

Defect Details

NC No.	8000858545
NC Date	13/01/2024
NC Submission Date	
Part No.	B2BK017230
Part Name	CALIPER BODY POWDER COATING -AVENGER
Supplier Name & Code	100204-KRISHNA COATING
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	POWDER COATING NOT OK-PART REJECTED AFTER 100% INSPECTION AT E

1. Problem Description

Defect Description	POWDER COATING NOT OK
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	192
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

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	3460	0	0	0	0	3460
Check Qty	3460	0	0	0	0	3460
NG Qty	192	0	0	0	0	192

Action taken on NG part

Scrap	0
Rework	192
Under Deviation	0

Containment Action

Uncover issue found. After inspection we found Venturi in powder coating gun defective i.e. damaged venturi. We replaced defective venturi with new one. After venturi replacement uncover issue was not observed.

3. Process Flow

Process Flow Description

Inward - Pretreatment - Drying - powder Coating- Baking- Final Inspection - dispatch.

4. Process Details

Process / Operation	Powder Coating
Outsource	No
Machine / Cell	Powder Coating Line
Machine / Cell No.	Powder Coating Line

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Powder Coating Gun defect	Venturi in powder coating gun found damaged	O
Man	Inconsistent powder coating by operator	Operator found doing Powder coating ok	X

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 Caliper Body.
Why 2	Powder Gun not proper check for powder coating process
Why 3	Powder flow not proper on the component
Why 4	Defective venturi observed in Powder coating Gun
Why 5	
Root Cause (Occurance)	Defective Venturi observed in Coating Gun

Root Cause Analysis (Outflow)

Why 1	Uncover issue observed due to damaged coating Gun Venturi
Why 2	Coating Gun venturi not checked on regular basis
Why 3	Improper gun cleaning
Why 4	Operator was unaware about proper gun cleaning
Why 5	
Root Cause (Outflow)	Coating Gun venturi not checked on regular basis

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
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Outflow	Training provided to operator on gun checking and cleaning	supervisor	15/01/2024	14/01/2024	Completed
Occurance	Damaged Venturi replaced with new one.	Supervisor	15/01/2024	14/01/2024	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	Damaged Venturi found as shown in attachment 634_Occurance_Before.jpg
Occurance (After)	New Venturi replaced with old one which was damaged 634_Occurance_After.jpg
Outflow (Before)	Gun Venturi checking was doing once per day 634_Outflow_Before.jpg
Outflow (After)	Gun Venturi Checking daily twice. 634_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	AI powder coating Guns

12. Document Review

Documents	
Specify Other Document	None

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	