QFR No - 8000887428

Defect Details

NC No.	8000887428
NC Date	20/08/2024
NC Submission Date	
Part No.	B2FP05313O
Part Name	HOLDER BRACKET FINISHED-RE J1 REAR
Supplier Name & Code	201092-PRANEEL INDUSTRIES
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	DENT MARK-DENT DAMAGE

1. Problem Description

Defect Description	DENT MARK-DENT DAMAGE
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	186
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	420	0	0	130	0	550
Check Qty	420	0	0	130	0	550
NG Qty	186	0	0	3	0	189

Action taken on NG part

Scrap	189
Rework	0
Under Deviation	0

Containment Action
All material at ETL end and In-house Finish Good material sagrigation done and NG material rejected.

3. Process Flow

Process Flow Description
Raw material inward=>Powder coating=>Powder coating inward=>VMC 1st setup=> VMC 2nd setup=>Final inspection=>Packing and Dispatch.

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Material not as per drawing.	Verify the material and found as per drawing.	O
Tool	Required tooling not as per specifications.	Verify the tooling on machine,found adequate.	O
Method	Packing method not as per packing standard.	Verify the packing standard and found inadequate.	X
Machine	Machine clamping pressure not as required.	Verify the machine clamping pressure on machine and found as per CP.	O
Man	Unskilled operator and inspector on machine and final inspection.	Verify skill matrix of operator and inspector ,found as per skill matrix.	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	samp.plan

7. Root Cause Analysis (Occurance)

Why 1	Holder Bracket REJ1C Rear found dent and damage on the parts.
Why 2	Operator unaware of material handling and packing
Why 3	Unskilled operator of packing.
Why 4	Stage wise material movement is improper
Why 5	
Root Cause (Occurance)	Stage wise material movement is improper.

Root Cause Analysis (Outflow)

Why 1	Holder Bracket REJ1C Rear found dent and damage on the parts.
Why 2	Phenomenon skip during visual inspection
Why 3	Inspector not aware about defects occurs.
Why 4	
Why 5	
Root Cause (Outflow)	Inspector not aware about defects occurs.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Stage wise material handling made and display on the shop floor to avoid dent and damage issue on parts.	Mr.Sudarshan Kadam	26/08/2024	26/08/2024	Completed
Outflow	Training and awareness given to Inspector about unknown defects received at ETL End.	Mr.Yogesh Sonune	24/08/2024	24/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection done as per eye sequence chart display on the inspection table.
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Before material handle in the box for machining. 1031_Occurance_Before.jpeg
Occurance (After)	After stage wise material handling display on the shop floor for material handling. 1031_Occurance_After.xlsx
Outflow (Before)	Before awareness not available about raise defects to inspector. 1031_Outflow_Before.jpeg
Outflow (After)	Training and Awareness given to Inspector with Q-Alert display on final inspection table. 1031_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All Holder Brackets and shop floor .

12. Document Review

Documents	WISOP, PackingStd, InspCheckSheet
Specify Other Document	Q-Alert

13. Effectiveness Of Action

Reviewed Quantity	150
Reason for submission	Seen improvement in dent/damage issue.