QFR No - 8000889507

Defect Details

NC No.	8000889507
NC Date	02/09/2024
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, PIN HOLE

1. Problem Description

Defect Description	DENT DAMAGE
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	16
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	350	0	0	0	200	550
Check Qty	350	0	0	0	200	550
NG Qty	27	0	0	0	30	57

Action taken on NG part

Scrap	57
Rework	0
Under Deviation	0

Containment Action
All material at ETL end and In-house sagrigation done and NG parts rejected at both location.

3. Process Flow

Process Flow Description
Raw Casting Inward=>CNC Setup=>Powder Coating=>VMC setup=>De-burring=>Final Inspection=>Packing and Dispatch.

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Clamping pressure not as per CP.	Verify clamping pressure as per CP and found OK.	O
Tool	Toolings used for part production is not as per standard.	Verify the toolings used for part production and found adequate.	O
Man	Unskilled manpower for inspection.	Verify skill matrix for inspector and found skilled person.	O
Method	Inspection method not as per standard.	Verify inspection method and found inadequate.	X
Material	Material not as per specifications.	Verify matertial composition and found as per specifications.	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	Pin hole observed on the parts after powder coating.
Why 2	Powder used for the process contains trapped air and moisture.
Why 3	Degreesing bath deep time for surface cleaning is found low for cleaning the parts.
Why 4	
Why 5	
Root Cause (Occurance)	Degreesing bath deep time for surface cleaning is found low for cleaning the parts.

Root Cause Analysis (Outflow)

Why 1	Pin hole observed on the parts after powder coating.
Why 2	Skipped from final inspection stage.
Why 3	Final inspector was unable to identify pin hole defect properly.
Why 4	Due to low lux level inspector was unable to identify the pin hole issue.
Why 5	
Root Cause (Outflow)	Due to low lux level inspector was unable to identify the pin hole issue.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	New high power LED tube installed at final inspection stage to increase the optimal lux level.	Mr. Yogesh Sonune	12/09/2024	12/09/2024	Completed
Occurance	Degreesing bath deep time for surface cleaning increases from 5-7 min to 7-9 min for cleaning the parts.	Mr.Dhawale	11/09/2024	12/09/2024	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. Evidance of Countermeasure

Occurance (Before)	Before Degree sing bath time 5-7 min available for part cleaning process. 1064_Occurance_Before.jpeg
Occurance (After)	After Degree sing bath time 7-9 min done for part cleaning process. 1064_Occurance_After.jpeg
Outflow (Before)	Lux level on the final inspection found low for inspection and no awareness about pin hole on the parts. 1064_Outflow_Before.pptx
Outflow (After)	Lux level increase on the final inspection for visual inspection also awareness and training given to inspector. 1064_Outflow_After.pptx

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