

## Defect Details

<b>NC No.</b>	8000873543
<b>NC Date</b>	06/05/2024
<b>NC Submission Date</b>	
<b>Part No.</b>	F2FQ00307B
<b>Part Name</b>	HOLDER HANDLE LOWER P/C (XF-521)
<b>Supplier Name &amp; Code</b>	201092-PRANEEL INDUSTRIES
<b>ETL Plant</b>	1117-ETL K-228/9 Suspension
<b>Defect Details</b>	DAMAGES-CASTING DENT AND DAMAGE

## 1. Problem Description

<b>Defect Description</b>	CASTING DENT AND DAMAGE
<b>Detection Stage</b>	Receipt
<b>Problem Severity</b>	Aesthetic
<b>NG Quantity</b>	19
<b>Is Defect Repeatative?</b>	Yes
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality@praneelgroup.com
<b>Plant Head/CEO Email ID</b>	praneelindustries@rediffmail.com
<b>MD Email ID</b>	anilpatil@praneelgroup.com

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	100	0	0	0	100	200
<b>Check Qty</b>	100	0	0	0	0	100
<b>NG Qty</b>	19	0	0	0	0	19

## Action taken on NG part

<b>Scrap</b>	19
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

All WIP checked at all end . Defective parts rejected.

## 3. Process Flow

**Process Flow Description**

Casting - powder coating - machining - final inspection - packing - dispatch

**4. Process Details**

<b>Process / Operation</b>	MACHING
<b>Outsource</b>	No
<b>Machine / Cell</b>	01
<b>Machine / Cell No.</b>	01

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Method	Packing method not as per required packing standard.	Verify packing standard for this part and found NG for packing standard.	X
Machine	Dent and damage on the machine.	Verify the clamping on the machine with input and output material and found ok on the machine.	O
Man	Packing person not aware about packing of the material.	Verify the skill about packaging and found new manpower for packing.	X
Tool	Tooling for manufacturing this part not as per required.	Verify the machine toolings and found Ok.	O
Material	Wrong material used for the process.	Verify the material and found as per drawing.	O

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	VISUAL
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	Dent / Damages on parts
<b>Why 2</b>	Dent / Damages while packing
<b>Why 3</b>	Without partition packing in bins
<b>Why 4</b>	Packing standard not followed
<b>Why 5</b>	
<b>Root Cause (Occurance)</b>	Packing standard not followed

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	Dent / Damage observed during packing
<b>Why 2</b>	Dent / Damage observed during dispatch.
<b>Why 3</b>	
<b>Why 4</b>	
<b>Why 5</b>	

<b>Root Cause (Outflow)</b>	packing operator was not aware of this.
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### 8. Countermeasure ( Occurrence , Outflow & System side Actions )

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Packing Standard followed for avoided dent damage	suraj madhavi	10/04/2024	11/04/2024	Completed
Occurance	Partition add to bins avoided metal to metal contact.	Madhav gaikwad	10/04/2024	11/04/2024	Completed

### 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	No
<b>Change Details</b>	-
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	VISUAL
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

### 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	PACKING NOT OK, METAL TO METAL CONTACT. <a href="#">794_Occurance_Before.pptx</a>
<b>Occurance (After)</b>	Partition add to bins avoided metal to metal contact. <a href="#">794_Occurance_After.pptx</a>
<b>Outflow (Before)</b>	Skipped from final inspection <a href="#">794_Outflow_Before.xlsx</a>
<b>Outflow (After)</b>	Training & awareness given to final inspector <a href="#">794_Outflow_After.xlsx</a>

### 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	No
<b>Applicable Machine / Model / Plant</b>	-

### 12. Document Review

<b>Documents</b>	PackingStd
<b>Specify Other Document</b>	Q-ALERT

### 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	50
<b>Reason for submission</b>	OK

