QFR No - 8000872209

Defect Details

NC No.	8000872209
NC Date	23/04/2024
NC Submission Date	
Part No.	B2GQ01823O
Part Name	M/CYL BODY RAW POWDER COATED-KHI
Supplier Name & Code	100204-KRISHNA COATING
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	POWDER COATING NOT OK-UNCOVER, DUST, COATING NOT OK

1. Problem Description

Defect Description	POWDER COATING NOT OK-UNCOVER, DUST, COATING NOT OK
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	118
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	1200	0	0	0	0	1200
Check Qty	1200	0	0	0	0	1200
NG Qty	118	0	0	0	0	118

Action taken on NG part

Scrap	0
Rework	118
Under Deviation	0

Containment Action
One dedicated inspection operator allocated at final inspection stage to recheck inspected material and make sure that defective parts should not be dispatched.

3. Process Flow

Process Flow Description
Inward + PT + Powder Coating + Baking + Final Inspection + Dispatch

4. Process Details

Process / Operation	Powder Coating
Outsource	No
Machine / Cell	powder coating lime
Machine / Cell No.	powder coating line

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Inconsistent powder flow through coating gun can causes uncover	Powder flow was not consistent	O
Method	Powder coating gun to part distance can cause uncover issue	Powder coating gun to part distance was found ok	X
Tool	Damage to any internal or external part of the powder coating gun can cause inconsistent flow	Gun Venturi found damage	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	each lot

7. Root Cause Analysis (Occurance)

Why 1	Uncover and dust issue observed with Master Cylinder
Why 2	Inconsistent powder flow causes uncover and dust formation
Why 3	Damaged Venturi causes inconsistent powder flow through powder coating gun.
Why 4	Proper gun maintenance not done by coating operator
Why 5	
Root Cause (Occurance)	Proper gun maintenance not done by coating operator that damaged gun Venturi by which powder flow was inconsistent that causes the formation of dust and some area left uncovered.

Root Cause Analysis (Outflow)

Why 1	Defective part skipped by inspection operator at final inspection stage.
Why 2	Operator was not aware of such kind of defects.
Why 3	Proper training was not provided to operator.
Why 4	
Why 5	
Root Cause (Outflow)	Proper training was not provided to operator on issues like Uncover and dust.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Instructions given to the coating operator about gun maintenance and updated gut maintenance check sheet provided to him.	QC / Production Supervisor	26/04/2024	25/04/2024	Completed
Outflow	Training about dust and uncover issue provided to inspection operator at final inspection stage	QC / Production supervisor	26/04/2024	25/04/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	none
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	each lot

10. Evidance of Countermeasure

Occurance (Before)	Gun maintenance before 763_Occurance_Before.jpg
Occurance (After)	Gun maintenance after 763_Occurance_After.jpg
Outflow (Before)	Training provided 763_Outflow_Before.png
Outflow (After)	training provided 763_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	all parts

12. Document Review

Documents	PMCheckSheet
Specify Other Document	Gun maintenance

13. Effectiveness Of Action

Reviewed Quantity	300
Reason for submission	No defect observed in latest lot