

Defect Details

NC No.	8000865087
NC Date	29/02/2024
NC Submission Date	
Part No.	B2BK068230
Part Name	CALIPER BODY-PAINTED - ATER FR
Supplier Name & Code	206460-TULJA ENTERPRISES
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	POWDER COATING NOT OK-AFTER 100% INSP. POWDER COATING UNCOVER,

1. Problem Description

Defect Description	POWDER COATING NOT OK-AFTER 100% INSP. POWDER COATING UNCOVER,
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	217
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality.tulja@gmail.com
Plant Head/CEO Email ID	tuljaenterprises.e124@gmail.com
MD Email ID	tuljaenterprises.e124@gmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	15126	0	0	0	0	15126
Check Qty	1363	0	0	0	0	1363
NG Qty	217	0	0	0	0	217

Action taken on NG part

Scrap	0
Rework	217
Under Deviation	0

Containment Action

Given training to painter how paint critical area during painting process.

3. Process Flow

Process Flow Description

Inward Inspection-PT process-WDO-PC-Baking-Final Inspection-Packing & Dispatch

4. Process Details

Process / Operation	Coating
Outsource	No
Machine / Cell	Wagner coating Gun
Machine / Cell No.	01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskilled operator	due to unskilled operator	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	During coating skip critical area.
Why 2	No awareness to operator about how to cover all critical area by coating.
Why 3	Skill level 2 operator was appointed
Why 4	Unskilled operator
Why 5	
Root Cause (Occurance)	Unskilled operator

Root Cause Analysis (Outflow)

Why 1	NG material mix up in Finish Good.
Why 2	Both location was near each other
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	OK/Not OK material mix up

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Given training to coating operator for critical parts area	production /Quality	05/03/2024	05/03/2024	Completed

Outflow	Define OK/Not OK material location away from each other.	Prod.& Inspector	04/03/2024	04/03/2024	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	No change required,due to mix up by loading person.
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	Skill level 2 operator 697_Occurance_Before.xlsx
Occurance (After)	Given training to operator 697_Occurance_After.pdf
Outflow (Before)	OK/Not OK material location near each other 697_Outflow_Before.xlsx
Outflow (After)	Define OK/Not OK location 697_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	
Specify Other Document	NA

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	