be checked
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100

10. Evidance of Countermeasure

Occurance (Before)	v lock loose contact 613_Occurance_Before.jpg
Occurance (After)	v block repaired 613_Occurance_After.jpg
Outflow (Before)	Plating Not ok to Hose Clamps 613_Outflow_Before.jpg
Outflow (After)	Plating OK to Hose clamps 613_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Plating process at Krishna Industries

12. Document Review

Documents	ControlPlan, PMCheckSheet, JHCheckSheet, InspCheckSheet
Specify Other Document	FFPA Checksheet

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	No defect found in latest lot