QFR No - 8000854744

Defect Details

NC No.	8000854744
NC Date	12/12/2023
NC Submission Date	
Part No.	B2SU00702O
Part Name	BRAKE HOSE TUBE CLAMP 1(NTORQ)
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	164
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	excellpressings.qc@gmail.com
Plant Head/CEO Email ID	yogesh_vaidya42@gmail.com
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	1000	0	0	2000	1000	4000
Check Qty	1000	0	0	2000	1000	4000
NG Qty	164	0	0	0	0	164

Action taken on NG part

Scrap	0
Rework	164
Under Deviation	0

Containment Action
All the lots are checked at ETL end and our end.

3. Process Flow

Process Flow Description
After pressings operation, the material is given for plating to M/S Krishna Industries.Then at final inspection 100% visual inspection is being carried out.

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Current supply issue on jigs	Rectifier wires loose contact so that causes for current fluctuations	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	10

7. Root Cause Analysis (Occurance)

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

Root Cause Analysis (Outflow)

Why 1	Visul found ok
Why 2	Thickness was not checked
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Thickness was not checked after plating operation

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Current supply issue 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 thickness will be checked at Krishna Industries and Excell pressings
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	10

10. Evidance of Countermeasure

Occurance (Before)	V block get damaged 616_Occurance_Before.jpg
Occurance (After)	V block repaired 616_Occurance_After.jpg
Outflow (Before)	Not Ok plating part 616_Outflow_Before.jpg
Outflow (After)	Ok plating part 616_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	At Krishna Industries, process flow chart is followed on every stage

12. Document Review

Documents	ControlPlan, JHCheckSheet, InspCheckSheet
Specify Other Document	FFPA checksheet

13. Effectiveness Of Action

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