

Defect Details

NC No.	8000886610
NC Date	12/08/2024
NC Submission Date	
Part No.	F2FQ00307B
Part Name	HOLDER HANDLE LOWER P/C (XF-521)
Supplier Name & Code	201092-PRANEEL INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	DENT MARK-DENT DAMAGE

1. Problem Description

Defect Description	Dent Mark & Damage
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	35
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

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

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	1216	0	0	100	0	1316
Check Qty	1216	0	0	100	0	1316
NG Qty	35	0	0	20	0	55

Action taken on NG part

Scrap	55
Rework	0
Under Deviation	0

Containment Action

All material at ETL end and at in-house sagrigation done and NG parts are scrap at both location.

3. Process Flow

Process Flow Description

Raw Casting inward=>CNC Setup=>Powder Coating=>Powder Coating Inward=>VMC Setup=>De-burring=>Final Inspection=>Packing and Dispatch.

4. Process Details

Process / Operation	VMC Machining
Outsource	No
Machine / Cell	VMC Machining
Machine / Cell No.	VMC Cell

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Inadequate clamping method while machining.	Verify the method of loading and unloading during machine found inadequate.	X
Machine	Clamping pressure for part load not as per specifications.	Verify the clamping pressure and found as per required specifications.	O
Man	Skilled person not available	Verify the skill matrix found as per skill matrix.	O
Material	Material specification not as per required.	Vewrify the material found ok.	O
Tool	Tooling for manufacturing the part not as per specification.	Verify the machining tool and found Ok.	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

7. Root Cause Analysis (Occurance)

Why 1	Dent mark-Dent Damage observed on the part.
Why 2	Clamping pressure not as per required specification on the machine.
Why 3	Clamping not done properly during the machining.
Why 4	Damage during the machining after parts unloading observed.
Why 5	
Root Cause (Occurance)	Damage during the machining after parts unloading observed.

Root Cause Analysis (Outflow)

Why 1	Dent mark-Dent Damage observed on the part.
Why 2	Parts skipped by inspector during the visual inspection.
Why 3	Awareness not available about dent and damage issue.
Why 4	
Why 5	
Root Cause (Outflow)	Awareness not available about dent and damage issue.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Awareness and training provided for visual inspection of the material for dent and damage issue.	Mr.Yogesh Sonune	19/08/2024	19/08/2024	Completed
Occurance	Training given to operator for air should be blow on the fixture and resting area to remove the burr.	Mr.Chandrakant Nanher	19/08/2024	19/08/2024	Completed

9. Inspection Method After Customer Complaint

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

10. Evidence of Countermeasure

Occurance (Before)	No any work instruction for fixture cleaning in the machine work instruction. 1004_Occurance_Before.pdf
Occurance (After)	Instruction for fixture cleaning with clamping and resting area added in the machine work instruction. 1004_Occurance_After.pdf
Outflow (Before)	No awareness about dent and damage issue observed at ETL end. 1004_Outflow_Before.pdf
Outflow (After)	Training and awareness provided for the dent and damage issue observed on the parts. 1004_Outflow_After.jpeg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Handle Holder Upper

12. Document Review

Documents	WISOP
Specify Other Document	Q alert, Training rec

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK

